October 20th, 2021



# W2D Lean Learnings from Prefabrication at the Virgin Hotel New Orleans

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LEARN BY DOING FROM THOSE WHO DO

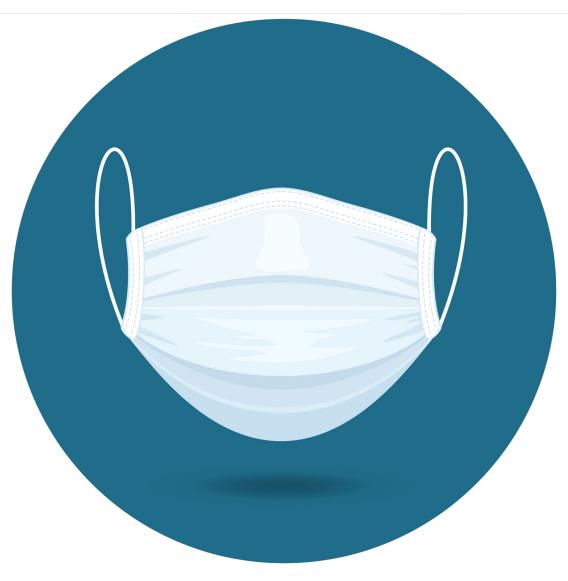






Health precautions to keep everyone as safe as possible at Congress:

- Wear masks at all times in indoor events.
- Complete your daily health screening on your phone and bring it with you when you enter the center each day.
- Practice social distancing to the extent possible. Seating at plenary sessions is structured to help with this.
- If you feel ill at any time, please leave the conference and return to your room/consult a physician as necessary.
- Ultimately, our collective health and safety at Congress is up to all of us. Thanks for your support!



#### **Overview**

- Design-Build Perspective with Broadmoor LLC
  - Lean tools and technology for success in prefabrication
- Prefabrication with LGS
  - Planning, fabrication, delivery and installation of metal stud walls
- Mechanical Design Build with Pontchartrain Mechanical
  - Designing to prefabrication with plumbing and HVAC



#### GROADMOOR Success

#### **Project Goals**

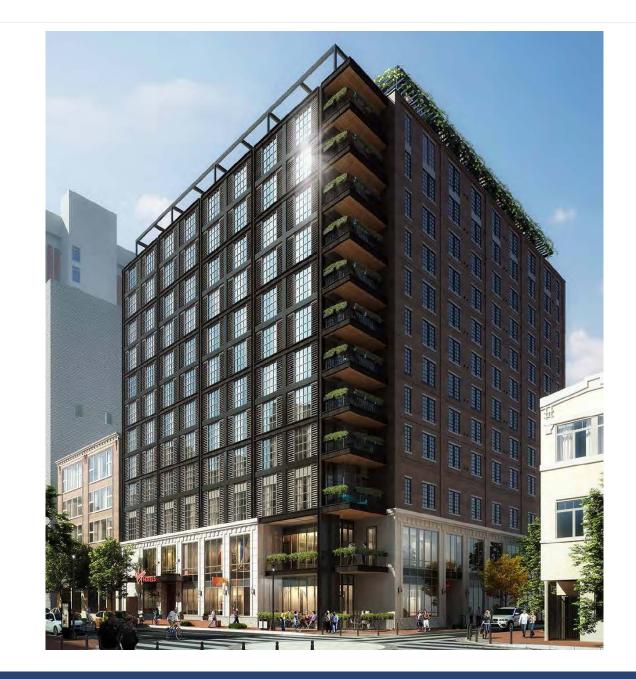
• **Budget**: \$52-\$55MM

Target Scope: 225 Keys Minimum

Schedule: 24 Month Construction Duration

#### Success

- Budget: \$54MM GMP (Guaranteed Maximum Pricing)
   Agreement
- Target Scope: Project has 238 Keys
- Schedule: 7/3/19, NTP 6/30/21 Substantial Completion





#### Keys to Success in Prefabrication



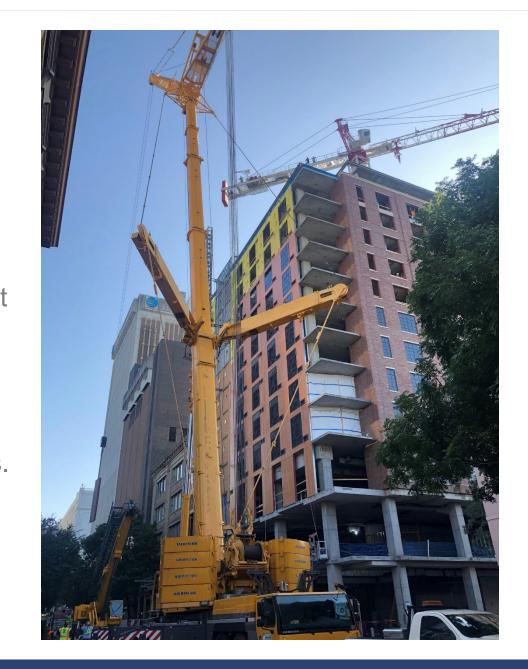
- 1. Plan for it as early as possible.
- 2. Identify all tolerances of building components that are touched.
- 3. BIM Coordination of all these components early.
  - Cannot allow one of the components to skip or shortcut the BIM process.
- 4. Constructability reviews with the trade partners involved.
- 5. Logistical planning for prefabricated building components.











#### **BIG ROOM PLANNING**



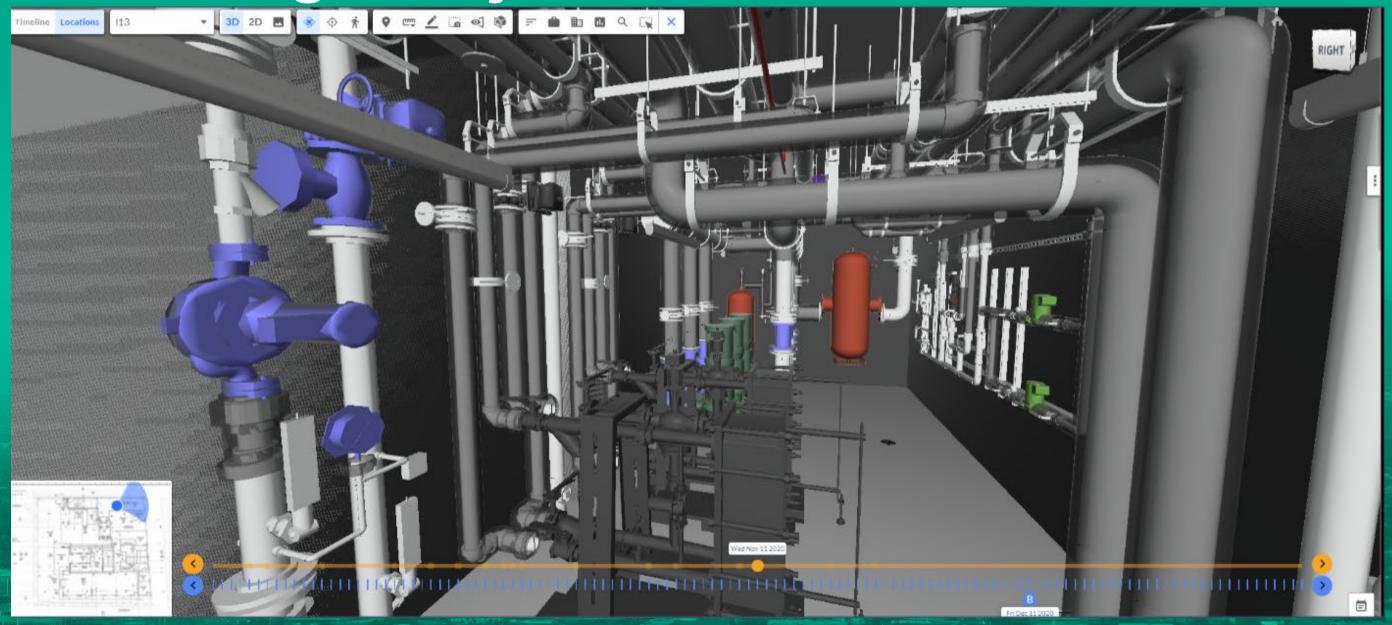


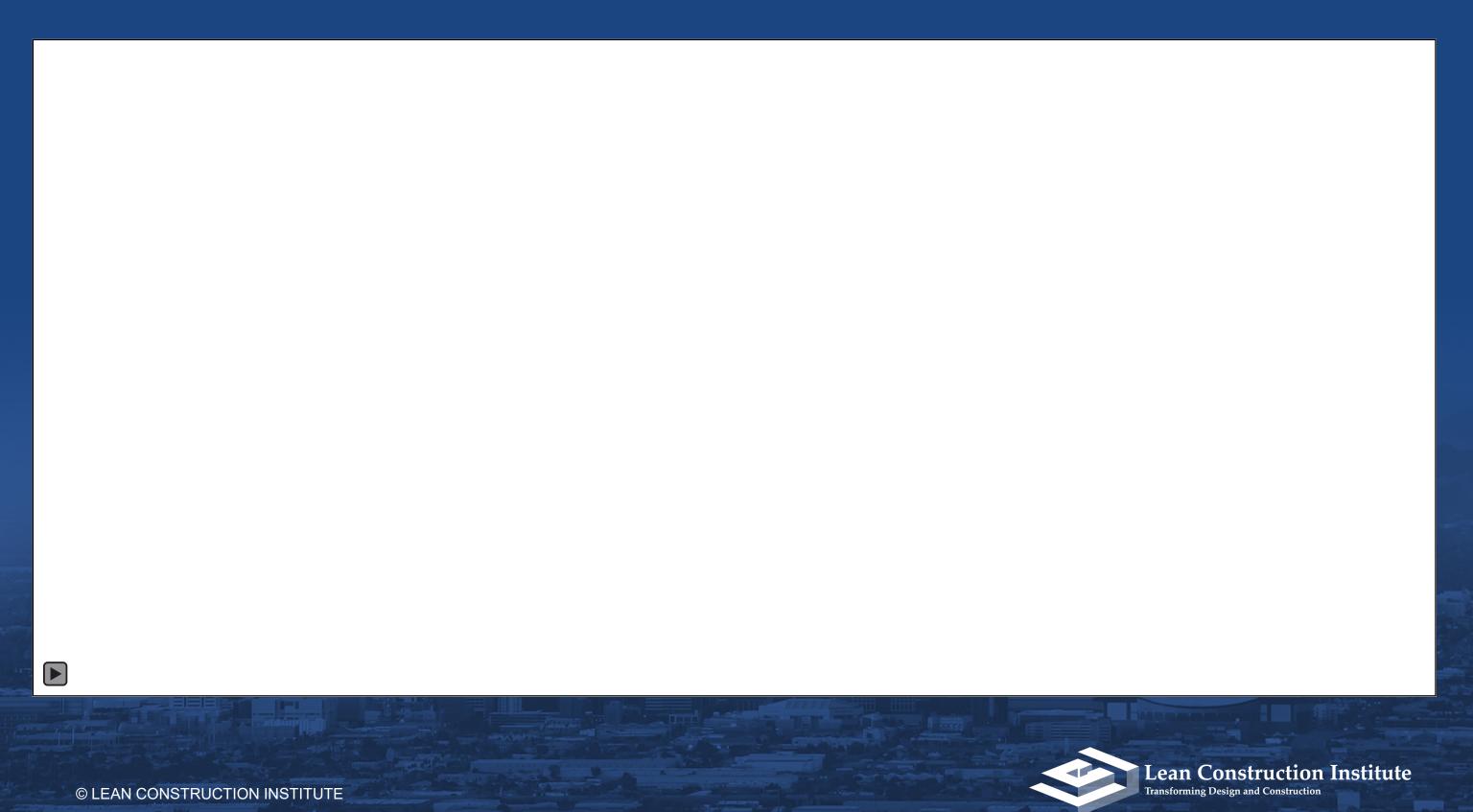


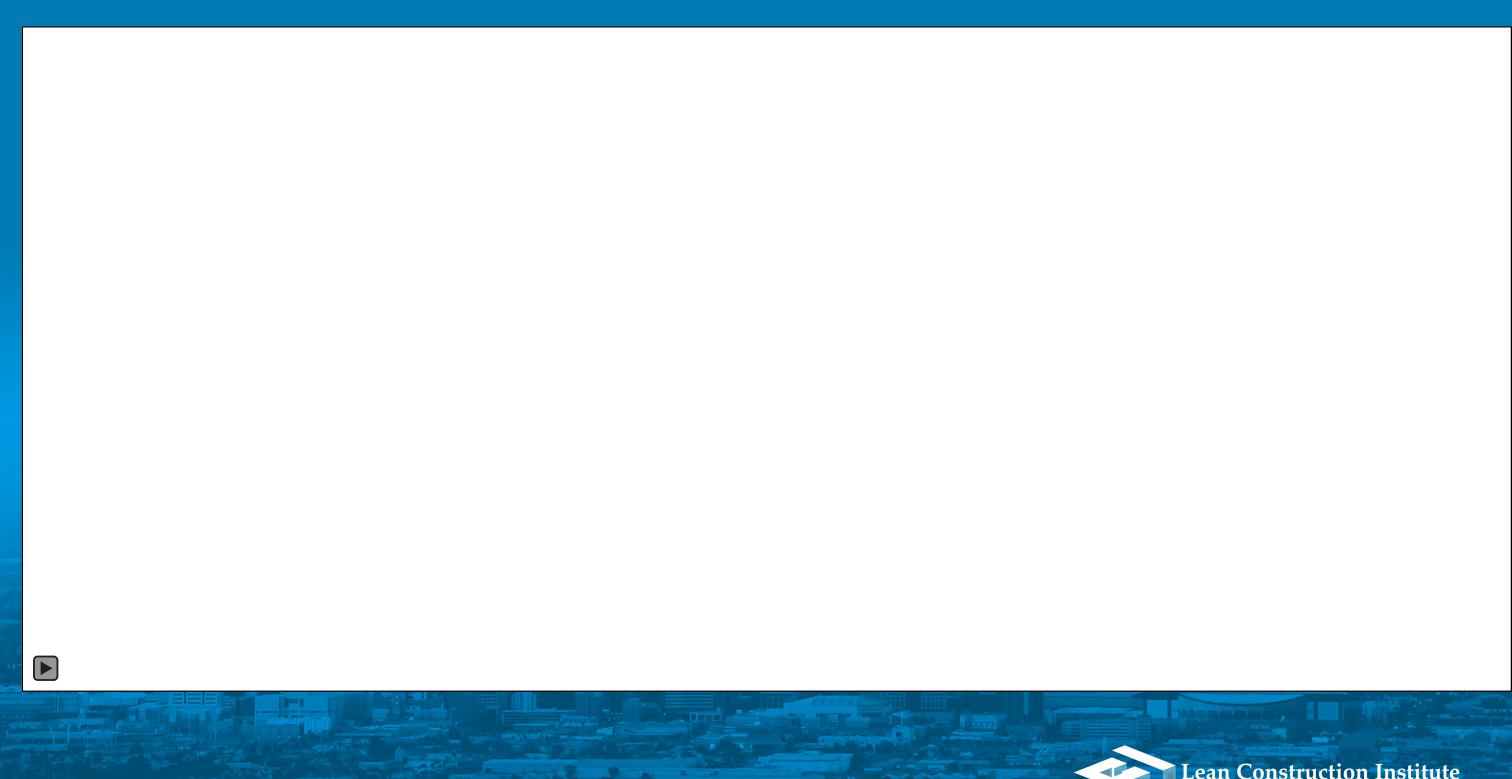




#### Floor Height Adjustment









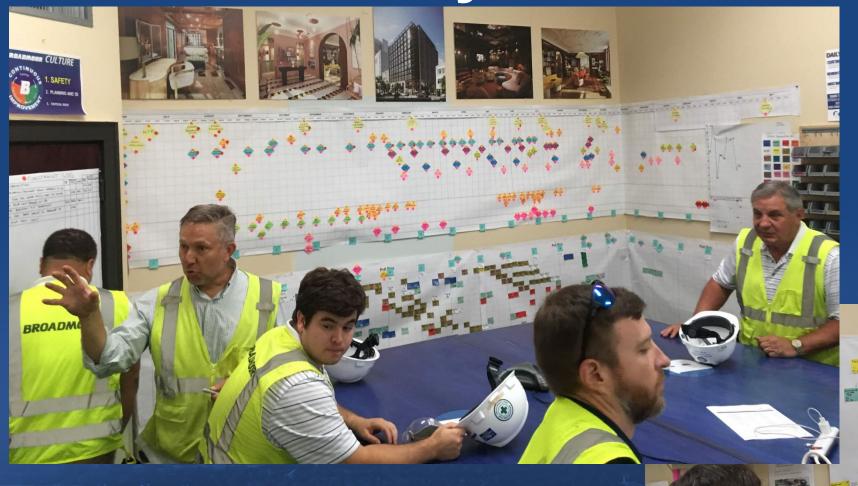
#### Last Planner System

Collaborative planning in a Big Room setting.





#### Last Planner System

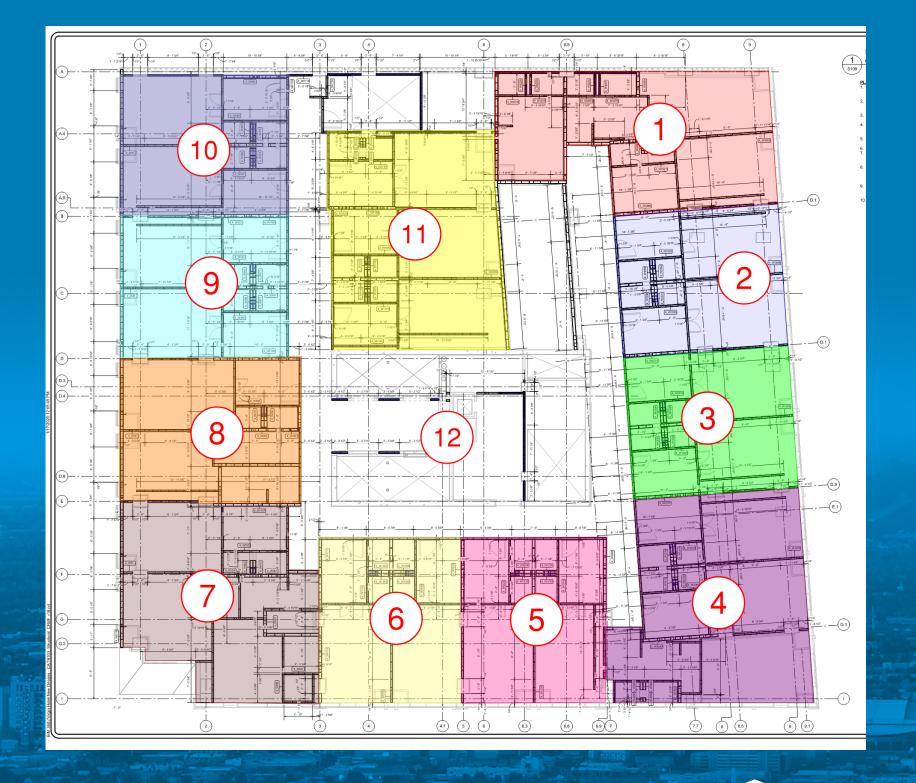


Milestone Schedule

Pull Planning



#### Takt Time Zones





#### **Takt Time Schedule**

Day	S	M	Т	w	Th	F	S	S	М	Т	w	Th	F	S	S	M	T	w	Th	F	S	S	M	Т	w	Th	F	S	S	M	Т	w	Th	F	S	S	М	Т	W
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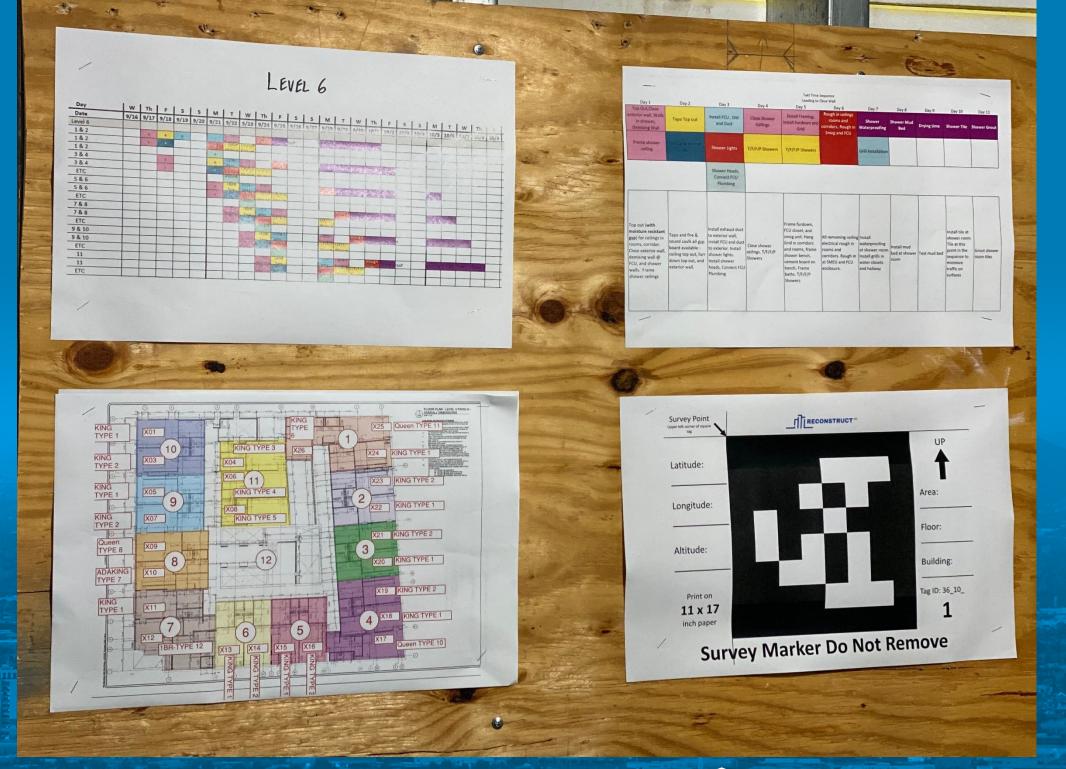


#### **Takt Time Activity Description**

Day 1	Day 2	Day 3	Day 3 Day 4 Day 5			Day 7	Day 8	Day 9	Day 10	Day 11
Top Out,Close exterior wall, Walls in shower, Demising Wall		Install FCU , DW and Duct	Detail Framing, Install Furdown and Grid, Close ceilings		Day 6 Rough in ceilings rooms and corridors, Rough in Smeg	Shower	Shower Mud Bed		Shower Tile	Shower Grout
Frame shower ceiling	Fire Caulk top out, etc.	Shower Lights	T/F Showers	F/P Showers		Grill Installation				
	Install Valves	Connect FCU Plumbing, Shower Heads								
rooms, corridor. Close exterior wall, demising wall @ FCU, and shower	Tape and fire & sound caulk all gyp board available - ceiling top out, furr	Install exhaust duct to exterior wall, install FCU and duct to exterior. Connect FCU Plumbing, Install shower lights. Install shower head	Frame furdown, FCU closet, and smeg unit.Close shower ceilings. Hang Grid in corridors and rooms, frame shower bench, cement board on bench, Frame baths. T/F Showers	F/P Showers.	rough in -	Install waterproofing at shower room. Install grills in water closets and hallway	Install mud bed at shower room	Test mud bed	•	Grout shower room tiles



#### Takt Time Boards







## Exterior Skin Prefabrication & Coordination





## Alley Precast Erected with Tower Crane





#### **Coordination with Elevated Formwork**



#### LEAN GEMBA WALKS



#### **GEMBA WALK**

#### **OBSERVE**

- -Walk With a Purpose
- -Not a Time to Instruct
- -Seek to Understand

#### ENGAGE

- eaders Ask Questions
- -Create Safe Sharing Environment
- -Uncover Chances for Improvement

#### IMPROVE

- -Understand the Process
- -Look For Waste
- -Allow Solutions to Come From Those Involved



"If You Don't Know How To Ask the Right Questions, You Discover Nothing." -W. Edwards Deming

RESPECT & CHALLENGE PEOPLE
DOES WORK FLOW?
ARE HANDOFFS RELIABLE & EFFICIENT
RAISE ACCOUNTABILITY





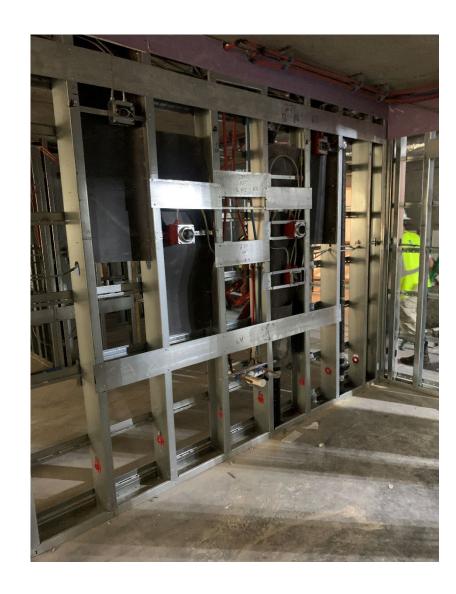


# PANELIZATION THROUGH DIGITAL DESIGN





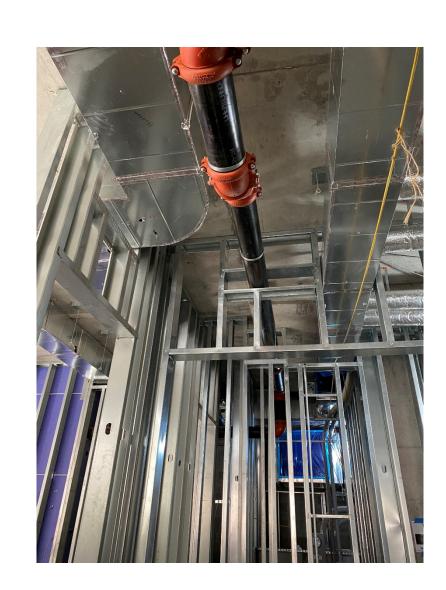
#### Thoughtful design + BIM + CNC = precision coordination



Our process and technology accommodates the penetrations for plumbing, mechanical, & electrical system components.

System elements are engineered to maintain alignment from panel to panel for ease of installation in the field or in our manufacturing facility.

systems integration

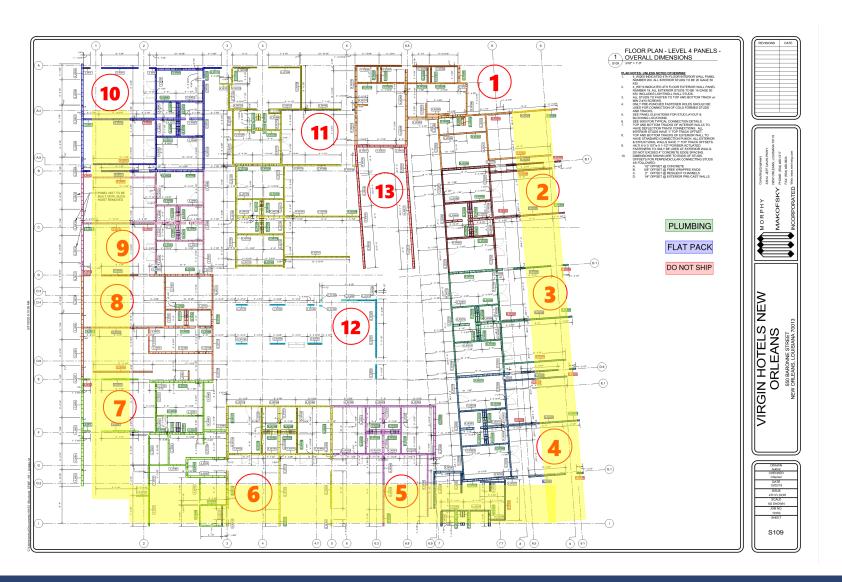




The controlled environment affords better quality assemblies built faster and with fewer touches.

### controlled environment

### coordinated deliveries & installation





## Safety & Sustainability

- Our material is 100% recyclable
- Our process reduces waste to 2% or less.



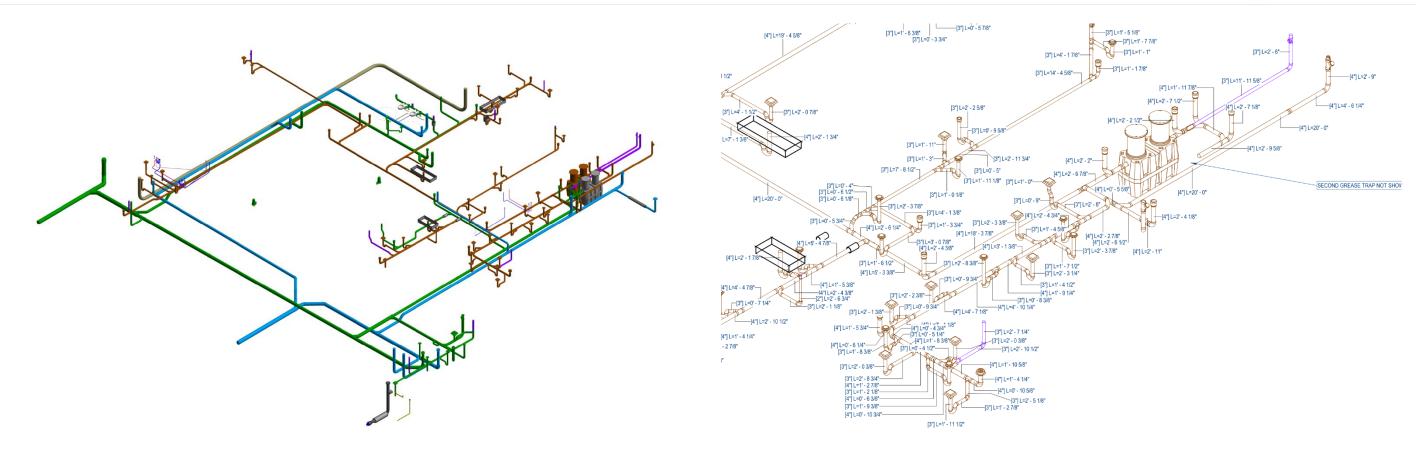
#### Prefabrication & Planning







#### Underground Prefabrication



- Last Planner coupled with BIM Coordination helped us see the whole picture.
- Coordinating with other trades forced redesign of the system to simplify staging of installation.
- Breaking down the piping into systems & areas allowed us to "kit" the piping for the delivery to site based on need.

#### Underground Prefabrication





- "Kits" consist of cutting pipe to length with as many joints installed in the fab shop as possible.
- Existing conditions changed the plan, but we were still able to meet initial milestone.

#### Underground Prefabrication

#### **KEYS TO SUCCESS**

- Use BIM modeling to coordinate with structure & Electrical/IT trades.
   CORRECT CONTENT IS KEY!
- Use Last Planner to create workflows for all teams with proper sequence.
- Adjust Design based on field crew's input to allow for partial testing & inspection.
- Use Robotic Layout tools to minimize reliance on string lines.
- HAVE A BEST-IN-CLASS FIELD CREW!

#### **LESSONS LEARNED**



- Make an adaptable plan.
- Pray to rain gods.



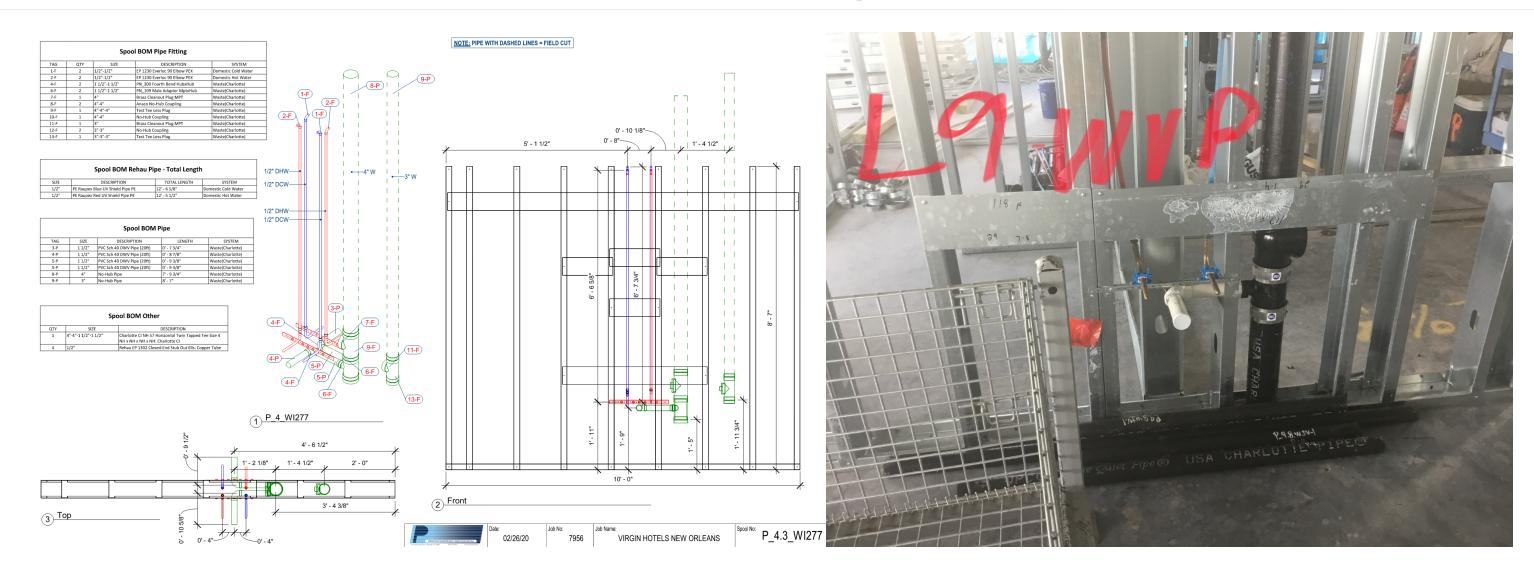
Precut & glue as much piping as possible.



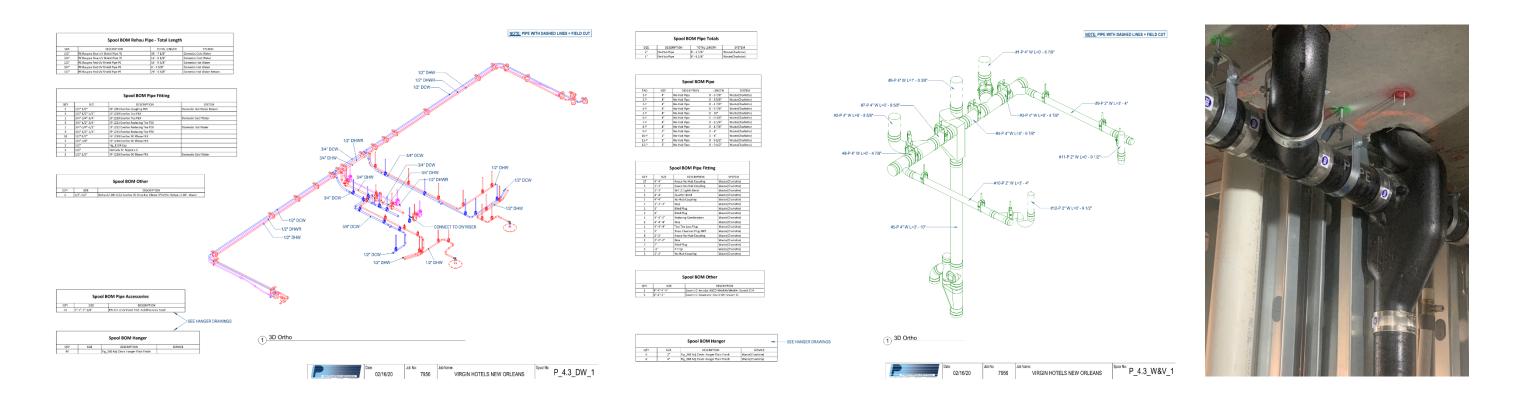
 Avoid gluing 6" and larger piping since it makes assembly harder in field.



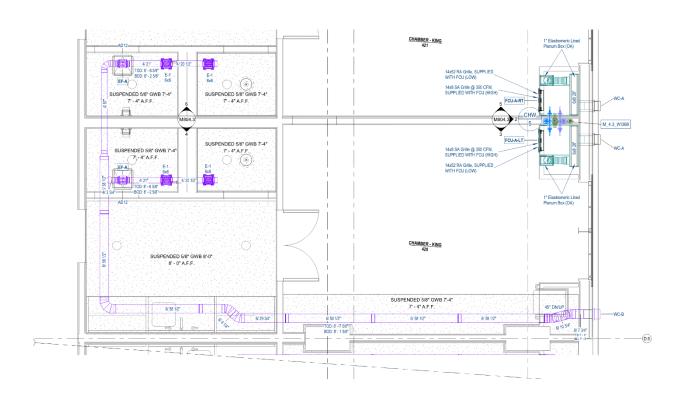




Wall panelization with BIM Coordination allowed us to install in wall plumbing components off-site.



 Kitting & packaging of overhead work into carts with wheels allowed us to work from our shop instead of jobsite during the early stages of the COVID outbreak.





Exhaust duct prefabrication for guestrooms.

#### **KEYS TO SUCCESS**

- All components need to be defined & modeled for wall panelization to add value. The small details make or break the plan.
- Use Last Planner to create workflows for all teams with proper sequence.
- Use Robotic Layout tools & shared control points to make sure all trades are laying out the same way.
- HAVE A BEST-IN-CLASS FIELD CREW!

#### **LESSONS LEARNED**



Minor details are major details when panelizing walls.



Rework with panelized walls is more difficult than conventional framing.



Field tolerances need to be accounted for in the planning effort.



Delivery & Lifting of wall panels/prefab kits requires some logistics & planning.



 Pre-rock needs to be defined in early stages of planning.



Rolling carts & kit delivery were very valuable.

#### Overhead Pipe Kits





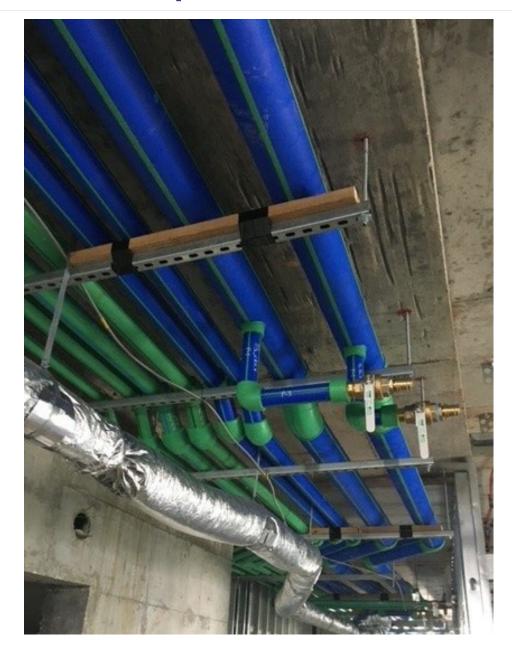
Making as many joints as possible offsite helps reduce time for installation onsite.

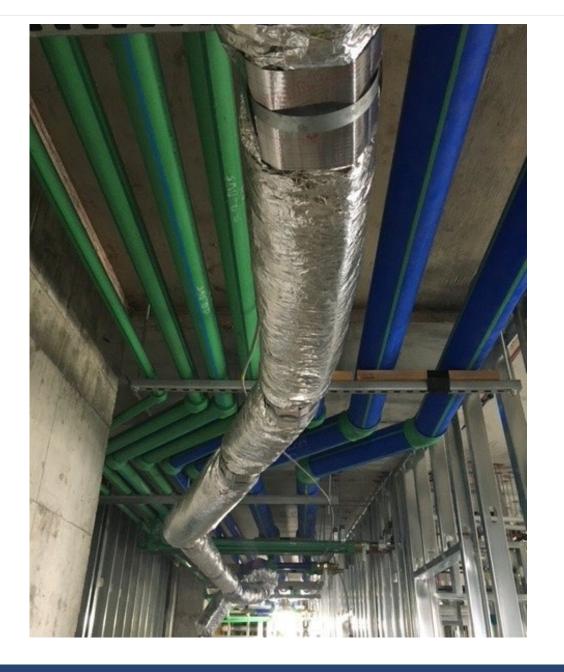
#### Overhead Pipe Kits



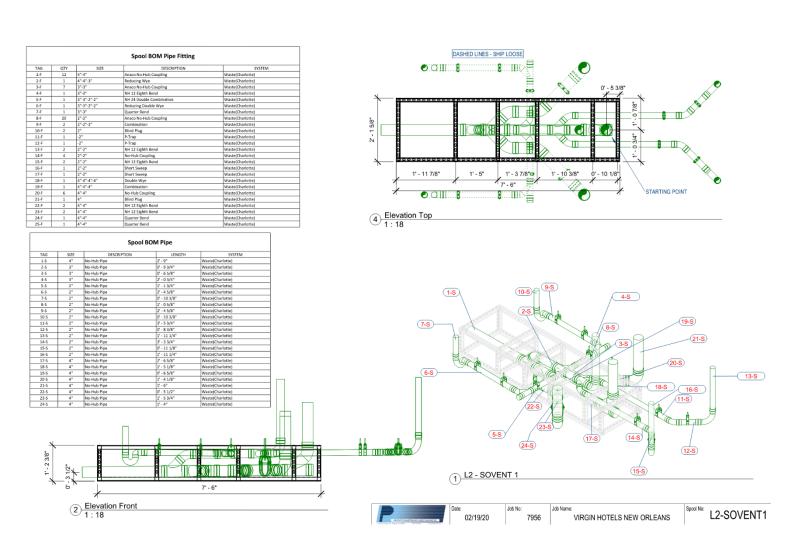


#### Overhead Pipe Kits





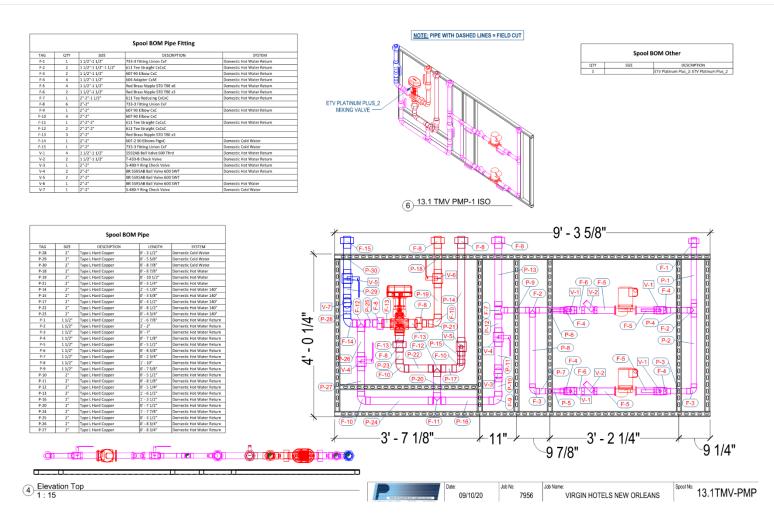
#### Component Prefabrication





 Sovent racks for the base of the system made installation of the most critical component very consistent between risers.

#### Component Prefabrication





 Wall mount racks for the domestic water mixing valves & recirculation pumps help reduce number of components to keep up with on-site.

#### Pipe Kits & Component Prefabrication

#### **KEYS TO SUCCESS**

- BIM Coordination & modeling make it work.
- Organization & naming of work packages is important to make sure all teammates "speak the same language"
- HAVE A BEST-IN-CLASS FIELD CREW!









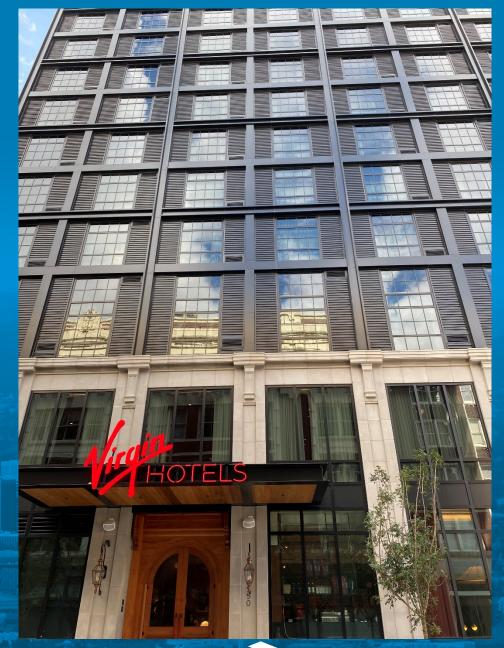


#### **LESSONS LEARNED**

- Garbage in = Garbage out
- How we sort, label, & deliver piping bundles to the jobsite makes a big difference.
- Smaller component prefab helps remove risk of errors in the field.

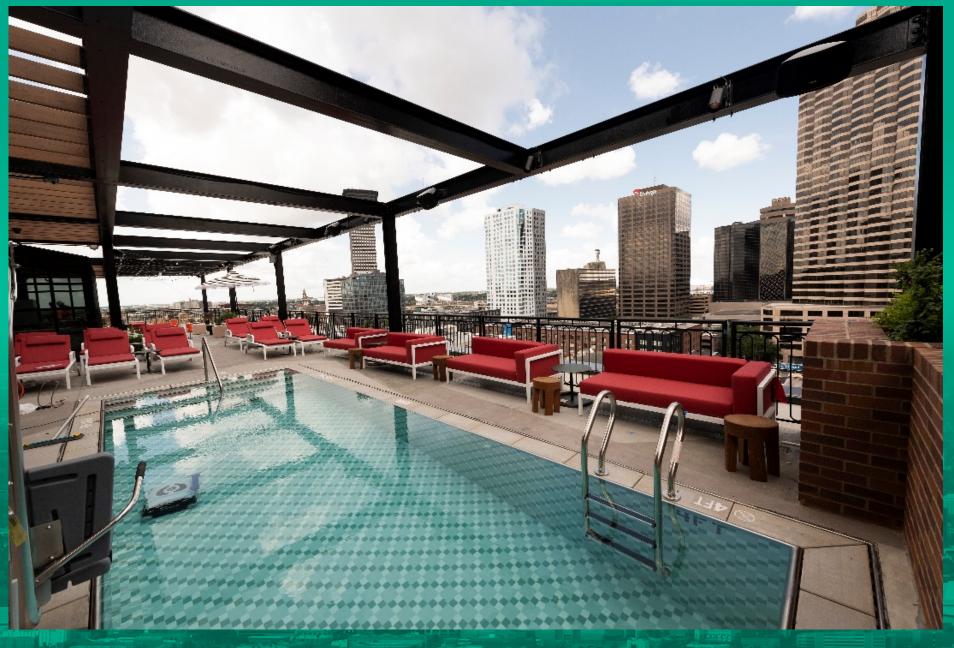
#### **Project Photos**







#### **Project Photos**





#### Virgin Hotel Grand Opening









In the spirit of continuous improvement, we would like to remind you to complete this session's survey! We look forward to receiving your feedback.



#### Contact Us

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#### Thank you for attending this presentation. Enjoy the rest of the 23<sup>rd</sup> Annual LCI Congress!

