



**Peter Pan Peanut Butter**  
**Sylvester, Georgia Processing Plant**



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## **Executive Summary**

Throughout this technical report I have uncovered a wealth of knowledge about my thesis project. While working for The Haskell Company in the summer of 2007 and assisting with Peter Pan Peanut Butter I have also gained the information needed to complete all the necessary requirements for this and further assignments. ConAgra Foods is one of the world's largest and most well know companies today. They are responsible for the production and distribution of many of the top brands in America such as, Hunts ketchup, Chef-boy-r-d, and of course Peter Pan Peanut Butter.

The call was made to The Haskell Company to come to look at a potential renovation on the roof at the processing plant, the scope of quickly grew into a whole project, large scale and with an extremely tight schedule. The current 200,100 SF facility was to be completely renovated in a total of 3 months. Crews worked around the clock, 24 hours a day and 7 days a week to bring the facility up to modern standards.

The primary project team consisted of the Following:  
ConAgra Foods Inc. (owner)  
The Haskell Company (design-build contractor)  
Structures International LLC (structural consultant)  
Solis Parker & Associates, Inc. (structural consultant)

Project Stallone is one of the most unique projects that I have ever seen and been involved with. If there was not as much teamwork and collaboration on this project with a whole team trying for the ultimate cause of getting the plant up and running, it would have been a disaster for many involved and carrying lots of risk.



Dr. Messner

Technical Report #1

**Project Summary Schedule:**

The schedule for Project Stallone was broken down by rooms of the building. It was broken down like this because of the phased occupancy, one day an area was free and the next it would be blocked off for sanitation or another contractor was there. Certain rooms had to be turned over to the owner sooner or later than others. The design for the project was going on along with the actual building on-site. All of the work associated with Project Stallone was crammed into a small window of about 3 months.

	Durration (Days)	Start	Finish	6-May	13-May	20-May	27-May	3-Jun	10-Jun	17-Jun	24-Jun	1-Jul	8-Jul	15-Jul	22-Jul	29-Jul	5-Aug	12-Aug
<b>HVAC Systems</b>																		
Design HVAC	30	6-May	5-Jun															
Install Make-up air units	25	6-Jun	1-Jul															
Conect all MAU's to power	8	28-Jun	6-Jul															
HVAC Controls	40	29-Jun	8-Aug															
Repairs to cooling towers	6	7-Jul	13-Jul															
Make gas conections to MAU's	13	20-Jul	2-Aug															
<b>Steel Modifications and Unloading</b>																		
Steel Modifications design	43	6-May	18-Jun															
Place Shoring	18	20-May	7-Jun															
Install Braces for Unloading	39	14-Jun	23-Jul															
Install Fixes for Frames	46	14-Jun	30-Jul															
Unload Existing Frames	10	30-Jul	9-Aug															
Remove Shoring	9	1-Aug	10-Aug															
<b>Roofing</b>																		
Clean Existing Roof	3	28-May	31-May															
Place 1-ply Roofing Membrane	28	1-Jun	29-Jun															
Place Flashing	8	30-Jun	8-Jul															
<b>Raw Bin and Receiving Area</b>																		
Place concrete base for walls	9	6-May	15-May															
Place Insulated metal panel walls	13	16-May	29-May															
Install lighting	16	30-May	15-Jun															
<b>Old Roaster Room</b>																		
Clean Walls and Paint	14	4-Jun	18-Jun															
Place concrete base for walls	9	10-Jun	19-Jun															
Place IMP Walls	12	20-Jun	2-Jul															
Install Floor Drains for COP room	8	2-Jul	10-Jul															
Install lighting	22	1-Jul	23-Jul															
Install plumbing	26	11-Jul	6-Aug															

Table A (See full sized Project Schedule Attached in Appendix)

**Building Systems Summary:**

Yes	No	Work Scope	If yes, address these questions/issues
X		Demolition Required	<ul style="list-style-type: none"> <li>The removal of old vinyl insulation that was draped over the existing purlins of the metal building.</li> <li>Demolition was also required where the addition of doors were needed in an existing CMU wall.</li> </ul>
X		Structural Steel Frame	<ul style="list-style-type: none"> <li>Bracing was added to the extremely over stresses frames in the building.</li> <li>Braces were added throughout the building to remove weight from the existing structure.</li> <li>Small mobile cranes were used inside the building to erect braces.</li> </ul>
X		Cast in Place Concrete	<ul style="list-style-type: none"> <li>Reusable metal horizontal and vertical formwork was used to form curbs for walls.</li> <li>For the interior cast in place concrete cart was used to haul concrete from the pump truck to an interior location. All exterior concrete was direct chute.</li> </ul>
	X	Precast Concrete	<ul style="list-style-type: none"> <li>There was no use of precast concrete on Project Stallone.</li> </ul>
X		Mechanical System	<ul style="list-style-type: none"> <li>14 Make-up air units each producing 20,000 – 25,000 CFM were added for the pressurization of the building.</li> <li>1 air handling unit with cooling at 2,500 CMF was added.</li> </ul>
X		Electrical System	<ul style="list-style-type: none"> <li>Lighting was added at 277/480V.</li> <li>Receptacles at 120/208V were added.</li> <li>(2) 480V Motor control centers.</li> <li>(2) 480 to 120/208 Transformers were added.</li> </ul>
X		Masonry	<ul style="list-style-type: none"> <li>Masonry work was limited to repairs made through existing CMU walls that were removed for the placement of doors.</li> </ul>
	X	Curtain Wall	<ul style="list-style-type: none"> <li>There was no work done to the curtain wall of the building, other than flashing penetrations made through the existing metal panels.</li> </ul>
	X	Support of Excavation	<ul style="list-style-type: none"> <li>There was no excavation on this renovation project.</li> </ul>



## Project Cost Evaluation

Several cost analysis calculating methods were used in determining the costs for the renovation of the Peter Pan Peanut Butter Processing Plant for ConAgra Foods. First are the actual project costs broken down into the respective CSI divisions. Next is a D4 cost estimate, D4 is a estimating program that has up to date cost and industry information on almost every type of construction there is. Finally is an estimate that is produced using R.S. Means, a estimating resource that is very well known in the industry.

### Actual Project Costs

<b>ConAgra Foods: Project Stallone Project Costs</b>			
<b>Package</b>	<b>CSI Division</b>	<b>Total Cost (\$)</b>	<b>SF Cost (\$)</b>
General Conditions	0	\$656,163.00	
Site Construction	2	\$103.00	
Concrete	3	\$155,069.00	
Masonry	4		
Metals	5	\$4,349,997.00	
Woods and Plastics	6		
Thermal and Moisture	7	\$1,678,365.00	
Doors and Windows	8	\$20,440.00	
Finishes	9	\$595,834.00	
Specialties	10		
Equipment	11	\$80,208.00	
Mechanical	15	\$3,021,857.00	
Electrical	16	\$590,219.00	
<b>Total Contract:</b>		<b>\$11,148,255.00</b>	<b>\$55.71 / SF</b>
AE Design FEE	8.80%	\$977,375.00	\$4.88 / SF
Design-Build FEE	8.80%	\$977,644.00	\$4.89 / SF
<b>Project Total:</b>		<b>\$13,103,274.00</b>	<b>\$65.48 / SF</b>

Table B

## Site Plan of Existing Conditions

The Site plan of ConAgra Foods Project Stallone is shown below as you can see that the site is a very open area with an existing fence around the current building. There is very tight security to get into the entrance, one entrance is monitored by a guard 24 hours a day 7 days a week and he/she is the only person with a key to access the other gated entrance at the other side of the site. Because this is a renovation project there is no need for a crane. There is a huge parking lot that will be utilized for parking and material storage. Material storage is available in only certain areas due to ConAgra Foods keeping a clean, orderly, and safe site. (See Attached Site Map in Appendix)

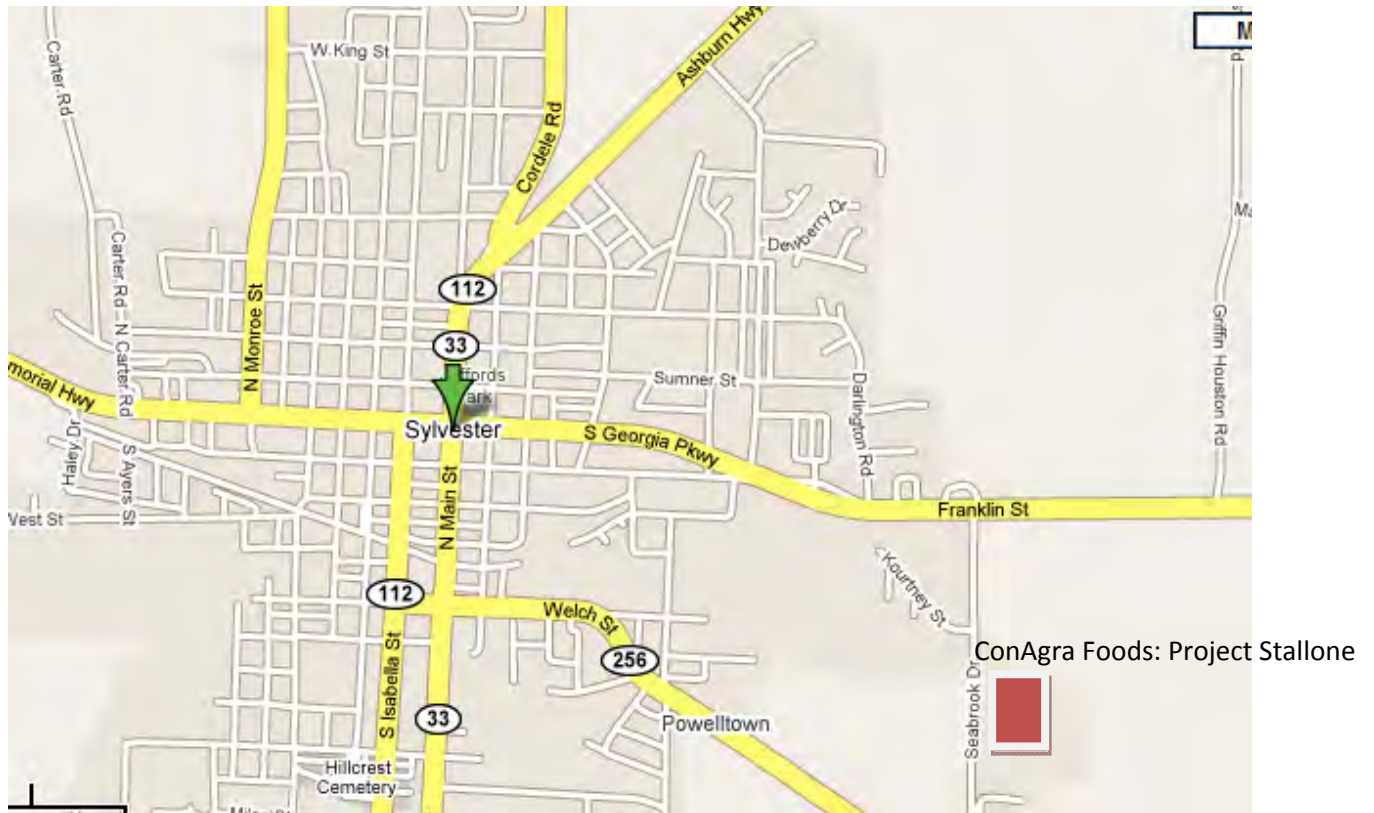


Table C Vicinity map of Sylvester, GA.

## **Local Conditions:**

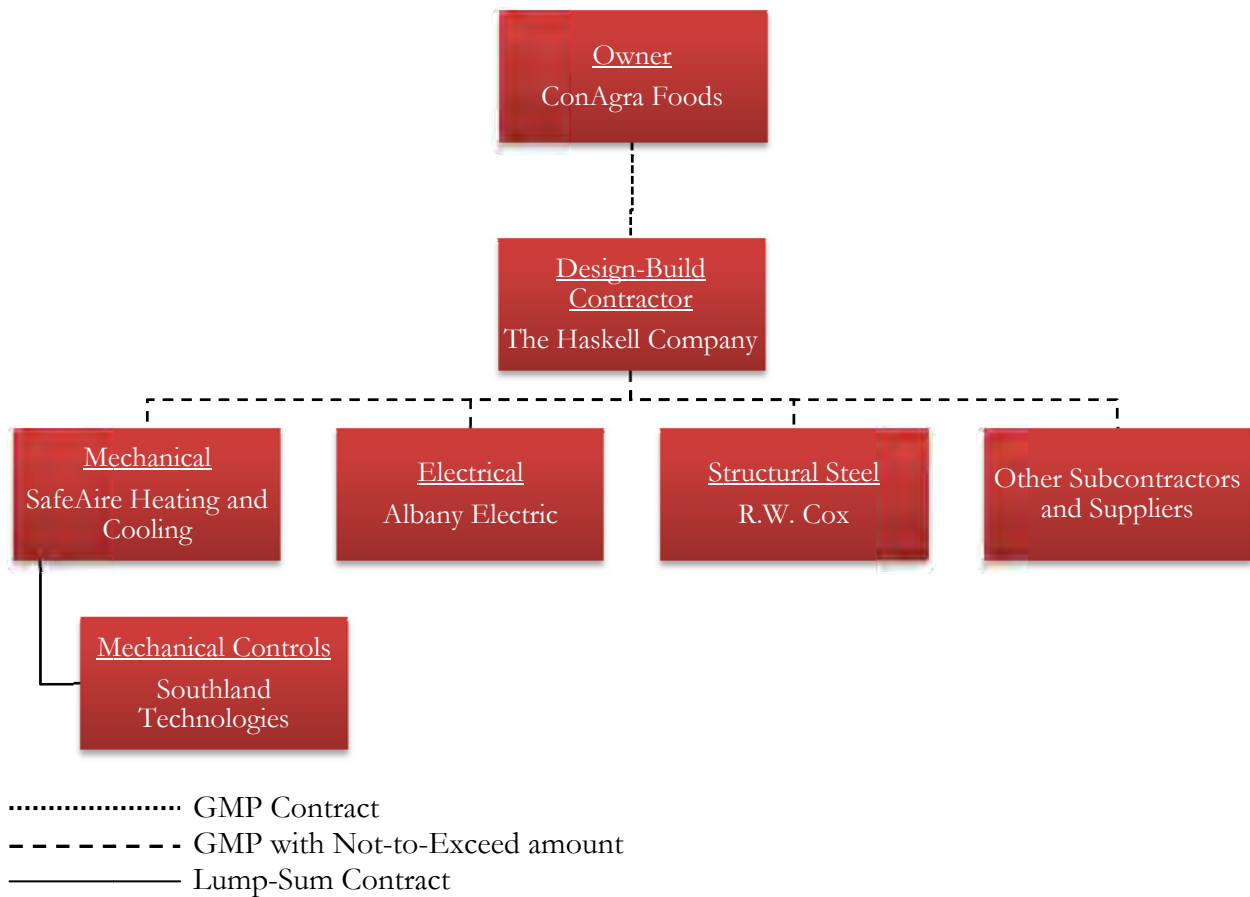
There are not very many conditions that are associated with the building, site or region. The building is located in Sylvester, Georgia, a small town outside of Albany, Georgia. The closest neighboring building is approximately 2,500 feet away, therefore there were no restrictions or problems with us interfering with any neighbors. There was not particular preferred working method that any of the contractors had in the area. The work on the project was done quickly and of the top most quality only because of the priority of the project. The parking onsite was an issue and additional parking in the front of the building was opened during the peak of the project. Each person that entered the site had to be issued a badge and must have gone through a training class to familiarize themselves with the project. ConAgra Foods had a deal with the local trash removal contractor in the area to remove the trash for free as long as the metals were separated from general trash. Stainless steel was also separated from the metals as well, with the money from that returning back to ConAgra Foods.

## **Client Information:**

The owner of the project is ConAgra Foods, a large producer, manufacturer, and distributor of food. At the processing plant in Sylvester, Georgia ConAgra Foods produces peanut butter. From this plant raw peanuts go in one side and finished packaged peanut butter comes out from the other. This plant produces peanut butter for Peter Pan as well as the Great Value brand of peanut butter sold at Wal-Mart stores nationwide. The reasoning for the renovation on this building is for the general upkeep to a top quality level that a food processing plant should be. There were really no cost exceptions for the project, but the schedule was of the highest priority, being that every day that the plant is down peanut butter is not being produced for sale. ConAgra Foods is a very safety orientated company. Walking through the building this becomes evident, there are safety signs posted everywhere. On the project there was a zero tolerance policy for anyone acting in an unsafe manor, any violator would be removed without question. There was joint phased occupancy in the project, due to the tight schedule. During construction of the building there was a contractor who was in charge of all furnishings as in conveyors, roasters, and pipe work. ConAgra Foods also had all of their people working in the building cleaning existing equipment.

## Project Delivery System

The Haskell Company acts as the Design-Build contract on this job with a GMP contract. The deal was negotiated with ConAgra Foods, which The Haskell Company has done work for in the past. This type of delivery was chosen because of the extreme amount of work that needed to be performed in such a short span. The Haskell Company had a modified GMP contract with a not to exceed cost for each of the subcontractors, with the exception of two outside structural engineering firms, who were on a cost plus fee contract. Second tier subcontractors all carried lump sum contracts with their respective contractors.







## Project Staffing

The staffing for Project Stallone was organized as outlined in the following chart. The Director of Construction was onsite for one day in every two weeks. The Senior PM and the other two PM's for the project were onsite for 2-3 days out of every week, usually rotating their time to ensure that there was always a Project Manager onsite at all times. The superintendents were onsite and on call for the whole duration of the project, the same is for the Assistant Project Manager and the Project Assistant. Superintendents, the Assistant PM, and the Project Assistant worked to keep a steady flow of work going on 24 hours a day and 7 days a week. The Superintendent was also responsible for a carpenter and an operator that were employed by The Haskell Company for Project Stallone.

