

# Compendium of Prospective Emerging Technologies for Mass Housing

Second Edition

**bmtpc**

Building Materials & Technology Promotion Council  
Ministry of Housing & Urban Poverty Alleviation  
Government of India





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Second Edition

April 2017



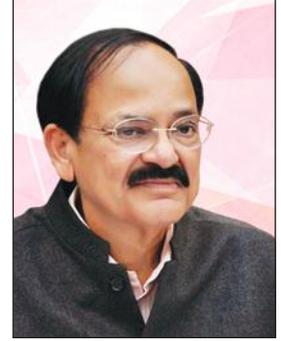
Building Materials & Technology Promotion Council  
Ministry of Housing & Urban Poverty Alleviation  
Government of India





**M. VENKAIAH NAIDU**

*Minister of Housing and Urban Poverty Alleviation,  
Urban Development and Information & Broadcasting  
Government of India*



## Message

**T**he need to look beyond conventional construction practices of energy intensive building materials based on natural resources and to introduce fast track emerging technologies, which not only bring speed & quality but are safe, durable leading towards sustainable development, to fulfill the goal of housing for all, was emphasized, while launching the Pradhan Mantri Awas Yojana (Urban) on June 25, 2015 by the Hon'ble Prime Minister of India. This need is more pronounced now with ever depleting natural resources, shortage of work force in urban areas, global commitment of reducing carbon footprint and increased focus on affordable housing in the country.

Eight technologies from across the globe, identified and evaluated earlier by the Building Materials & Technology Promotion Council (BMTPC), under the aegis of Ministry of Housing & Urban Poverty Alleviation, GoI and introduced through a Compendium, have shown encouraging results in their uses in mass housing programmes in many states.

With this initiative of the government, more and more technology providers of emerging new technologies are now willing to play active role in the massive programme of the government. I am happy to know that BMTPC under the guidance of Technology Sub Mission and Mission Directorate in the Ministry has identified and evaluated eight more such technologies from different agencies.

This upgraded booklet with technical profile of 16 such technologies, aims to provide first hand information about these technologies for their use in mass housing programme. The usage of these technologies in housing programme in the country could help expediting the delivery of housing stock and meeting the desired goal of "Housing for All and Environmental Protection".

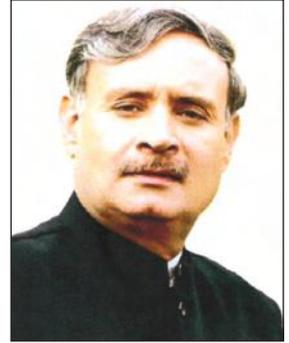
  
(M. Venkaiah Naidu)





**RAO INDERJIT SINGH**

*Minister of State (Independent Charge) for  
Ministry of Planning and MoS for Ministry of Urban Development and Housing  
& Urban Poverty Alleviation  
Government of India*



## Message

“Housing for All by 2022” - the dream mission of Hon'ble Prime Minister, Shri Narendra Modi is now at implementation stage. With the extension of interest subsidy for MIG category by the Government, the Mission has got a big boost and increased construction activities are envisaged in the housing sector in coming years.

With the constraints of non-availability and increasing cost of some of the basic building materials used in traditional construction practices, environmental concerns and shortage of work force in the urban areas; concerned agencies of State Governments and UTs are in look out for new viable fast track emerging technologies.

Building Materials & Technology Promotion Council (BMTPC), taking the initiative, brought out a Compendium of eight prospective emerging technologies, identified and evaluated for mass scale housing by them, at the time of launching the Mission by the Hon'ble Prime Minister of India on June 25, 2015.

The continuous efforts put up by BMTPC in identifying, evaluating and certifying further new technologies is laudable and it is hoped this will provide better options to the States while selecting technologies for their mass housing projects. I hope these technologies will now be seen in the upcoming housing projects under the Pradhan Mantri Awas Yojana across the country.

I congratulate BMTPC for their efforts of bringing new emerging technologies for mass housing.

  
(Inderjit Singh)





**DR. NANDITA CHATTERJEE**  
*Secretary*  
*Ministry of Housing & Urban Poverty Alleviation*  
*Government of India*



## Message

**W**ith the aim to provide sustainable, safe & affordable technological solutions for faster & cost effective construction of houses suited to various geo-climatic and hazard conditions of the country, the Government of India has set up a Technology Sub-Mission as a part of “Pradhan Mantri Awas Yojana (Urban) – Housing for All” Mission.

The conventional construction system are primarily a cast in situ, slow pace construction system besides being energy intensive and dependent on natural resources which cannot meet the present requirement of Housing Shortage. Therefore, it is the call of the day to adopt new construction systems which are fast track and at the same time which meet functional & structural requirements, ensuring a paradigm shift from a slow track system to fast track emerging systems. This will require judicious selection and evaluation of globally acceptable contemporary technologies to suit the Indian Specification including utilization of local available resources, wherever feasible.

It is indeed heartening that Building Materials & Technology Promotion Council (BMTPC) has identified & evaluated 16 emerging technologies under its Performance Appraisal Certification Scheme (PACS) and is bringing out the second edition of Compendium on Prospective Emerging Technologies for Mass Housing under the guidance of Technology Sub Mission.

This Compendium containing technology details of sixteen such evaluated technology is expected to be a useful resource for State Governments and related Housing Agencies for construction of mass housing, will help in speedy delivery of housing stock and in achieving the desired goals of Housing for All and Climate Change.

I wish BMTPC all success in their efforts.

  
(N. CHATTERJEE)

Place : New Delhi  
Dated: 24.03.2017





**RAJIV RANJAN MISHRA**  
*Joint Secretary (Housing)*  
*Ministry of Housing & Urban Poverty Alleviation*  
*Government of India*



## Message

The “Housing for All by 2022” Mission is entering its third year of implementation in urban areas. Such an ambitious task requires multi-faceted approach and significant amongst it is the role of technology, which can ensure speed, quality & sustainability. This is also in consonance with the Global commitments of achieving Sustainable Development Goals and New Urban Agenda, which demands technological innovation to reduce resource and energy consumption especially with proliferating urbanization and urban footprint. Conventional methods of construction have not only strained our present resources but have also put an undue pressure on their equitable distribution for competing needs, significant among which is the use of water. The use of cement, sand and bricks has for centuries been the central cause of pollution and in this context, it is pertinent to explore alternatives to achieve a drastic balance in the ecology of sustenance.

The Ministry of Housing & Urban Poverty Alleviation, Govt of India has taken several initiatives including setting up of Technology Sub-Mission under Pradhan Mantri Awas Yojana (Urban) to facilitate adoption of modern, innovative and green technologies and building materials for faster and quality construction of houses. A step in this direction included release of publication “Compendium of Prospective Emerging Technologies for Mass Housing”, containing eight emerging technologies evaluated & certified by Building Materials & Technology Promotion Council (BMTPC), during launch of the Mission. The publication was circulated to all the States/UTs for deploying environment friendly technologies in mass housing projects and it is a matter of satisfaction that these technologies are getting good recognition. While some States/UTs have used these technologies, some others are in process of using it.

BMTPC has now evaluated and certified eight more technologies during last one and half year period under its Performance Appraisal & Certification Scheme (PACS). With inclusion of these additional technologies, which are mainly new variants of recent construction systems, the present publication encompasses the details of sixteen technologies.

I sincerely hope that various public & private housing agencies would find this document as a useful resource for selection of appropriate technologies in their mass housing projects.

  
(Rajiv Ranjan Mishra)





**AMRIT ABHIJAT**

*Joint Secretary & Mission Director (Housing for All)  
Ministry of Housing & Urban Poverty Alleviation  
Government of India*



## Message

**T**he Pradhan Mantri Awas Yojana (Urban) - Housing for All Mission has grounded firmly and gained momentum as most of the States have completed their demand survey and bringing more and more projects for Central Assistance. It is also observed during the last two years that states are realizing the fact that without the use of new fast track technologies, it will not be possible to achieve the target of providing houses to all by 2022. Few states have already started implementing projects with new technologies and others are approaching Ministry for seeking guidance in adopting new technologies for their projects.

I am glad that Building Materials & Technology Promotion Council (BMTPC), is playing a key role in mainstreaming these new technologies by providing technical assistance to states in identifying, evaluating and finalisation of technologies and also conducting sensitization programmes in the states.

Ministry in 2015, had published a Compendium of Prospective Emerging Technologies for Mass Housing which contained technical details of eight new technologies. During the last two years, BMTPC has identified and certified few more technologies, therefore, it was felt that updation of the compendium need to be done. BMTPC has prepared the new Compendium which contains sixteen technologies.

I am sure that this document will help the states in adopting appropriate technologies for their upcoming projects and fulfil the dream of common man by providing safe, durable and affordable house in quicker time.

I appreciate the efforts and contribution of BMTPC in preparing this document and also undertaking this ongoing exercise of identification, evaluation and certification of New & Emerging technologies.

  
(Amrit Abhijat)



## Foreword

With the launch of Pradhan Mantri Awas Yojna (PMAY) - Urban & Rural, which envisions to provide pucca house to each household of India by 2022, a year when India will be celebrating its 75th year of Independence, it is incumbent on part of academic, research & other organizations involved in construction to bring innovation & thus paradigm shift in the prevailing construction practices so as to fast-track delivery of houses without compromising structural & functional performance. With this objective in mind, BMTPC initiated identifying, evaluating & certifying new emerging construction systems from all across the globe which can help in replacing the conventional cast-in-situ RCC construction. The first set of such 8 technologies were published in form of compendium in 2015. It is heartening to mention here that with the concerted efforts put up by BMTPC, now, we have a set of 16 such new emerging technologies which can bring in speed, safety, sustainability in the construction sector and same are being published in this document as second edition of previous publication.

The next biggest challenge is to mainstream these new systems in the construction sector and, therefore, there is need to create an enabling eco-system to facilitate use of these new systems. Under PMAY(U) mission, Ministry of Housing & Urban Poverty Alleviation (MoHUPA) has setup a technology sub-mission which aims to encourage the use of sustainable & safe practices across states with the help of IITs/NITs. Under sub-mission, we are disseminating information to the states and also holding capacity building and sensitization programmes. The CPWD has also been brought in and they have recently published in DSR 2016, schedule of rates of three such technologies e.g. monolithic concrete construction, Expanded Polystyrene Core Panel system & Light gauge steel frame system. There have been a few circulars from CPWD & Ministry of Urban Development which recommends mandatorily use of such systems and encourage turnkey approach instead of item rate contract for use of new technologies. Bureau of Indian Standards (BIS) has also included these systems in their recently published NBC-2016. Apart from this, MoHUPA along with BMTPC is also constantly interacting with Defence, Railways & PSUs involved into construction such as NBCC, DDA etc. to make use of these emerging technologies in their own housing projects. The response has been very good. In fact, almost all states are coming forward to embrace these technologies for their upcoming social mass housing projects.

As of now, the only impediment in usage of these systems has been cost but given economies of scale, the cost comes comparable with conventional construction cost and there are host of additional benefits such as low maintenance, low life-cycle cost, better durability, improved thermal & acoustical performance, better hazard resistance, low wastages & above all green & sustainable development, which are often neglected while drawing comparisons.

The technical contributions made by BMTPC officers namely Shri J.K. Prasad, Shri S.K. Gupta, Shri C.N. Jha, Shri Pankaj Gupta, Shri A.K. Tiwari, Shri Y.D. Munjal & Shri Dalip Kumar in bringing this compendium are deeply appreciated and acknowledged. Through this publication, I solemnly hope that the all stakeholders involved into construction including state agencies will make use of the information available in right earnest and start using these innovate systems in their future housing projects so as to fulfil the dream of Govt. of India of providing housing to all without vitiating the environment & stressing the natural resources.

Date: 23<sup>rd</sup> Day of March, 2017  
Place: New Delhi



(Dr. Shailesh Kr. Agrawal)  
Executive Director, BMTPC



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## Background

The Pradhan Mantri Awas Yojna (Urban) launched on 25th day of June 2015, set the target of delivering approximately 20 million houses by 2022 and subsequently Pradhan Mantri Awas Yojna (Rural) launched on 1st day of April 2016 envisages 10 million houses in next three years. In order to achieve this gigantic task, the natural question comes to mind whether we have sufficient quantity of such building materials which do not impact the mother earth adversely and further do we have existing construction practices in vogue which can help fast delivery of houses? The answer to both the question is negative as if we look at the traditional building materials e.g. brick, cement, steel, aggregates, sand etc., they are either based on natural resources which are finite in nature or energy intensive or emit greenhouse during production. Thus, the entire proposition of using these materials as usual will not be sustainable and environment friendly. Further, the construction technologies being practiced in India, is cast-in-situ RCC framed construction which is primarily slow track construction methodology and is subjected to time & cost overruns. Also, these constructions are labour intensive, which further hamper fast delivery, as there is acute paucity of unskilled labour force in cities. Therefore, it is prudent to take a paradigm shift from brick & stick approach and look for alternate systems which overcome these limitations. There have been number of such construction systems available elsewhere in the world which are in use since decades successfully. Nevertheless, these systems to be promoted and adapted in Indian conditions. BMTPC have been identifying, evaluating and certifying these systems and also in order to showcase these technologies, demonstration housing projects are being executed in different states. Our endeavor has been to bring innovation, speed, safety & sustainability in the existing construction methodology without compromising structural & functional performance. Also, BMTPC has been conducting capacity building programmes across India, in partnering with states, so as to educate practicing engineers & architects, students, policy makers, contractors and artisans about these technologies.

In order to give further impetus to these technologies, Ministry of Housing & Urban Poverty Alleviation has assertively pursued with Ministry of Urban Development, CPWD, BIS and state departments to come out with notifications, circulars, SORs, specifications etc. which will authorize state governments to use these new construction technologies in housing projects. The various OMs of Ministry of Urban Development and CPWD are included in Appendices. CPWD has included New Technology Items in Delhi Schedule of Rates (DSR) 2016 Volume-2 namely (a) Light Gauge Steel Framed System (Item No. 26.41 to 26.45), (b) Expanded Polystyrene Core Panel System (Item No. 26.46 to 26.47), and (c) Aluminum Formwork for Monolithic Construction (Item No. 26.48) and their detailed analysis is given in Delhi Analysis of Rates(DAR) 2016 (Volume-2).

Further, in the recently published National Building Code 2016 by BIS, provisions have been updated to ensure utilization of number of new/alternative building materials and technologies to provide for innovation in the field of building construction. Updated provisions on new alternate technologies for speedier construction have also been included in Part-5 BUILDING MATERIALS; Part-6 STRUCTURAL DESIGN: Section 7 Prefabrication and Systems Building and Mixed/Composite Construction, 7A Prefabricated Concrete, 7B Systems Building and Mixed/Composite Construction; and Part-7 CONSTRUCTION MANAGEMENT, PRACTICES AND SAFETY.

This second edition of compendium contains following sixteen innovative construction systems, developed within the country and from abroad and are recommended based on their technical suitability. A few others are under evaluation.

**Formwork Systems**

- 1 Monolithic Concrete Construction System – (a) using Plastic - Aluminium Formwork; and (b) using Aluminium Formwork
- 2 Modular Tunnel form
- 3 Sismo Building Technology

**Precast Sandwich Panel Systems**

- 4 Advanced Building System – EMMEDUE
- 5 Rapid Panels
- 6 Reinforced EPS Core Panel System
- 7 QuickBuild 3D Panels
- 8 Concrewall Panel System
- 9 Glass Fibre Reinforced Gypsum (GFRG) Panel System

**Light Gauge Steel Structural Systems**

- 10 Light Gauge Steel Framed Structure (LGSFS)
- 11 Light Gauge Steel Framed Structure with Infill Concrete Panels (LGSFS-ICP)

**Steel Structural Systems**

- 12 Factory Made Fast Track Building System
- 13 Speed Floor System

**Precast Concrete Construction Systems**

- 14 Waffle-Crete Building System
- 15 Precast Large Concrete Panel System
- 16 Industrialized 3-S system using cellular light weight concrete slabs & precast columns

One of the crucial component of technology transfer cycle is demonstration construction and therefore, in order to demonstrate these new systems in the field, BMTPC with the support of Ministry of Housing & Urban Poverty Alleviation, Govt. of India has initiated several Demonstration housing projects as pilot projects in different states wherein about 40 houses are being constructed. The land is provided by the state govt. free of cost whereas the houses are constructed along with onsite infrastructure by BMTPC through the financial support extended by Ministry. During the construction, the professionals, students, artisans, policy makers & residents of the area are sensitized & educated about these new technologies. One of the pilot has already been completed at Nellore, AP using GFRG panel systems. The projects at Bhubaneswar, Odisha (using EPS Core Panel system), Bihar Sharif, Bihar (using structural stay-in-place formwork system-Coffor), Lucknow, UP (using double walled EPS Core Panel system), Hyderabad, Telangana (using light gauge steel structural system & Coffor) are currently underway.

The evaluation has been done through Technology Advisory Committee and under Performance Appraisal Certification Scheme (PACS) being operated by BMTPC.

The PACS is a third party assurance system based on laboratory and field tests of the required performance criteria of the any system / building materials on which there is no Indian Standard. The broad parameters, based on which the evaluation is done inter-alia include:

- Structural performance against vertical & lateral loads
- Fire resistance
- Protection against rain & moisture.
- Thermal behaviour
- Acoustic
- Ease of fixing services
- Quality assurance
- Durability

The process flow chart for PACS is given in figure-1. Whereas PACS takes care of verifying technical suitability of the system; other parameters are required to be addressed for proper selection of technology for particular place. A multi attribute evaluation system evolved by BMTPC to provide a technical framework for selection of any new technologies is given in Figure-2. It may be used by agencies for selection of any technology/construction system.

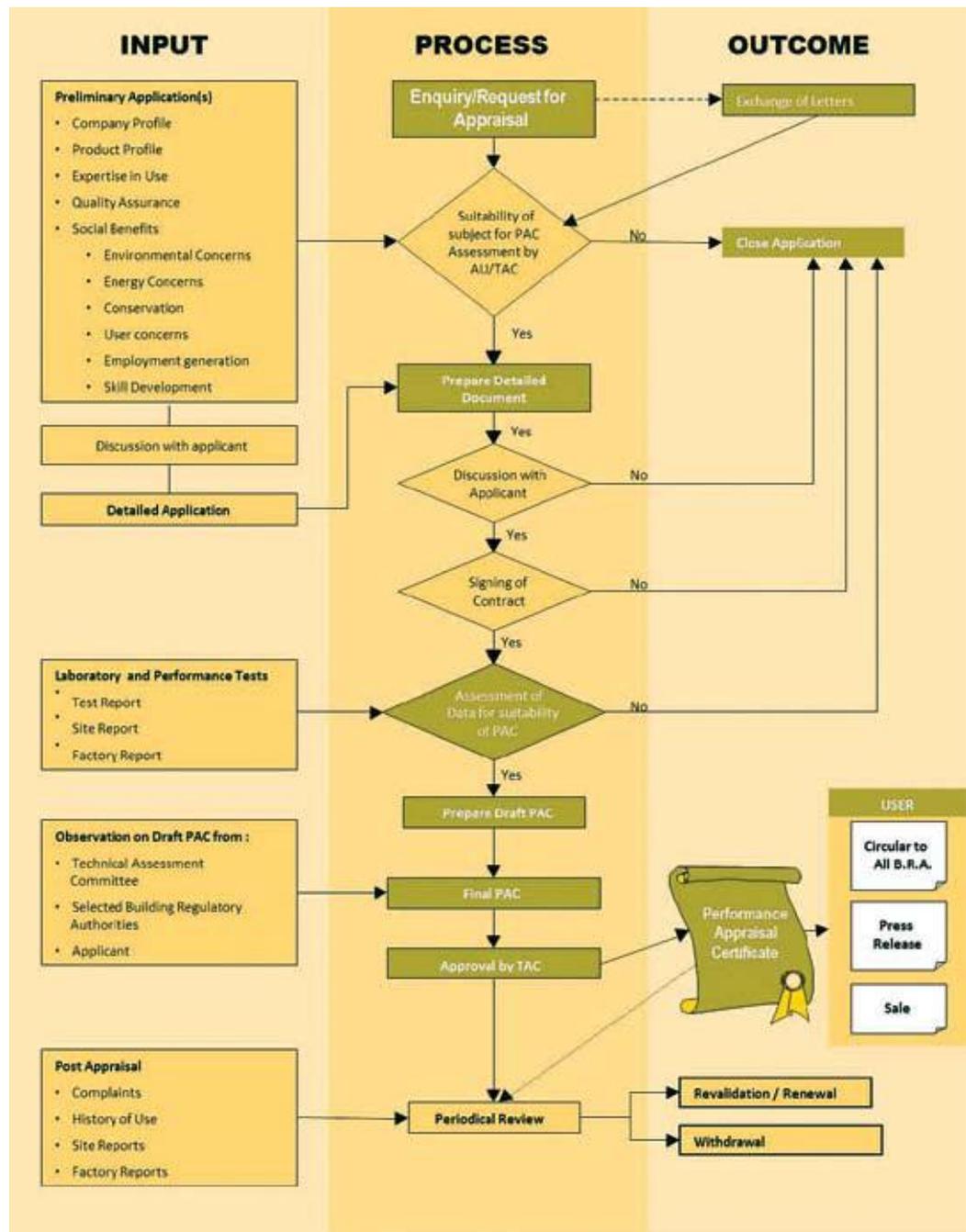


Figure-1: Performance Appraisal Certification System – Process Chart

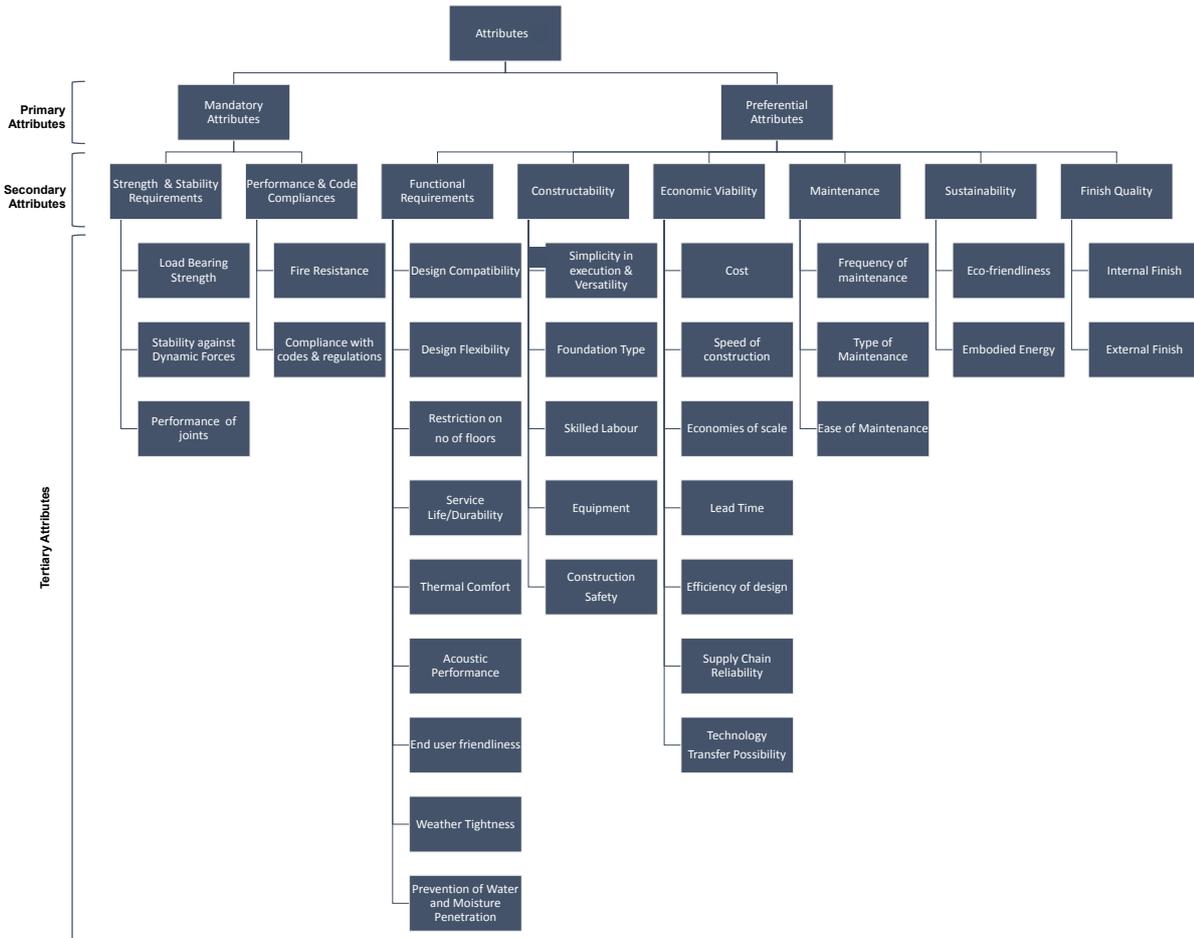


Figure-2: Multi-Attribute Evaluation System for New Technologies

The details of the technologies evaluated and recommended, as contained in this Compendium, will help user agencies in getting informed choice of different innovative construction practices, which could be utilized for mass housing scheme. For any further details regarding technologies, the following may be approached:

1. The Joint Secretary & Mission Director (Housing for All)  
Ministry of Housing & Urban Poverty Alleviation, Government of India  
Room No.116, G-Wing, Nirman Bhawan, New Delhi-110011  
Tel: 011-23061419; Fax: 011-23061420; E-mail: jshfa-mhupa@gov.in
2. The Executive Director,  
Building Materials & Technology Promotion Council,  
Core-5A, 1st Floor, India Habitat Centre, Lodhi Road, New Delhi,  
Tel: 011-24636705; Fax: 011-24642849,  
E-mail: info@bmtpc.org; ska@bmtpc.org

## Formwork Systems





# Monolithic Concrete Construction System – using Plastic - Aluminium Formwork

*(Suitable for Low Rise to High Rise Structures)*

## ABOUT THE TECHNOLOGY

In this system, in place of traditional RCC framed construction of columns and beams; all walls, floors, slabs, columns, beams, stairs, together with door and window openings are cast-in-place monolithically using appropriate grade of concrete in one operation. The specially custom designed modular formwork made up of Aluminium/Plastic/Aluminium-Plastic Composite is used for the purpose which facilitates easy handling with minimum labour & without use of any equipment. Being modular formwork system, it enable fast construction of multiple/mass modular units.

## BASIC MATERIAL REQUIREMENTS

### Formwork system

Formwork system is propriety system and designed as per loading requirements of the structure. It has adequate stiffness to weight ratio, yielding minimum deflection under concrete loading. The panel should fix precisely, securely and require no bracing. Being recent advancement in technology, IS 14687 : 1999 Guidelines for falsework for concrete does not cover requirements of special type of formwork system.

### Concrete

Shall be of appropriate grade based on environment condition as per IS 456:2000

### Reinforcement

Shall conform to IS 1786:2008

## DETAILS OF FORMWORK

The formwork made of Aluminium Extruded Section conforming to IS 733:1983 and PVC of Grade PVC 67G ER01 is in accordance with IS 10151:1982. It consists of different sections including starter of MS Angle, top frame of aluminium channels, wall panels, slab panels & truss.

The formwork is designed based on the structural requirements of building units. A quality control scheme is required to be followed in manufacturing of formwork components.

Under Performance Appraisal Certification Scheme, the present formwork system manufactured by M/s Sintex Industries, Ahmedabad, has been evaluated and certified by BMTPC (PAC No. 1006-A/2011).



## STRUCTURAL REQUIREMENTS OF THE CONSTRUCTION

The Monolithic RCC construction is considered as shear wall system. The maximum spacing between cross wall shall be limited to 1.5 times the floor height if supported on two edges and 2.0 times the floor height, when supported on all four edges.

The walls are designed primarily for loading and also for in-plane lateral load (shear) and out of plane (bending) due to wind load and earthquake forces as per relevant Indian Standard Code IS 875(Pt.3):2015 and IS1893(Pt.1):2002 respectively. For out of plane loading, the plate can be assumed to be supported by floor slabs / diaphragm and cross walls and continuity can be assumed, wherever applicable.

The structural design of plain & RCC shall be as per IS 456:2000 while IS 13920:2016 is referred for ductile detailing of reinforced concrete structure. Thickness of wall below plinth level should be minimum 200 mm with double layers reinforcement.

Guidelines on Monolithic Concrete Construction prepared by BMTPC may be referred for material requirements & design aspects of this system.

## DURABILITY

Since concrete is main constituent material in this system, durability of the structure can be achieved by using proper ingredient, Grade of concrete as per IS 456:2000 and mix design in accordance with IS 10262:2009.

Thickness of the wall is generally 100 mm with the centrally placed reinforcement. Therefore, adequate cover is likely to be maintained, as a result high durability is achieved.

## THERMAL BEHAVIOUR OF STRUCTURE

100 mm thick RCC walls and slab has thermal transmittance ( $U$ ) value as  $3.59 \text{ W/m}^2\text{K}$  (as per IS 3792:1978). As, it is more than the normal plastered brick masonry walls (thermal transmittance ( $U$ )  $2.13 \text{ W/m}^2\text{K}$ ), it is advised that implementing agency shall ensure proper planning for heat insulation and air ventilation in the housing units through proper orientation, shedding etc. (see IS 3792:1978 for guidance).

## ACOUSTIC

Average sound reduction for 100 mm concrete is  $\geq 45\text{db}$  (IS 1950:1962), which refers reasonable acoustic insulation.

## EASE OF FIXING SERVICES

All electric and plumbing fixtures, lines have to be pre-planned and placed appropriately before pouring concrete in RC walls & slabs. Post construction alternation is not desirable.



## ECONOMY OF SCALE

Economies of scale depend upon the volume of work and number of repetition of the formwork. To achieve economy, minimum 100 repetitions are desirable.

For very small project of less than 500 units, this system may not prove to be economical. However, now with number of formwork manufacturers available, the project with less number units may also be feasible.



## OTHER FEATURES

- 1) Pre designed formwork acts as assembly line production and enables rapid construction of multiple/mass scale units of repetitive type.
- 2) Varying work cycle is possible, however, for speed and economy, 3 to 4 days cycle are desirable.
- 3) It is flexible in design and can form any architectural or structural configuration, such as stairs, windows, etc.

## LIMITATION

- 1) A lead time of about 3 months is required for initiation of work, as the formwork are custom designed, manufactured and prototype approved before manufacturing required number of sets of formwork.
- 2) Capital cost to initiate construction is high and may require regular flow of funds.
- 3) Post construction alterations are difficult.
- 4) All the service lines are to be pre-planned in advance.
- 4) Not much saving in construction in one storey structure.

## MAJOR COMPLETED PROJECT

- 1) 5008 houses at Kanjhawala Narela, Delhi for DSIIDC.
- 2) 512 houses in Bawana, Delhi for DSIIDC.
- 3) 3000 houses in Ahmedabad for Ahmedabad Municipal Corporation.
- 4) 3000 houses in Lucknow for Lucknow Development Authority & other projects in major Indian Cities among many others....

## STANDARDS/GUIDELINES REFERRED

IS 456:2000	Code of Practice for plain and reinforced concrete (Fourth Revision)
IS 733 : 1983	Wrought Aluminium and Aluminium Alloy Bars, Rods and Sections (for General Engineering Purposes)
IS 875 (Pt.3):2015	Code of Practice for Design Loads (Other than Earthquake) for Buildings and Structures - Part 3 : Wind Loads
IS 1786:2008	High strength deformed steel bars and wires for concrete reinforcement-
IS 1893 (Pt.1):2002)	Criteria for Earthquake Resistant Design of Structures - Part 1 : General Provisions and Buildings (Fifth Revision)
IS 1950: 1962	Code of practice for sound insulation of non-industrial buildings
IS 3792: 1978	Guide for heat insulation of non-industrial buildings
IS 10151:1982	Polyvinyl Chloride (PVC) and its Copolymers for its Safe Use in Contact with Foodstuffs, Pharmaceuticals and Drinking Water
IS 10262:2009	Concrete Mix Proportioning - Guidelines (First Revision)
IS 13920:2016	Ductile detailing of reinforced concrete structures subjected to seismic forces - Code of practice (First Revision)
IS 14687:1999	Falsework for Concrete Structures - Guidelines
BMTPC Guidelines : 2011	Guidelines on Monolithic Concrete Construction
PAC No. 1006-A/2011	Performance Appraisal Certificate issued by BMTPC on Formwork for Monolithic Construction

# Monolithic Concrete Construction System – using Aluminium Formwork

*(Suitable for Low Rise to High Rise Structures)*

## ABOUT THE TECHNOLOGY

In this system, in place of traditional RCC framed construction of columns and beams; all walls, floors, slabs, columns, beams, stairs, together with door and window openings are cast-in-place monolithically using appropriate grade of concrete in one operation. The specially custom designed modular formwork made up of Aluminium/Plastic/Aluminium-Plastic Composite is easy to handle with minimum labour & without use of any equipment. Being modular formwork system, it facilitates in rapid construction of multiple/mass modular units.

## BASIC MATERIAL REQUIREMENTS

### Formwork system

Formwork system is propriety system and designed as per loading requirements of the structure. It has adequate stiffness to weight ratio, yielding minimum deflection under concrete loading. The panel should fix precisely, securely and require no bracing. Being recent advancement in technology, IS 14687 : 1999 Guidelines for falsework for concrete does not cover requirements of special type of formwork system.

### Concrete

Shall be of appropriate grade based on environment condition as per IS 456:2000

### Reinforcement

Shall conform to IS 1786:2008

## DETAILS OF FORMWORK

The formwork systems used are made of light weight Aluminium. The recommended concrete forms generally use robotics welding system for manufacturing. A soft alloy weld wire is utilized in the concrete form weld process. Fixing of the formwork is done using tie, pin & wedges system. Does not require very skilled labour to do the job.

The formwork can be designed based on requirements of dwelling unit and the project. A repetition of about 1000 cycle is claimed (This, however, needs, verification).

## STRUCTURAL REQUIREMENTS OF THE CONSTRUCTION

The Monolithic RCC construction is considered as shear wall system. The maximum spacing between cross wall shall be limited to 1.5 times the floor height if supported on two edges and 2.0 times the floor height, when supported on all four edges.

The walls are designed primarily for loading and also for in-plane lateral load (shear) and out of plane (bending) due to wind load and



earthquake forces as per relevant Indian Standard Code IS 875(Pt.3):2015 and IS1893(Pt.1):2002 respectively. For out of plane loading, the plate can be assumed to be supported by floor slabs / diaphragm and cross walls and continuity can be assumed, wherever applicable.

The structural design of plain & RCC shall be as per IS 456:2000 while IS 13920:2016 is referred for ductile detailing of reinforced concrete structure. Thickness of wall below plinth level should be minimum 200 mm with double layers reinforcement.

Guidelines on Monolithic Concrete Construction prepared by BMTPC may be referred for material requirements & design aspects of this system.

### **DURABILITY**

Since concrete is main constituent material in this system, durability of the structure can be achieved by using proper ingredient, Grade of concrete as per IS 456:2000 and mix design in accordance with IS 10262:2009.

Thickness of the wall is generally 100 mm with the centrally placed reinforcement. Therefore, adequate cover is likely to be maintained, as a result high durability is achieved.



### **THERMAL BEHAVIOUR OF STRUCTURE**

100 mm thick RCC walls and slab has thermal transmittance ( $U$ ) value as  $3.59 \text{ W/m}^2\text{K}$  (as per IS 3792:1978). As, it is more than the normal plastered brick masonry walls (thermal transmittance ( $U$ )  $2.13 \text{ W/m}^2\text{K}$ ), it is advised that implementing agency shall ensure proper planning for heat insulation and air ventilation in the housing units through proper orientation, shedding etc. (see IS 3792:1978 for guidance).

### **ACOUSTIC**

Average sound reduction for 100 mm concrete is  $\geq 45\text{db}$  (IS 1950:1962), which refers reasonable acoustic insulation.



### **EASE OF FIXING SERVICES**

All electric and plumbing fixtures, lines have to be pre-planned and placed appropriately before pouring concrete in RC walls & slabs. Post construction alternation is not desirable.

### **ECONOMY OF SCALE**

Economies of scale depend upon the volume of work and number of repetition of the formwork. To achieve economy, minimum 100 repetitions are desirable.

For very small project of less than 500 units, this system may not prove to be economical. However, now with number of formwork manufacturers available, the project with less number units may also be feasible.

For very small project of less than 500 units, this system may not prove to be economical.



## OTHER FEATURES

- 1) Pre designed formwork acts as assembly line production and enables rapid construction of multiple/mass scale units of repetitive type.
- 2) Varying work cycle is possible, however, for speed and economy 3-4 days cycle are desirable.
- 3) It is flexible in design and can form any architectural or structural configuration, such as stairs, windows, etc.

## LIMITATION

- 1) A lead time of about 3 months is required for initiation of work, as the formwork are custom designed, manufactured and prototype approved before manufacturing required number of sets of formwork.
- 2) Capital cost to initiate construction is high and may require regular flow of funds.
- 3) Post construction alterations are difficult.
- 4) All the service lines are to be pre-planned in advance.
- 4) Not much saving in construction in one storey structure.

## MAJOR COMPLETED PROJECT

- 1) Houses in Bangalore for Karnataka Slum Development Board.
- 2) Houses in Mysore for Karnataka Slum Development Board.
- 3) Houses in Bangalore for Bangalore Development Authority & several other projects in major cities of India, among many others...

## STANDARDS/GUIDELINES REFERRED

IS 456:2000	Code of Practice for plain and reinforced concrete (fourth revision)
IS 733 : 1983	Wrought Aluminium and Aluminium Alloy Bars, Rods and Sections (for General Engineering Purposes)
IS 875 (Pt.3):2015	Code of Practice for Design Loads (Other than Earthquake) for Buildings and Structures - Part 3 : Wind Loads
IS 1786:2008	High strength deformed steel bars and wires for concrete reinforcement-
IS 1893 (Pt.1):2002)	Criteria for Earthquake Resistant Design of Structures - Part 1 : General Provisions and Buildings
IS 1950: 1962	Code of practice for sound insulation of non-industrial buildings
IS 3792: 1978	Guide for heat insulation of non-industrial buildings
IS 10151:1982	Polyvinyl Chloride (PVC) and its Copolymers for its Safe Use in Contact with Foodstuffs, Pharmaceuticals and Drinking Water
IS 10262:2009	Concrete Mix Proportioning - Guidelines
IS 13920 : 2016	Ductile detailing of reinforced concrete structures subjected to seismic forces - Code of practice
IS 14687:1999	Guidelines for Falsework for Concrete Structures
BMTPC Guidelines : 2011	Guidelines on Monolithic Concrete Construction
PAC No. 1006-A/2011	Performance Appraisal Certificate issued by BMTPC on Formwork for Monolithic Construction



# Modular Tunnelform

*(Suitable for Low Rise to High Rise Structures)*

## ABOUT THE TECHNOLOGY

Tunnel formwork is a mechanized system for cellular structures. It is based on two half shells which are placed together to form a room or cell. Several cells make an apartment. With tunnel forms, walls and slab are cast in a single day. The structure is divided into phases. Each phase consists of a section of the structure that will cast in one day. The phasing is determined by the program and the amount of floor area that can be poured in one day. The formwork is set up for the day's pour in the morning. The reinforcement and services are positioned and concrete is poured in the afternoon. Once reinforcement is placed, concrete for walls and slabs shall be poured in one single operation. The formwork is stripped the early morning next day and positioned for the subsequent phase.



The formwork is manufactured in a fully automated plant. Presently, it is imported from France and there is no plant in India.

The on-site implementation of 24 hour cycle is divided into following operations.

1. Stripping of the formwork from the previous day.
2. Positioning of the formwork for the current day's phase, with the installation of mechanical, electrical and plumbing services.
3. Installation of reinforcement in the walls and slabs.
4. Concreting and if necessary, the heating equipment.

## TYPES OF FORMWORK SYSTEM

### ***TMPH Modular Tunnelform***

Tunnel forms are room size formworks that allow walls and floors to be cast in a single pour. With multiple forms, the entire floor of a building can be done in a single pour. Tunnel forms require sufficient space exterior to the building for the entire form to be slipped out and lifted up to the next level.

This Tunnelform consists of inverted L-shaped half tunnels (one vertical panel and one horizontal panel) joined together to create a tunnel. Articulated struts brace the horizontal and vertical panels. These struts enable the adjustment of the horizontal level of the slab and simplify the stripping of the formwork. The vertical panel is equipped with adjustable jacking devices and a triangular stability system. Both devices are on wheels.

A range of spans is possible by altering the additional horizontal infill panel's dimensions. Due to the distribution of the horizontal beams on the vertical plank, the formwork also cast staggers and offsets in the layout of the walls as well as differing wall thicknesses. The half-tunnels shall be equipped with back panels to cast perpendicular shear walls or corridor walls. Assembly and levelling devices ensure that the formwork surfaces are completely plumbed and levelled.

**Standard Characteristics**

Standard dimensions: TMPH & Modular  
 Unit width : 2.40 m to 6.00 m  
 Type 1 horizontal panel : 1.20 m to 1.60 m  
 Type 2 horizontal panel: 1.80 m to 2.40 m  
 Type 3 horizontal panel: 2.40 m to 3.00 m  
 Span which can be adjusted by fitting an additional panel measuring between 0.05 and 0.60 m  
 Package length: Up to 12.50 m in length as a function of the hoisting facilities and availability  
 Basic length: 1.25 m  
 Average weight: 90 Kg/m<sup>2</sup>  
 Handling: Lifting triangle or sling  
 Transportation: 180 m<sup>2</sup> per truckload.

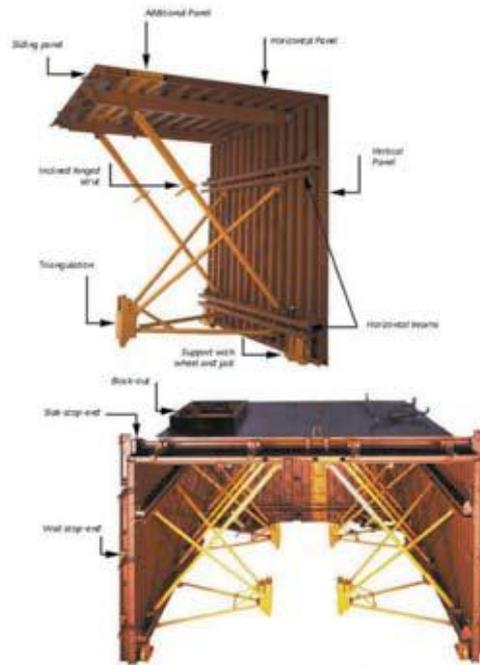
**Wallforms**

Wallforms are temporary moulds in which concrete is poured in order to build a structure. Once the concrete is poured into the formwork and has set, the formwork is stripped to expose perfect finished concrete. These forms constitute a system approach for construction and are particularly suited to build structural walls, columns, bridge piers, culverts etc. This system adopts well to daily work-phase of both repetitive and non-repetitive tasks. The equipment used each day is productive and is reused in subsequent phases. The four daily operations which outlines the daily production cycle for wall form equipment are identical to those for Tunnel form equipment with the exception that it is solely used for casting concrete walls. The slabs are cast as a secondary phase. The existing equipment can be adapted on a day-to-day basis by the addition of standard elements and corner-wall formwork to take into account different wall configurations on site. All safety and stability devices shall be fully integrated into the standard version of Wallform equipment.

**B 8000 Wallforms**

These Wallforms are tools specially designed to be used on specific buildings and structures. This vertical wallform panel is a multi-purpose formwork system. This system has been designed and developed to ensure that it is simple and quick to assemble and position the following:

- A full range of standard dimensioned components
- Multiple combination of panels for simple adoption to specific configurations
- Basic standard equipment incorporates complete safety, circulation and stability equipment
- Caliper–device opposing Wallform packages are craned into position in one lift.



### **Standard characteristics**

#### *Standard dimensions:*

Standard height: 2.80 m

Upper extension: 0.50 m

Lower extension: 1.00 m-1.50 m

Average weight: 135 Kg/m<sup>2</sup>

Assembly: 0.80 H/m<sup>2</sup> of formwork

Use: 0.15 to 0.30 H/m<sup>2</sup> of formwork, depending on complexity

Wind stability: by prop

Access: inner ladder accessed via hatch

Superposition: up to 22.5 m with specific engineering performed to determine hoisting and stability characteristics

Transportation: 24 wall forms per container/ truckload

### **Angle Formwork**

Inner and outer angle configurations are designed to attach to 1.25 m wall forms to obtain a 160 mm wall. Spacers shall be installed for producing wall thicknesses.

### **Back Panel**

The back panel allows pouring of cross walls, other walls, walls and slab in one operation.

### **Slab Stop End and Wall stop**

These can be adjusted to fit the lengths of wall and slabs. These remain fixed to the form during all handling operations.

### **Kicker Form**

In order to guide the walls of the upper floor precisely above the walls of the floor below, a kicker form is fixed to the tunnel form before pouring the concrete. Slab and starting walls are then poured during the same phase.

### **Box Out**

During each phase, window box out, door box out and slab box out are mounted on the tunnel using a magnetized system.

## **MATERIAL REQUIREMENTS**

- i. Hot dip galvanized steel sheet – 3 mm thick shall conform to IS 277:2003
- ii. Steel for Angle section – 80 mm x 80 mm x 6 mm shall conform to IS 2062:2011
- iii. Cold rolled U-sections – 60 mm x 30 mm shall conform to IS 2062:2011.

### **Mechanical properties:**

Yield stress :  $\geq 23.5$  daN/mm<sup>2</sup>

Breaking load :  $\geq 36$  daN/mm<sup>2</sup>

Elongation :  $\geq 20\%$

Steel for spacer pins – Apart from the requirements given above, the steel used for the manufacture of the spacer pins, the gripping mechanisms, anchoring points for the rear stabilizing and adjusting mechanisms shall guarantee a KCV resilience at  $-20^{\circ}\text{C}$  of at least 28J.

## **CHARACTERISTICS OF THE SYSTEM**

- Maximum span between walls shall be 5.60 m without accessory units and 7.00 m with accessory units.
- Height of the formwork – The forms are designed for floor to ceiling height of 2.51 m minimum with the

possibility to increase this by action of the leg jacks or with the use of movable panels in the event of extra heights.

- Appearances of the faces after form removal – The surfaces obtained allow direct application of finishing paint or wallpaper after sanding off the fins at the joints connecting the units and smoothing with paint filler.
- Working rhythm using the system – Under average temperature conditions, with the use of ordinary cement, the normal rhythm is two days per cycle with one day and two nights for drying and setting of the concrete.
- Time period required for execution of the process – The time required for execution shall vary according to the cell plan. For a type cell consisting of two formed wall surfaces and a floor surface, the average time is less than one & one half hours per square meter of building. This time includes the form removal, oiling, displacement of the units, formwork and adjustment.

## UTILIZATION OF THE FORMWORK SYSTEM

At each stage, utilization of the system requires the following successive operations:

- i. The placing of the vertical wall reinforcement of the floor and possibly the door frames provided for in the erection drawing;
- ii. Dismantling of the movable form units of the preceding storey. This shall be carried out in two stages:
  - a) Loosening of the normal units (half-shells), by removal of the spacers passing through the walls, by unlocking the tunnel keys and disassembly of the sections. This work is executed in principle by two non-specializes maneuvers.
  - b) Striking and removal of the forms. This shall be carried out by using the special dolly and two maneuvers in the tunnel and by two other maneuvers at the new location (usually on the storey above). This suite of operations shall be carried out by bringing the dolly under the half-shell to be removed and then working the different jacks for the striking operation itself. The leg jacks are lifted first, then a slight deformation of the half-shell is provoked by working the diagonal bracing jacks (shortening). This deformation is sufficient to strip the form progressively. It drops down automatically onto the dolly. The dolly half-shell assembly shall then be rolled across the service platform where the form is cleaned and oiled with a sprayer, then picked up with a crane and hoisted to its new location site, the dolly remaining in place. The half-shell design makes it possible to remove the whole side of a tunnel, then to prop the slab near the key before removing the other half, permitting if necessary, a faster rotation of the equipment.
- iii) Reassembly of the units on the floor above. This assembly consists of the following operations:
  - a) A half-shell shall be positioned on its leg jacks and knee brace, and adjustment shall be squared by blocking the diagonal bracing jacks, then adjustment of the height and plumb by working the leg jacks and the knee brace jack.
  - b) The half-shells shall be assembled together.
  - c) The opposite half-shells shall be positioned, and adjacent half-shells of the 'tunnel' half-shells shall also be positioned using the same procedure.
  - d) The half-shells shall be blocked by constituting the two faces of the wall on the 'starters' with the help of the lower spacers; the upper spacers shall be tightened without being forced, only after verification of the general adjustment; positioning of the butt end forms of the walls and floors.
  - e) The key-locks solidifying the opposite half-shells shall be positioned and blocked. If necessary, a light action on the knee brace and diagonal bracing jacks shall be used to bring the locking units into line.
  - f) The starter forms shall be positioned and blockouts, if necessary for anticipated door and window frames.
  - g) The overall adjustment and finish making-up shall be verified, if necessary, after lifting of the knee braces.
  - h) The suspended floor shall be reinforced and concrete shall be poured in the walls and slab.
- iv) The service platform shall be removed and this platform shall be installed on the storey above.

## APPLICATIONS

Designed to cast concrete load-bearing walls and slabs in a single monolithic pour, tunnel forms are suited for the construction of following structures:

- Multiple residential dwellings
- Housing projects
- Garden apartments
- Town homes
- Condomiums
- Hotels etc.

## SPECIAL FEATURES

### ***Behavior in earthquake***

Formwork shall be designed to meet the requirement of permanent structures using specified Indian Standards for material used. The design should take into account the conditions of materials to be actually used for the formwork, environment, site condition loads on formwork and combination of loads shall be taken in accordance with the clause 7.3 of IS 14687:1999.

### ***Behavior under high winds***

The design for wind loads shall be in accordance with the provisions given in IS 875 (Part 3):2015 and IS 14687:1999.

### ***Productive***

The equipment used each day is productive and is reused in subsequent phases.

### ***Day-to-day basis***

The existing equipment can be adapted on a day-to-day basis by the addition of standard elements and corner-wall formwork to take into account different wall configurations on site.

## LIMITATIONS

- The floor spans executed with movable forms shall not be more than 5.60 m, unless accessory units are used.
- The thickness of vertical in-situ walls shall not be more than 120 mm, unless justified by special provisions.

## MAJOR WORKS COMPLETED USING THE FORMWORK

- Apartments by M/s Runwal Group at Mumbai in 2000
- Apartments complexes by M/s B G Shirke Construction Technology Pvt. Ltd., Pune at Navi Mumbai, and Tirupati in 2001
- Apartments by M/s L&T South City Projects Ltd., at Chennai in 2008
- Slum Rehabilitation by M/s Pawar Patkar Construction Pvt. Ltd., at Nasik in 2014

## CERTIFICATION

Performance Appraisal Certificate No. 1018-S/2015 issued to M/s Outinord Formworks Pvt. Ltd., Pune by BMTPC.

## STANDARDS/REFERENCES

- Agreement No. 2569 relating to New Materials and Non-traditional Construction Processes between Cashiers of the C.S.T.B, Paris, France and Outinord, Company, S.A given in Annex I.
- Case studies of the projects carried out by various agencies throughout the world including India using Outinord Formwork.

- Design of the Formwork submitted by the manufacturer
- Quality Management Manual and Maintenance Manual followed by the manufacturer
- Application of accelerated curing to Apartment Formwork System – Advisory Note from British Cement Corporation
- IS 277:2003 – Specifications for plain and corrugated galvanized steel sheets (sixth revision)
- IS 456:2000 – Code of practice for plain and reinforced concrete (fourth revision)
- IS 875 (Part 3):2015 – Code of Practice for Design Loads (Other than Earthquake) for Buildings and Structures - Part 3 : Wind Loads
- IS 2062:1999 – Hot rolled medium and high tensile structural steel
- IS 14687:1999 – Falsework for concrete structures

# Sismo Building Technology

(Suitable for Low Rise to High Rise Structures)

## ABOUT THE TECHNOLOGY

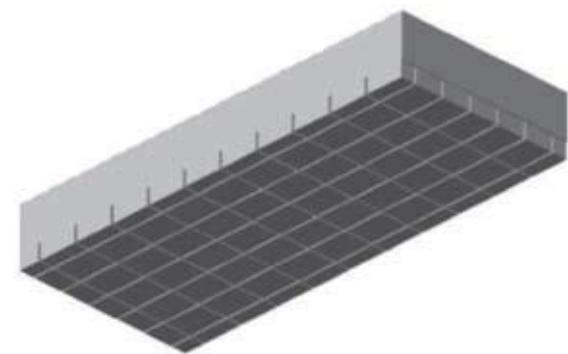
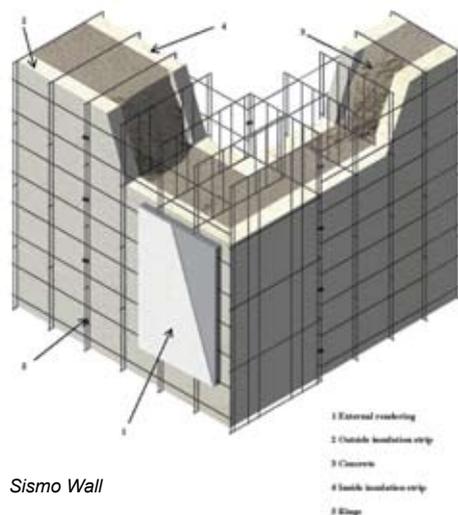
Sismo Building Technology is an insulating shuttering kit for whole building based on a three-dimensional lattice made of galvanized steel wire. The lattice is filled with materials of different nature to serve as formwork. The basic structure of the Sismo building module is steel wire lattice. At the exterior sides of the lattice, infill panels are inserted, which transform the lattice into a closed structure that can be filled with concrete. The type of infill panels used depends on the purpose of the wall: load bearing or not, insulated or otherwise, etc. The steel wire also acts as armature and anchoring for the finished material and it holds reinforcement bars in place during concrete filling.



This technology was initially developed in Belgium and the firm in India has a collaboration with n. v. Desmo-Home "Sismo" Ltd., Belgium.

Description of the components is as follows:

- 3D lattice (2.2 mm Ø galvanized steel wire)
- Infill panels (EPS, rock wool, mineral board)
- Structural filler (concrete)
- Finishing (plastering, natural stone, paneling etc.)



One-way girder-slab floor

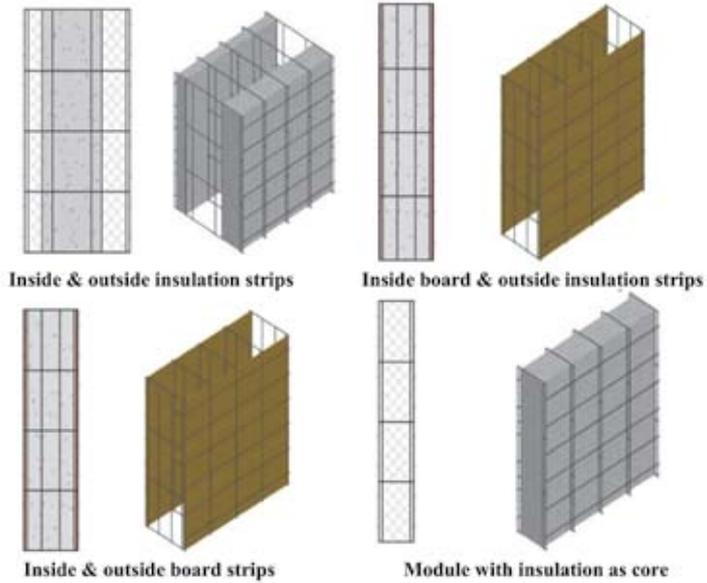
## MODULES

### Type of Modules

Depending on the internal and external material, the walls may be divided into following types:

- Inside & outside insulation (EPS) strips symmetrical and asymmetrical
- Inside board and outside insulation (EPS) strips
- Inside & outside board strips

- (iv) Inside & outside insulation strips
- (v) 2 Sismo walls decoupled and insulated for an optimized acoustic performance. This type is typically used as separating wall between apartment and houses.
- (vi) Module with insulation strips as core material Sismo floors and roofs may be plain, one and two-way slabs; as per requirement.



## DESCRIPTION OF THE COMPONENTS

### Steel Lattice

The steel wire frame, formwork for the walls, are available in panels of different dimensions as follows:

- Height: in multiples of 150 mm, with a max. of 12 m
- Length: in multiples of 100 mm, with a max. of 1.2 m
- Thickness: Max. 500 mm, depending on the type of wall /roof required

### Functions of steel lattice

The steel wire lattice has the following basic functions:

- (i) To resist hydraulic pressure of fresh concrete during pouring and first hours of hardening
- (ii) To keep reinforcement bars in place during pouring of concrete
- (iii) To ensure adhesion (and reinforcement) of finishing when using mineral based renders

### Insulation strips and Interjoists

The insulation strips have following functions:

- Maintain fresh concrete during the provisional phase of pouring
- Thermal insulation in final phase
- Support of interior and exterior finishing

The strips have fixed dimensions and shall be fixed with tongue and groove: 15 mm x 20 mm for EPS strips of thickness 38 mm to 118 mm and 10 mm x 15 mm (h x w) for other strips of thickness 38 mm.

The interjoists have following functions:

- Creation of ribs in order to have a one or two-way girder-slab floor
- Thermal insulation in final phase

The interjoists have fixed dimensions (length 1200 mm & width 450 mm) but may be cut in length in multiples of 100 mm and width in multiples of 150 mm. These shall be available in various thicknesses from 100 mm to 350 mm. These shall have a 'waffle' structure (100 mm x 75 mm) and the groove has depth of 30 mm and a width of 10 mm. Their shape ensures a good grip on the metal frame of the floor modules.

The details of one-way girder-slab floor are as follows:

- The center to center distance between the ribs is in multiples of 150 mm
- The width of the ribs is 150 mm or in multiples thereof.

The details of two-way girder-slab floor are as follows:

- The center to center distance between the ribs is in multiples of 150 mm on one side and 10cm on the other side
- The width of the ribs is 150 mm or in multiples thereof on one side and 100 mm on the other side.

### **MATERIAL REQUIREMENTS**

Hot galvanized steel wire shall conform to the specifications as given below:

- Zinc coating shall not be less than 60 g/m<sup>2</sup>
- The dia. of the wires and rings shall be 2.2 mm ± 0.03 mm.
- Tensile strength: 680 N/mm<sup>2</sup> min.
- Chemical composition: C = 0.020 % min., Mn = 0.150 % min,  
Si = 0.250% max., P = 0.030 % max., S = 0.030 % max.

*Rings:* Rings shall be used to hold the panels together during installation phase.

#### ***Insulation strips and panels:***

- Expanded polystyrene (EPS): shall conform to IS 4671:1984 and shall have density not less than 15 kg/m<sup>3</sup>.
- Fibre cement board (FCB) 5 mm thick: shall conform to IS 14862:2000.

*Cast-in-place concrete:* The ingredients, grade of concrete & slump for walls, floors and roofs shall be used as per IS 456:2000.

### **APPLICATIONS**

The technology shall be used for construction of structures consisting of load bearing walls, foundations, cellars, floors and roof etc. for residential, commercial and industrial purposes.

### **PRODUCTION PROCESS**

The production of the modules is carried out in the Sismo Production Station (SPS). The main stages of production include:

- Unwinding of steel wire rolls
- Cutting and straightening of steel wire
- Assembly and welding of two-dimensional lattices
- Assembly and welding of three-dimensional lattices
- Cutting of insulation strips and interjoists
- Insertion of the insulation strips into three-dimensional lattice at the lateral intervals intended for this purpose.

The fixing of the panels and placing of interjoists on respective walls and floors is done at site. Panels are installed after hardening of concrete.

The production is carried out according to an internal factory production control plan.

Conformity checks are done on incoming materials and at regular stages throughout the production sequence to ensure the fitness of the components.

#### **Accessories**

The accessories required for erection of the walls in construction site shall be as follows:

- *Struts:* to support the panels during installation and pouring of concrete (max. distance of 2 m between two panels).
- *Strut for stanchion:* to support stanchion for guard rail and used to align and support the top of panels at floor level during installation and pouring of concrete.

- *Hollow profiles*: to support the panels during installation and pouring of concrete (max. distance of 2 m between two panels).
- *U-profiles*: to connect the hollow profiles with horizontal steel wire supporting the panels during pouring of concrete.
- *Stapler & Rings*: to connect the panels (7 rings per linear meter, on each side of the wall, back and front).
- *Lop ties and Tie twister*: to secure the reinforcement bars to the metal frame.
- *Cutter*: to cut the steel wire at the openings (doors, ceilings etc.) after hardening of the concrete.
- *Boards*: (30 mm/120 mm) for proper alignment of the walls.
- *Props and Shuttering boards (e.g. CFB)*: as support for floors to spread the concentrated loads of the vertical props. The number of vertical props may be reducing by using load spread beams.

## IMPLEMENTATION

### **Handling, transportation and storage of panels**

- The handling of panels on site shall be done with gloves and protective glasses as they have sharp points.
- Loading and unloading of modules shall be done either manually or by machine.
- The modules shall be transported and stored sideways, standing or in a horizontal position. When stored and transported in horizontal position, extra care should be taken to limit stress because bottom panels of a pile horizontal staked modules have a higher risk of deformation.

### **Erection of Panels**

- The panels shall be placed on the foundation or on the floors. They shall be held together by rings longitudinally placed every 150 mm on both sides of the wall.
- In the initial phase, the panels shall be supported on one of their sides by struts specially developed for this purpose. They shall provide lateral support to the panels till hardening of the concrete. The maximum distance between lateral supports should not exceed 2 m. It should be possible to transform the struts to scaffolding to allow access at the top of the casing to monitor pouring of the concrete.
- The free end of the panels (in case of openings, windows, doors or ceilings) shall be closed in the same manner as the common parts to ensure holding of fresh concrete.
- The verticality of the walls shall be checked before and during casting.
- The floor modules shall be temporarily, till hardening of the concrete, be supported by shuttering panels, beams and props. When props are only calculated for supporting the weight of fresh concrete, circulation and curing platform shall be used.

### **Placing of reinforcement**

- The modulated dimensions of the lattice shall be 100 mm horizontally and 150 mm vertically and in multiples thereof. The securing of the bars through the lattice, shall ensure a correct positioning of the reinforcement after pouring of concrete.
- Stirrups, straight, L and U shaped bars shall be placed during mounting of the modules. The lattice should not be combined with welded reinforcement mesh.
- The placing of vertical bars shall be done through the top of panels and shall progress together with the mounting of the panels.
- Horizontal bars for ties, lintels etc. shall be inserted sideways and progresses together with the mounting of the walls. It is sometimes required to remove the insulating strips used as formwork at the edge of the panels to be able to insert the horizontal reinforcement bars and then slide them back into position.
- Length of U-shaped horizontal bars used shall be 1 m for straight length and 300 mm for bend portion, wherever required.

#### **i. Corner –connection**

- U-shaped horizontal reinforced bars
- U-shaped horizontal reinforced bars in the second wall
- Common vertical reinforced bars

**ii. T-connection**

- U-shaped horizontal reinforced bars in the wall to join
- Installation of the wall in T-connection
- Horizontal reinforced bars of a wall
- Common vertical reinforced bars

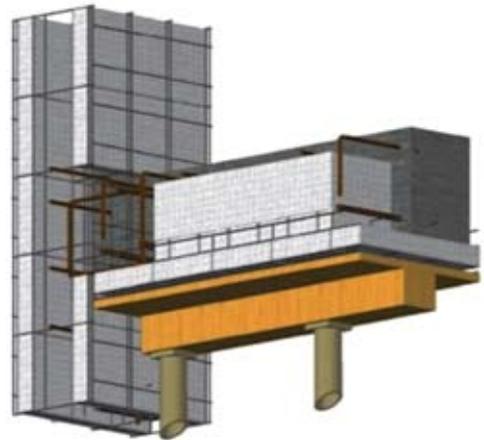
**iii. Beam**

- Vertical stirrups
- Horizontal reinforced bars

**iv. Wall-floor connection**

**v. Starter bars**

**vi. Floor**



**Pouring of concrete**

The pouring of concrete shall be done with a pump device or a tipper. The following requirements shall be adhered to:

- The speed of concrete filling shall be limited to 1000 mm per hour. Concrete is filled in layers up to 500 mm and shall be filled up to a maximum height of 6 m in a day.
- If filling is done with a pump device, suitable measures should be taken to cut the dynamic pressure of concrete. A flexible rubber sleeve is secured with retaining rings to the pipe of the pump device in order to limit the pressure of concrete by compressing the hose manually.

In order to ensure the geometrical and mechanical properties of the finished wall, the following checks are carried out during concrete filling:

- Control and possible correction of verticality of the wall before hardening of concrete
- Visual verification of penetration of cement of the cement laitance in joints between the strips so that all gaps are completely filled. Cores shall be taken through the insulation at critical positions, such as below windows and at corners, to establish integrity of concrete.

Roofs with pitch below and over 30° shall be constructed with open and closed lattices respectively.

Insulating strips shall be cleaned with a water jet or brushed after pouring of concrete to remove light leakage of laitance.

**Finishing**

**Rendering**

As there are significant regional differences due to availability of local materials and climatic conditions, the recommendations of the manufacturer of the material should generally be followed and good trade practice regarding installation and sealing should be observed. Renders should contact the local supplier to ascertain the product best suited for finishing of the modules.



**Imbedding of ducts**

- In self-extinguishing polystyrene panel conduits path shall be made.
- When thin hard panels are used for shuttering, conduits may either be surface mounted or inserted before the concrete is poured.
- Alternatively, polystyrene strips may be inserted allowing the conduits to be installed at a later stage.

**Fixing of objects**

- It is possible to fix objects up to 80 kg per fixing device in the insulation strips.
- For other cases, the fixing devices should be inserted in the concrete.

**SPECIAL FEATURES****Structural Stability**

The technology used is to exploit concrete to the ultimate and standard solutions for reinforcement are used, wherever required. Reinforcement, shall be placed according to the specifications, depending on the application and shall be determined by structural calculations performed according to the IS 456:2000. In seismic prone areas requiring seismic resistant construction, relevant provisions of IS 1893 (Part 1):2002, IS 4326:2013 and IS 13920:2016 shall apply.

**Durability**

The modules provide maximum strength during concrete placement. Once complete, structures reach an incredible structural integrity. When concrete is hardened, durability of steel wire is necessary in only those applications where the adhesion of finishing depends on it, in addition to the adhesion between concrete and insulation and between insulation and rendering.

**Behavior in earthquake**

The structure can be made earthquake resistant by applying provisions of IS 1893 and IS 13920.

**Fire Safety**

The assembled system is a continuous monolithic concrete system, thus without fire leakage through the assembled system. The required rating is achieved with proper thickness of concrete and polystyrene/other strips.

**Thermal Performance**

Depending on the climate, a variety of infill materials that completely and permanently insulate the building without thermal bridges, can be chosen

**Behavior in wind/hurricane**

A Sismo building is extremely resistant to the complex strains and thrusts due to the force emitted by wind, hurricanes and cyclones.

**Light weight**

Sismo modules weigh between 2 & 7 kg, eliminating the need for heavy and expensive building equipment on site. These can easily be handled and assembled manually.



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### **Fast implementation**

The time required to raise buildings using this technology is significantly shorter than any conventional building method.

### **MAJOR WORKS COMPLETED**

Sismo Building Technology, Belgium has constructed numerous residential and utility projects mostly in Belgium, France, Portugal, Italy, Turkey, Korea and Middle East etc. The Indian firm is constructing about 70 (G to G+2) housing units at Kashipur (Uttarakhand) by using this technology. The project is likely to be completed by 2017. Police Barracks (2500 sqft.) has been constructed at Siliguri. A project of construction of District Magistrate Office (7000 sqft.) at Cooch Behar, West Bengal is under progress.

### **CERTIFICATION**

Performance Appraisal Certificate No. 1025-S/2016 issued to M/s M K S Infosolutions Pvt. Ltd., Manesar (Haryana) by BMTPC.

### **STANDARDS/REFERENCES**

- European Assessment Technical Regulation
- Sismo technology: Plain concrete in high rise buildings by Sismo Engineering, Belgium
- Guideline for European Technical Approval of 'Non-load bearing permanent shuttering systems based on hollow blocks or panels of insulating materials' by EOTA, Brussels, Belgium
- Experimental Research in 92-93 & 93-94 by Sismo Engineering & CE Deptt., University of Leunen, Belgium
- IS 456:2000 – Code of practice for plain and reinforced concrete
- IS 875 (Parts 1,2, 4 & 5) :1987 – Code of Practice for Design Loads (other than earthquake) for Buildings & Structures (Part 3 : 2015)
- IS 1893 (Part 1):2002 – Criteria for Earthquake Resistant Design of Structure
- IS 4326:2013 – Code of Practice for Earthquake Resistant Design and Construction of Buildings
- IS 4671:1984 – Specifications for expanded polystyrene for thermal insulation purposes
- IS 14862:2000 – Fibre cement flat sheets - Specification





## Precast Sandwich Panel Systems



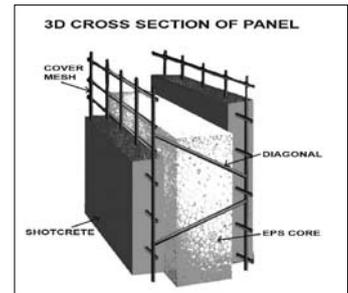


# Advanced Building System - EMMEDUE

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

Expanded Polystyrene (EPS) Core Panel System is based on factory made panels, consisting of self extinguishing expanded polystyrene sheet (generally corrugated) with minimum density of 15 Kg/m<sup>3</sup>, thickness not less than 60 mm, sandwiched between two engineered sheet of welded wire fabric mesh, made of high strength galvanized wire of 2.5 mm to 3 mm dia. A 3 mm to 4 mm dia galvanized steel truss wire is pierced completely through the polystyrene core at the offset angle for superior strength and welded to each of the outer layer sheet of steel welded wire fabric mesh. The panels are finished at the site using minimum 30 mm thick shotcrete of cement & coarse sand in the ratio of 1:4 applied under pressure. (Refer sectional details as shown). The shotcrete coat encases the EPS Core with centrally placed steel welded wire fabric mesh.



The technology (developed about 30 years back) has been successfully used in many countries like Morocco, Algeria, South Africa, Kenya, Austria, Malasiya, Ireland, Romania & Australia with involvement of different agencies and brand names.



## PANEL TYPES

The Panels being manufactured are of different types depending upon the application. The details of different types of typical panels are given below:

### Single Panel for structural uses

<b>Longitudinal wire</b>	2.5 mm / 3.5 mm ø spaced @ 65 mm	
<b>Transverse Wire</b>	2.5 mm ø spaced @ 65 mm	
<b>Cross Steel Wire</b>	3.0 mm ø approx 68 nos. / m <sup>2</sup>	
<b>Polystyrene Core</b>	Density ≥15 Kg/m <sup>3</sup> , Thickness not less than 60 mm	
<b>Finished Masonry</b>	Not less than 130 mm thick	

### Single Panel for Internal partition, external walls and insulation

<b>Longitudinal wire</b>	2.5 mm ø spaced @ 70 mm	
<b>Transverse Wire</b>	2.5 mm ø spaced @ 70 mm	
<b>Cross Steel Wire</b>	3.0 mm ø approx 68 nos. / m <sup>2</sup>	
<b>Polystyrene Core</b>	Density ≥ 15 Kg/m <sup>3</sup> , Thickness 40 mm to 320 mm	
<b>Finished Masonry</b>	90 mm to 370 mm thick	

**Single Panel for horizontal structure for floor/ roof**

<b>Longitudinal wire</b>	3.5 mm / 4.5 mm spaced @ 65 mm	
<b>Transverse Wire</b>	2.5 mm $\phi$ spaced @ 65 mm	
<b>Cross Steel Wire</b>	3.0 mm $\phi$ approx 68 nos. / m <sup>2</sup>	
<b>Polystyrene Core</b>	Density 15 - 25 Kg/m <sup>3</sup> Thickness 80 mm to 160 mm	
<b>Finished Masonry</b>	155 mm to 235 mm thick	

*a = EPS Nominal Thickness (variable between 80 mm to 160 mm); b = Distance between thickness steel meshes (a + 10 mm); c = Shotcrete thickness (average  $\geq$  25 mm); d = Total thickness (2xc+a)*

Generally used for buildings of not more than 4 storeys for floor and covering slabs with maximum span of 4 m.

**Floor Panel with reinforcement at joist**

<b>Longitudinal wire</b>	2.5 mm $\phi$ spaced @ 70 mm	
<b>Transverse Wire</b>	2.5 mm spaced @ 70 mm	
<b>Cross Steel Wire</b>	3.0 mm $\phi$ approx. 68nos. /m <sup>2</sup>	
<b>Polystyrene Core</b>	Density $\geq$ 15 kg/m <sup>3</sup>	

*a = thickness of core; b = thickness of concrete; c = overall thickness*

Panels are used for the floor and the roof system and reinforced in the joists with concrete casting on the site. The reinforcement of the panel is integrated during the panel assembly by additional reinforcing bars inside the joists as per the design. Suitable upto 8m span with the live load of up to 4 kN/m<sup>2</sup>.

**Double Panel**

**External mesh**

<b>Longitudinal wire</b>	2.5 mm $\phi$ spaced @ 65 m	
<b>Transverse Wire</b>	2.5 m $\phi$ spaced @ 65 mm	
<b>Cross Steel Wire</b>	3.0 mm $\phi$ approx 68nos. /m <sup>2</sup>	
<b>Polystyrene Core</b>	Density 25 Kg/m <sup>3</sup> thickness 50 mm to 80 mm	
<b>Finished Masonry</b>	Finished inter-plate thickness 120 mm to 200 mm	

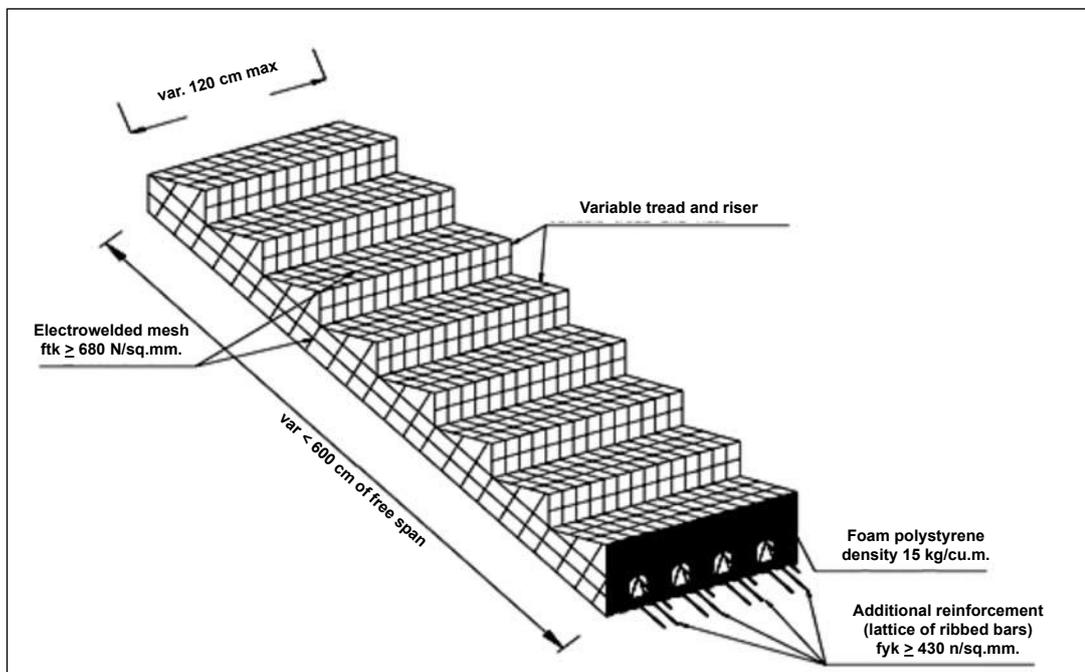
**Internal mesh**

<b>Longitudinal wire</b>	5 mm $\phi$ spaced @ 100 mm	<p>Externally the panels are sprayed with traditional pre-mixed cement based plaster. The space between the panels are filled with concrete. It functions as insulating elements as well as formwork.</p>
<b>Transverse Wire</b>	5 mm $\phi$ spaced @ 260 mm	
<b>Polystyrene Core</b>	Density 25kg/m <sup>3</sup> thickness 50 mm to 80 mm	

## Connections

Connecting the wall panel to the concrete substrata	By dowels embedded in concrete with adequate anchorage length.
Coplanar panels	By overlapping one row of electro-welded mesh and tying using 16 gauge wire.
Walls panels and ceiling panels of intermediate floors	By protruding the inner vertical dowels that connect the upper and lower wall panels through. Then putting corner mesh, tied with 16 gauge wire to the mesh of the lower wall panels as well as to the base mesh of the ceiling panel. Openings for doors & windows etc. are braced using flat mesh at 45° above and below corners of the opening.
Consecutive Floors	Using the same dowels utilized to connect the walls of the first floor to the foundation. Additional reinforcement of electro-welded mesh is provided on edges and diagonal fringe by tying on the inner and outer face of the panels by suitable wire.

## Staircase Panel



### Galvanized steel wire mesh:

Longitudinal wires:	2.5 mm dia
Transversal wires:	2.5 mm dia
Cross steel wire:	3.0 mm dia
Polystyrene slab density:	≥ 15 kg/m <sup>3</sup>



## FEATURES OF PANEL SYSTEM

### Load carrying capacity

Numerous lab tests, performed in different parts of the world, have highlighted the high load carrying capacities of the panels which after compression testing with centred load performed on a single finished panel, 2700mm high, have shown that they withstand a maximum load of up to 1530 kN/m  $\approx$  153 ton/m. The Monolithic joints of the building system provide a high level of structural strength to buildings.



### Seismic Performance

The prototype houses tested using both artificial and natural accelerograms with peak values over 1.0g, came through unscathed. Buildings made using panels are particularly lightweight, so have a low seismic mass, but are at the same time rigid due to two sheets of reinforced plaster that interact to create an enveloping 'shell' of the whole structure.



### Thermal Behaviour

The thickness and density of the panel can be customised to deliver specific thermal insulation requirements. Furthermore, the EPS core extends throughout the surface which makes up the building envelope eliminating thermal bridging.

For example, a wall with a 80 mm core and finished thickness of about 150mm provides the same thermal insulation as an insulated solid masonry wall of about 400mm, with obvious advantages in terms of additional space.



### Acoustic Behaviour

The panel has good acoustic behaviour, coupling with sound-absorbing materials (such as plasterboard, cork, coconut fibre, rock wool, etc.), further optimizes the acoustic insulation of walls.

### Sustainability and Energy Efficiency

The insulating envelope provided by polystyrene core eliminates thermal bridges and ducts within the panel. This brings high level of energy efficiency. The system provides significant improvements in indoor thermal comfort by greatly reducing energy consumption and promoting strategies aimed at sustainable development.



### Fire Resistivity

The expanded foam polystyrene used for panels is self-extinguishing and is perfectly encased by layers of reinforced concrete as external coat to sides of the panel and inhibit combustion. Fire resistance has also been verified in tests performed in various laboratories. For instance, a wall erected using a 80 mm core single panel

with 150 mm thickness provides REI\* 150 fire resistance, which means that for 150 minutes, the panel can resist fire for 150 minutes with respect to load bearing capacity, integrity and insulation.

\* R=Load bearing capacity; E=Integrity; I=Insulation

### Cost Effectiveness

Compared to traditional products, panels achieve far better results, at considerably reduced cost. The speedy construction represent additional savings.

### Rapid Installation

The system has been used in many countries worldwide. The construction experiences using the system show a marked reduction in construction time compared to traditional building methods. Panels are industrialized, and for this reason, assembly processes are optimised, labour is significantly reduced, and construction time decreased by roughly 40%.

### Lightness, Ease of Transport and Handling

Being light weight and rigid, panels are both easy to handle and transport even in the most adverse conditions. Prior to an application of shortcrete, a panel weighs between 3.5kg/m<sup>2</sup> to 5 kg/m<sup>2</sup> which means that a single worker can easily handle a 3 m<sup>2</sup> wall, that is, a panel as high as the storey height.

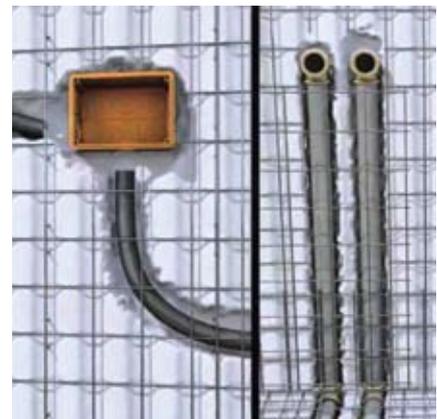
### Versatility

The building system gives full design flexibility as it offers a complete range of building elements such as load-bearing walls, curtain walls, floors and stairs.

The panels are easy to use in the construction of any type of structure, and can be shaped to any geometric requirement i.e. flat or curved by simple cutting the panels at site.

### Compatibility with Other Existing System

It is an extremely versatile building system which is completely compatible with all other existing construction systems; in fact, panels are even suitable for completing reinforced concrete or steel structures. In addition, panels can be easily anchored to other construction elements, such as steel, wood, and pre-stressed concrete.



### Blast Resistance

A series of tests has been carried out on a variety of panels finished with different types of high strength concrete. These tests were conducted using a powerful explosive, in a test chamber optimized to produce a uniform shock waves on the face of the panels.

The panels performed excellently withstanding explosions of 29.5 tons/m<sup>2</sup>.

### Wide Choice of Finishes

Buildings constructed using panels can be completed in a variety of finishes, or can be painted traditionally on smoothed plaster.

The surface of the walls has the appearance of a thin sheet of reinforced plaster that can easily accommodate all types of wall coverings including stone tiles and rain screen cladding.

### Cyclone Resistant

Laboratory tests conducted on buildings, to determine the resistance of cyclone impact and damage caused by wind-borne debris confirm the strength of the building system against such loads.

Building constructed in cyclone prone area have shown very high resistance to cyclonic wind.

### REQUIREMENTS FOR SETTING UP OF PLANTS

The viability depends upon the quantum of work. Generally requirements of 1.5 lakh sqm of panel per year for minimum period of three years makes the plant viable.

### CERTIFICATION

BMTPC under Performance Appraisal Certification Scheme has evaluated the System by EMMEDUE SPA, Italy and issued Performance Appraisal Certificate No 1010-S/2014. The systems by any other agency may required to be verified, appropriately.

### STANDARDS/REFERENCES

- PAC No. 1010-S/2014 : Performance Appraisal Certificate issued by BMTPC, New Delhi, India.
- Manual on M2 System by EMMEDUE, S.P.A. Italy.
- Manual on Schnell Home, Schnell Wire, Italy.
- Certificate No. 06/0241, Irish Agreement Board, Ireland.
- Technical Report on Experimental Evaluation of Building System M2 by Structure Lab. Department of Engineering, Ponitificia Universidad Catolica Del, Peru.
- Review of EVG-3D Technology for residential buildings in India, IIT Mumbai, India.
- Report on Performance Tests conducted on EMMEDUE Panel System at Hesarghalta, Bangalore Civil Aid Techno Clinic Pvt. Ltd., Bangalore.



# Rapid Panels

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

The Rapid Panel is a prefabricated assembly of high-strength steel wire forming a panel with a core of expanded polystyrene (EPS). During construction, Rapid Panels are installed as walls and/or slabs. Specified mixtures of mortar or concrete are applied to the surfaces of the panels to complete the structure.

The basic unit of the Rapid Panel is the zig-zag truss. Steel wire is bent into a zig-zag shape to form a continuous chain of web members. This bent wire is then welded to continuous chord wires at every node to form the complete truss. (See Figs. 1 & 2)

The Rapid panels are manufactured in a fully automated plant. This technology was initially developed in USA and the Indian firm has a collaboration with WorldHaus, California, USA. These panels are manufactured in Mexico and there is no plant in India at present.

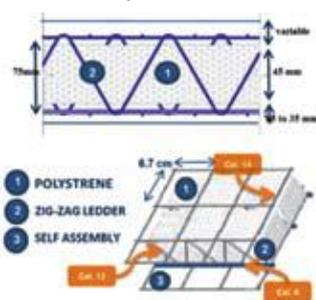


Fig. 1 Rapid Panel

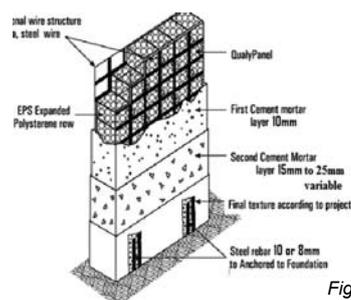
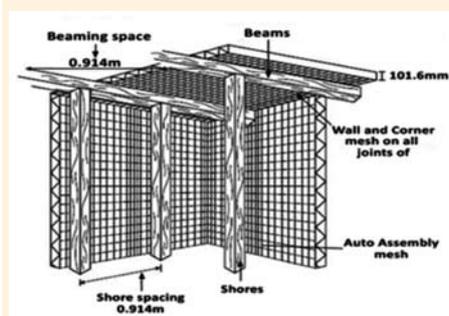


Fig. 2 Panel System Wall

## PANEL TYPES

### Wall panel

Top Wire	2.65 mm Ø
Top distribution wire	1.90 mm Ø
Truss wire	2.65 mm Ø
Bottom wire	2.65 mm Ø
Bottom distribution wire:	1.90 mm Ø
Chemical Composition	C < 0.153%, P < 0.016% S < 0.015%, Mn < 0.893%, Si % < 0.134
Galvanizing	Zinc coating of 60 gm/m <sup>2</sup> ± 5 gm/m <sup>2</sup>
Mechanical characteristics:	
1.9 mm dia	
Yield stress	> 680 N/ mm <sup>2</sup> ,
Breaking load	> 687 N/mm <sup>2</sup> ,
Elongation	> 4.8%
2.65 mm dia	
Yield strength	>618 N/mm <sup>2</sup>
Breaking load	>632 N/mm <sup>2</sup>
Elongation	> 6.1 %

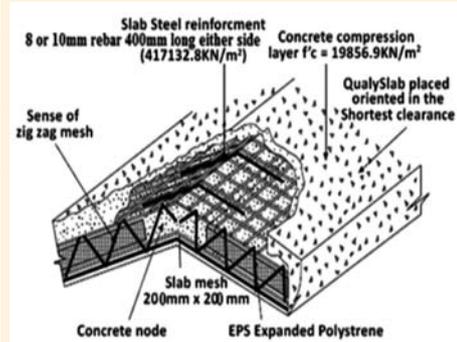


Wall Panel

Polystyrene Core	Density > 15 kg/m <sup>3</sup> , Flammability: Non Flammable, Moisture Content at 50°C: <1.1% Thickness: not < 50 mm Bead size: shall be > 95% between 0.5 – 1.12 mm as per ASTM C 578
Cast-in-place concrete	The min. grade of concrete is M20 and slump for walls, floors and roofs shall be as per IS 456:2000
Cement Plaster	Shall have a minimum 28-day compressive strength

### Roof Panel

Top Wire	2.65 mm Ø
Top distribution wire	1.90 mm Ø
Truss wire	2.65 mm Ø
Bottom wire	5.00 mm Ø
Bottom distribution wire:	1.90 mm Ø
Chemical Composition	C < 24%, P < 0.055% S < 0.055%, Ceq < 0.52%
Galvanizing	Zinc coating of 60 gm/m <sup>2</sup> ± 5 gm/m <sup>2</sup>
Mechanical characteristics:	
1.9 mm dia	
Yield stress	> 680 N/mm <sup>2</sup> ,
Breaking load	> 687 N/mm <sup>2</sup> ,
Elongation	> 4.8%
2.65 mm dia	
Yield strength	> 618 N/mm <sup>2</sup>
Breaking load	> 632 N/mm <sup>2</sup>
Elongation	> 6.1 %
5.00 mm dia	
Yield strength	670 N/mm <sup>2</sup> ,
Breaking load	816 N/mm <sup>2</sup> ,
Elongation	> 14%
Polystyrene Core	Density > 15 kg/m <sup>3</sup> , Flammability: Non Flammable, Moisture Content at 50°C: <1.1% Thickness: not < 50 mm



Roof Panel

### MATERIAL REQUIREMENTS

**Galvanised high strength steel wire:** Fe 500 & Fe 550 as per IS 1786: 2008

**Ordinary Portland Cement:** 43 grade as per IS 269:2015.

**Fine aggregate:** 4.7 mm size for concrete as per IS 383:2016 and plaster of sand 150 micron – 2.36 mm as per IS 1542:1992

**Coarse Aggregate:** of 20 mm & 40 mm size as per IS 383:2016

**Steel reinforcement:** as per IS 1786:2008.

**Gypsum Plaster board:** as per IS 2095 (Part 1):2011.

*Adhesive:* as per ASTM C 881

*Plasticizers:* as per IS 9103:1999

*Waterproofing compound:* as per IS 2645:2003

*Fibers:* Polypropylene fiber mesh as per EN 14889-2:2006

*Ledger Bolt:* Consists of 12.7 mm diameter L-shaped bolt with washers and nuts as per ASTM A 307. It shall be fastened to the panel wire sand plastered.

*Hartco clips:* Formed from 11.11mm-wide, No. 20 gauge cold-rolled steel and manufactured by Stanley Hartco or Spenax Flex-C-Rings, No. 516 G100.

### CONSTRUCTION PROCESS

The construction process of the panels is as follows:

The shop-fabricated panels consist of welded wire zig-zag trusses and a foam plastic core to which structure plaster shall be applied on each side. The panels have vertical 75 mm deep 14 gauge (1.63 mm) wire trusses spaced at 50 mm centers with preformed 57 mm thick expanded polystyrene (EPS) foam strips between. The assembly is held together with 14 gauge horizontal wires on each face at 50 mm centers electro welded to the truss chords. The horizontal wires and vertical truss chords shall project 10 mm approx. beyond each foam plastic face to permit wire embedment within cement and gypsum plaster finish applied to each face after erection on the site.

The panels are manufactured in 1.22 m widths and varying heights from 1.52 m to 3.55 m in increments of 100 mm. The nominal thickness of the panel is 75 mm resulting in a finished wall thickness, after plastering, of 100 mm or more.



*Manufacturing Process of Rapid Panels*

## APPLICATIONS

The panels shall be used for construction of buildings consisting of frame structures, load bearing walls, floors and roof etc. for residential purposes up to G+3 storey.

## IMPLEMENTATION

### Panel System

#### **Raft foundation**

For only ground floor and G+1 unit constructions. When the soil is strong or when the soil is improved, this is done by using a slab/raft foundation.

#### **Strip foundation**

For only ground floor and G+1 unit constructions. When the surface soil is in a terrain with vegetation or lime, and it is required to locate the foundation in a stronger and deeper layer, this is done by using a strip footing.

#### **Existing foundation**

When a foundation already exists or when something is being constructed over existing construction, steps given below shall be followed:

- (i) Holes of 8 or 10 mm dia. of 100 mm depth every 400 mm shall be drilled and lined up with inside of the wall.
- (ii) High strength steel bars of 8 or 10 mm dia. shall be placed in every hole leaving 400 mm of height above the foundation.
- (iii) The wall panel shall be tied with bars of 8 or 10 mm dia. on the outside of the mesh with steel wire, with a minimum of 3 ties per bar.

#### **Boundary Wall**

Following procedure shall be followed for construction of boundary walls:

- (i) Bars of 8 or 10 mm dia shall be placed on top of the foundation, alternating one on the outside of the foundation and the other on the inside every 400 mm.
- (ii) The bars that are placed on the inside shall be bent in such a way that they are rooted in the foundation.
- (iii) The wall panel shall be located on the soil and plastered on the bordering side. They shall be placed in groups of two or three.
- (iv) The mortar layer shall be dried, and the wall panel erected while straightening the interior bars.
- (v) Finally, the wall panels shall be tied to the bars on both sides perfectly and plastered on the interior.

#### **Wall Panels**

Exterior wall panels shall be set with a minimum 6 mm clearance between the concrete slab edge and the panel reinforcement. The slab shall be attached with perimeter 63 mm-long by 3 mm thick steel hold-down connector channels and 13 mm diameter foundation bolts placed at a distance of 1.22 m max. centers along width and at each panel end. Panel reinforcement and connector channels shall be attached with 305 mm long, 12 gauge (2.06 mm) wires extending approximately 45 degrees upward along each panel face from each channel end. The upper end of the diagonal wires shall be attached to the panel reinforcement. Panels shall be joined along vertical edges with 203 mm wide strips of 14 gauge 51 square mm welded wire mesh on each face centered on the panel joint. The mesh shall be attached to the vertical panel wire reinforcement with Hartco clips spaced 305 mm on center at the edge wires and 610 mm on center at interior wire Panels shall also be joined on both sides with 14 gauge wire trusses).



Interior wall panels shall be set and attached to hold-down connector channels with 12 gauge wires in the same manner as exterior panels. Approved powder-actuated anchors shall be used, provided they are adequate for applicable uplift loads. A nonstructural plaster ground shall be attached at the base of the interior panels if desired.

### **Roof and Floor Panels**

The panels shall not be permitted to bear on wood-frame walls. Horizontal diaphragms shall be permitted the same shear values as vertical racking shear, provided the panels are fastened to each other and to walls as described here.

### **Installation of Panels**

The procedure for installing the panels shall be as follows:

- i. The panels shall be put in place according to the building plan as follows:
  - It must be ensured that the rebar is on the bottom of the panel.
  - Each panel shall have a portion of wire mesh on the end without polystyrene.
  - The adjacent panel shall be inserted into this area thereby locking them together. The overlapping wire mesh should be tied together.
  - The vertical rebar in the wall shall be allowed to go through the polystyrene in the panels.
  - It shall be necessary to cut some of the wire mesh to allow this. The rebar on the bottom of the panel shall not be cut.
- ii. The polystyrene in the areas directly over the walls shall be removed.
- iii. The rebar that bends into the panels shall be placed according to the wall reinforcement and this bar shall be tied to the wire mesh on top of the panel. The vertical rebar shall be extended as necessary.
- iv. The edge molds shall be placed around the perimeter of the panel as follows:
  - Each set of holes in the edge molds shall be tied tightly to the panel
  - It must be ensured that the edge molds are level and straight.
  - It must also be ensured that there is more than 50 mm clearance between the top of panels and top of edge molds.
- vi. A minimum M20 grade of concrete shall be used.



### **Supports and Cambers**

Slabs for roofs and floors shall be made with slab panels and supported during erection with temporary beams with props spaced at 900 mm, leaving a camber. The support beams shall be located on the bottom of the panel, always perpendicular to the direction of the zigzag trusses in the panel.

### **Connections**

All the connections for walls and slabs shall use the self-connection system, where the mesh on the end of the panel shall be used to join the panels in different situations.

### **Door and Window**

These shall be made by marking and cutting the mesh of the wall panel with a circular saw, reciprocating saw, or with wire cutters, and reinforcing the edges on both sides with zigzag mesh. The zigzag mesh should extend 300 mm from the edges of the doors and windows. Afterwards, diagonal zigzag mesh shall be installed on every corner of 400 mm.

Where edges and corners are reinforced, the polystyrene along the perimeter of the opening shall be removed and the space is filled with mortar or concrete to form a rigid boundary. In the area on top of the opening, the polystyrene shall be removed and reinforcing steel placed to form a lintel beam.



### **Plumbing and Electrical Fixtures**

Water pipes and electrical conduits shall be placed within the panels as shown in the building plans by removing polystyrene from the portion. For layers pipes wire mesh shall be cut. Good practices of electrical and plumbing services shall be adopted.

### **Plumb and Alignment**

It shall be assured that the wall panel is plumb and in line, and to maintain right angles between them, tension wire and metal rulers shall be used. The polystyrene in the center of the panel shall be toothed on the surface to ensure better mortar connection and less wastage.



### **Finishing**

#### *i. Floor finishing*

- It must be ensured that the floor area is completely clear of any debris, dust and soil etc.
- It must be ensured that the floor surface is damp prior to finishing and it should be fully moist without any water stagnating on it.
- Cement mortar of mix 1 cement: 3 sand shall be prepared and required quantity of mortar shall be applied to the floor to provide a smooth finish.

#### *ii. Ceiling finishing*

- A stiff mix of 1 cement: 3 sand mortar shall be prepared and applied to the ceiling, providing a level but rough surface.
- It must be ensured that the first layer of plaster is damp prior to applying the finish layer.
- Cement mortar of mix 1 cement: 4 sand shall be prepared and required quantity of mortar shall be applied to the ceiling to provide a smooth finish.
- The total thickness of the ceiling finish should not exceed 19 mm below the panel wire mesh.

#### *iii. Wall finishing*

- Cement mortar of mix 1 cement: 4 sand shall be prepared and 25 mm plaster shall be applied to the pre-damp wall to give a finish surface.
- Wall plaster should be allowed to be cured for at least 7 days after placement.



### **Handling of Panels**

These panels are composed of two layers of steel wire mesh with a layer of polystyrene in the middle. The bottom side of each panel has rebar welded in which provides the strength that allows the panel to be used as a slab. The wire mesh on the top and bottom are connected to each other with a 'zig-zag truss' of wire running between the two meshes, welded at each joint. Good practices for handling of the panels shall be followed.

### **Cutting of Panels**

As the panels are manufactured in a few fixed sizes, it shall be necessary to cut the panels to a smaller size. The procedure for cutting of the panels shall be as follows:

- The length of the panel to be cut shall be measured and the measurement extended to the far-side of the nearest cross-wire.
- Bolt cutters shall be used to cut the wires along the measured length on one side of the panel.
- Panels shall be flipped to the other side and bolt cutters used to cut the wires along the measured length on the other side of the panel.
- Panels shall be allowed to stand on its end and bended to 90° to expose the 'zig-zag truss'. The bolt cutter shall be used to cut the exposed wires.

## **SPECIAL FEATURES**

### **Structural Stability**

IIT Madras has certified that RapidPanel Roofing slab system is found satisfactory for use in buildings, for imposed loads (live loads) defined in IS 875 (Part 2):1987 on the basis of static tests under gravity loading.

### **Durability**

On the basis of test conducted, the wall panel is capable of taking the min. load of 12.0 ton and no crack observed on the surface of the wall panel

### **Behavior in earthquake**

Load bearing wall panel system acts as a continuous shear wall system. It is analyzed as per box section and additional vertical bars are fixed to the panels according to lateral analysis. Load bearing/shear wall panel system is being used for structures upto G+5 in high seismic areas (zone v) having poor soil conditions to provide an economical and robust structure that meets codal seismic design requirements.

### **Fire Safety**

For one hour fire-resistive wall assembly, the panels are covered with 29 mm thick cement plaster on both sides. For two hour fire-resistive wall assembly, the panels are covered with 25 mm thick cement plaster followed by 12 mm thick light weight gypsum plaster or light weight cement plaster on both sides.

### **Thermal Performance**

As per the tests conducted, the thermal transmittance U works out to 0.503 W/mK.

### **Shuttering**

Rapid panel slab does not require conventional shuttering/formwork, as the EPS filler acts in this capacity.

### **Limitations of Use**

- Panel lengths shall be up to 5 m, simply supported on beams or bearing walls not less than 125 mm in width.
- Panels shall be installed with min. M20 grade of concrete and 1:3 cement plaster.
- Total dead load (including panel self-weight) shall not exceed 3.3 kN/m<sup>2</sup>
- Total imposed load (live load) shall not exceed 3.0 kN/m<sup>2</sup>.

## WORKS COMPLETED

1. (GF) house at Sarjapura, Bangalore of 200 sqm area
2. (B+G) house at Coorg, Bangalore of 300 sqm area
3. (S+2) Nirmithi Kendra at Bangalore of 120 sqm area
4. (S+2+H) flat at Bangalore of 180 sqm area
5. (S+2) flat at Bangalore of 120 sqm area
6. CSI Church at Hosur, Bangalore of 350 sqm area
7. (G+2) flat at Bangalore of 120 sqm area
8. (G+3) flat at Bhubaneswar of 200 sqm area

## CERTIFICATION

Performance Appraisal Certificate No. 1026-S/2016 issued to M/s Worldhaus Construction Pvt. Ltd., Bangalore by BMTPC.

## STANDARDS/REFERENCES

- Legacy Report by ICC Evaluation Services Inc., USA
- Construction Manual by WorldHaus Construction Ltd., USA
- IS 383:2016 – Specifications for coarse and fine aggregates for concrete
- IS 456:2000 – Code of practice for plain and reinforced concrete
- IS 875 (Part 1 & 2):1987 – Code of Practice for Design Loads (Other than Earthquake) for buildings & structures: Part 1 Dead Loads; Part 2 Imposed Loads
- IS 1786:2008 – Specifications for high strength deformed steel bars and wires for concrete reinforcement (Fourth Revision)
- IS 1893 (Part 1):2002 – Criteria for earthquake resistant design of structures (Part 1) - General Provisions and Buildings
- IS 1904: 1986 – Code of practice for design and construction of foundations in soils: General requirements
- IS 2095 (Part 1):2011 – Specifications for gypsum plaster board (Part 1) - Plain gypsum plaster boards
- IS 2645:2003 – Specifications for integral water proofing compounds for cement, mortar and concrete



# Reinforced EPS Core Panel System

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

Reinforced Expanded Polystyrene Core (EPC) Panel System is a factory produced panel system for the construction of low rise buildings upto G+3 and as filler walls in high rise RCC and steel frame buildings. In this technique, a core of undulated polystyrene is covered with interconnected zinc coated welded wire mesh on both sided reinforcement and shotcrete concrete.

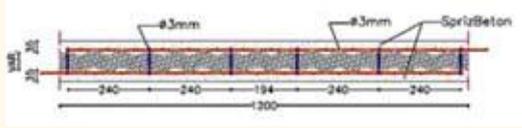
The panels are finished on site by pouring concrete (double panel, floors and stairs) and spraying concrete to realise the following different elements of the system:

- Vertical Structural Walls
- Horizontal Structural elements
- Cladding elements

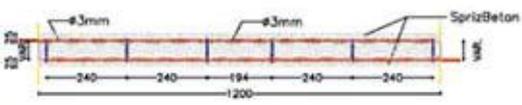
## PANEL TYPES

The panels are of three types depending upon the application as shown below:

### Single load bearing Panel

Longitudinal wires	2.5 /3.0 mm Ø @80 mm c/c	
Transverse wires	2.5 /3.0 mm Ø @80 mm c/c	
Connectors & cross wires	3.0 mm Ø @ 150 mm c/c	
Polystyrene core conforming to IS 4671	Density : $\geq 15 \text{ kg/m}^3$ Thickness: 50 mm to 160 mm Wave Depth: 15 mm	
Finished Masonry	Not less than 130mm thick	

### Single Non Load Bearing Panel

Longitudinal wires	2.5 /3.0 mm Ø @80 mm c/c	
Transverse wires	2.5 /3.0 mm Ø @80 mm c/c	
Connectors & cross wires	3.0 mm Ø @ 150 mm c/c	
Polystyrene core	Density : $\geq 15 \text{ kg/m}^3$ Thickness: 40 mm to 280 mm Wave Depth: 5 mm	
Finished Masonry	90 to 370mm thick	

### Single Floor Panel

Used as floors or roofs span upto 5 m x 5 m and supported by the walls in all the sides. The panels are finished on site by 50 mm of casted concrete in upper side and 30 mm of projected plaster in the lower side.

Longitudinal wires	2.5 /3.0 mm Ø @80 mm c/c	
Transverse wires	2.5 /3.0 mm Ø @75 mm c/c	
Connectors & cross wires	3.0 mm Ø @ 150 mm c/c	
Polystyrene core	Density : $\geq 15 \text{ kg/m}^3$ Thickness: 80 mm to 160 mm Wave Depth: 5 mm	
Finished Masonry	Not less than 80mm thick	

### Two Pot Floor Panel

With span up to 9 m, these panels are characterized by the presence of joist. The joists are reinforced on site by the steel bars according to the structural verification and are finished by 40 mm of casted concrete (M25) on the upper side and 25 mm of projected plaster (M15) in the lower side.

Longitudinal wires	2.5 /3.0 mm Ø @80 mm c/c	
Transverse wires	2.5 /3.0 mm Ø @75/150 mm c/c	
Connectors & cross wires	3.0 mm Ø @ 150 mm c/c	
Polystyrene core	Density : $\geq 15 \text{ kg/m}^3$ Thickness: 40 mm to 280 mm Wave Depth: 5 mm	
Finished Masonry	Not less than 65mm thick	

### MATERIAL REQUIREMENTS

Steel for both wire mesh and connectors.

Zinc Coating – The zinc covering is variable with the diameter of the wire mesh. Standard wire mesh shall be 3.0 mm dia and minimum zinc coating galvanizing shall be of 60 gm/m<sup>2</sup>.

#### Mechanical characteristics

Tensile strength (2.5 mm Ø)	:	$\leq 750 \text{ N/mm}^2$
Tensile strength (3.0 mm Ø)	:	$\leq 700 \text{ N/mm}^2$
Yield strength (2.5 mm Ø)	:	$\leq 680 \text{ N/mm}^2$
Yield strength (3.0 mm Ø)	:	$\leq 600 \text{ N/mm}^2$
Elongation	:	$> 8\%$

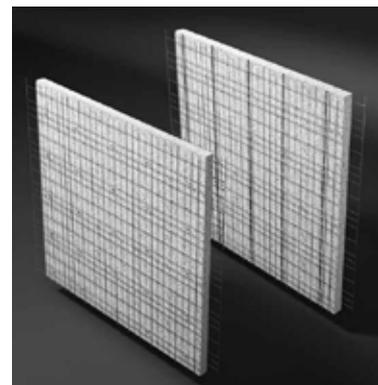
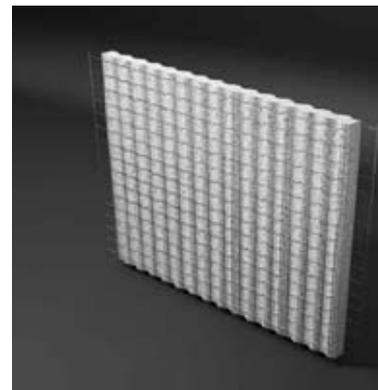
#### Chemical characteristics

% C	:	$< 0.24$
%P	:	$< 0.055$
%S	:	Max 0.045
%Ceq	:	$< 0.52$
%Si	:	0.300 – 0.600

### APPLICATIONS

The panels are used as:

- i. load bearing walling in buildings
- ii. non- load bearing wall panels
- iii. partition infill wall in multi storey framed buildings
- iv. floor / roof slabs



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## INSTALLATION PROCEDURE

### **Foundations**

Foundations for the EPS Core Panel system whether strip or raft are conventional. If strip foundations are used, they should be levelled and stepped as this makes panel positioning easier.

For EPS Core panels, parallel sided timber or metal template of the width of panel shall be required to mark the position of the wall panels on the foundation and the spacing of the starter bar holes.

### **Wall start-up**

- Line wall positions shall be marked and profiled.
- A timber or metal template of the exact width of panel (from wire to wire) shall be used to mark the position of the panels with chalk or pencil lines.
- On the panel, lines positions shall be marked to drill the starter bar holes. These should be in a zig zag pattern at 600 mm centres on each side of the panels. Starter bars should be at all panel joints and on the opposite side in mid panel plus at all wall corners and joints.
- Starter bars should be either 6 mm or 8 mm dia. 500 mm long with 100 mm drilled into the foundations and 400 mm above.
- Drill bits shall be used to give a tight fit with the starter bars.
- Once starter bars are in position, EPS Core panels shall be placed between the starter bars, starting from a corner. Starter bars shall be wire-tied to the panel mesh and the panels to each other on the overlapping mesh.

### **Wall construction**

- All corners and wall joints shall be reinforced with right angled wire mesh to the full height of the walls.
- To cut panels to fit for door & window openings, wire should be cut with a wire cutter or angle grinder. Measure and mark the cut lines before starting to cut.
- After the wire mesh has been cut, EPS shall be cut with a hacksaw blade or stiff blade hand saw.
- Added steel mesh reinforcement shall be required around door and window openings to ensure that no plaster cracks form in these areas. Mesh reinforcement strips shall be tied diagonally with wire around openings before plastering.
- Once wall panels are in place and tied together, bracing shall be required to hold them vertical before plastering. This shall be done only on one side of the panels.
- Once the panels are plastered on one side, the wall bracing shall be removed after 24 h. Plastering on other side can be done without bracing.

### **Door and Window fittings**

- Fix a metal angle iron or hollow tube sub frame into the openings before plastering. Fix and plaster these in place and then secure the frames to the sub frame.
- In order to secure heavy door/window frames, the EPS where the bolts are to be fixed to the wall, shall be



burnt or cut and this space shall be filled with mortar or concrete to hold the bolts.

### **Plastering**

- Plastering shall be done by machine or hand. The indicative quantity of each material per m<sup>3</sup> shall be:
  - (i) Cement: 350 kg
  - (ii) Sand with mixed granulometry: 1600 kg. Sand should be without clay or any organic substance and totally washed.
  - (iii) Water – 160 l. The quantity of water may be different according to the natural sand moisture. W/C = 0.52 and I/C = 4.50 shall be maintained.
- Any problem of workability should be solved without adding water. The retraction cracks formation may be avoided by adding polypropylene fibers in the mix (1kg/m<sup>3</sup>).
- In order to control the final plaster thickness, some guides should be used. These shall be removed as soon as the plaster 'sets up' and the spaces are filled and are smoother before the plaster gets dry.
- Spray application should be done in two steps with a first layer covering the mesh applied on both the sides of the wall and the finishing layer as soon as the first layer gets dry.



### **Plumbing and electrical fittings**

- Plumbing and electrical conduits shall be behind the panel wire mesh before plastering.
- The space behind the wire mesh shall be opened up by using a blow torch to partially melt the EPS along the lines of the conduits.
- As the EPS used in the panels is fire retardant, it will melt under the flame but not burn.
- The wire mesh shall be cut with wire clippers to make space for DB boards, switches and plug boxes.



### **Connection**

The Reinforced EPS Wall system is composed by panels consisting of a polystyrene sheet assembled together with welded wire mesh.

## **SPECIAL FEATURES**

### **Structural Stability**

Numerous lab tests, performed in different parts of the world, have highlighted the high load resistance of the panels which after compression testing with centred load performed on a single finished panel, 2700 mm high, have shown that they withstand a maximum load of up to 1530 kN/m =153 ton/m. The Monolithic joints of the building system provide a high level of structural strength to buildings.

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### **Durability**

Durability is achieved with the use of proper grade and thickness of concrete as per IS 456. Minimum 45 mm thick plaster is recommended for structural and fire safety point of view.

### **Behaviour in earthquake**

Buildings made using panels are particularly lightweight, so have a low seismic mass, but are at the same time rigid due to two sheets of reinforced plaster that interact to create an enveloping shell of the whole structure.

### **Fire Safety**

The quality of the expanded foam polystyrene used for panels is self-extinguishing and is perfectly encased by layers of reinforced concrete as external coat to sides of the panel and inhibit combustion.

### **Thermal Performance**

The thickness and density of the panel can be customized to deliver specific thermal insulation requirements. Furthermore, the EPS core extends throughout the surface, which makes up the building envelope eliminating thermal bridging. For example, a wall with 80 mm core and finished thickness of about 150 mm provides the same

thermal insulation as an insulated solid masonry wall of about 400 mm, with obvious advantages in terms of additional space



**During finishing**



**After finishing**

### **Acoustic Performance**

The panel has got good acoustic behaviour, coupling with sound-absorbing materials (such as plasterboard, cork, coconut fibre, rock wool, etc.), further optimizes the acoustic insulation of those walls.

### **Behaviour under high winds/Cyclone**

Laboratory tests conducted on buildings, to determine the resistance of cyclone impact and damage caused by wind-borne debris confirm the strength of the building system against such loads. Building constructed in cyclone prone area have shown very high resistance to cyclonic wind.

### **Sustainability and Energy efficiency**

The insulating envelope provided by polystyrene core eliminates thermal bridges and ducts within the panel. This brings high level of energy efficiency. The system provides significant improvements in indoor thermal comfort by greatly reducing energy consumption and promoting strategies aimed at sustainable development.

### **Cost Effectiveness**

Compared to traditional products, panels achieve far better results at considerably reduced cost. The speedy construction represent additional savings.

### **Lightness, ease of transport and handling**

Being light weight and rigid, panels are both easy to handle and transport even in most adverse conditions. Prior to an application of shotcrete, a panel weighs between 3.5 kg/m<sup>2</sup> to 5 kg/m<sup>2</sup> which means that a single worker can easily handle a 3 m<sup>2</sup> wall, i.e. a panel as high as a storey height.

## MAJOR WORKS COMPLETED

At Angul, Odisha:

### **Load Bearing Structures**

- Construction of C, D & F type flats of 3 to 4 storey having a total of 70 flats
- Construction of G type flats of 3 storey having a total of 60 flats
- Construction of Police Quarters of 3 storey having a total of 18 flats

### **Partition Walls for Non-load Bearing Structures**

- Construction of C & D type flats of 3 to 4 storey having a total of 38 flats

## CERTIFICATION

Performance Appraisal Certificate No. 1020-S/2015 issued to M/s Jindal Steel & Power Ltd., Angul, Odisha by BMTPC.

## STANDARDS/REFERENCES

- IS 456:2000 – Code of practice for plain and reinforced concrete
- IS 4671:1984 – Specifications for expanded polystyrene for thermal insulation purposes

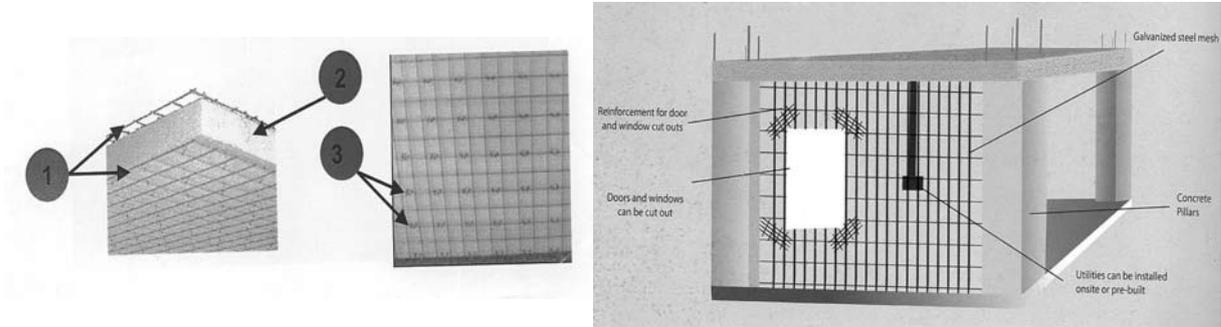






## MANUFACTURING PROCESS

QuickBuild 3D panel is manufactured from welded wire space frame integrated with a polystyrene (EPS) insulation core sandwiched between two layers of engineered galvanized steel mesh that are held together with steel trusses. Steel trusses are pierced through the polystyrene core and welded to the outer layer sheets of galvanized steel mesh to form a rigid panel.



For any structure, foundation is built using conventional methods, starter bars are cast into the slab. The panels are erected vertical in plumb and temporarily supported by way of bracing Rebar which is set between the mesh and the polystyrene (for easy wall alignment). Splice meshes are then fixed using fastener tool. Door & window openings can be cut both before or after panel erection. Roof panels are then erected and fastened with joining mesh. Concealed plumbing and electrical wiring can be pre-built into the panel using hot air torch. Subsequently, doors and windows are fixed. Structural plaster is finally applied pneumatically on both sides and concreting of exterior side of the roof panel is done. Natural Curing is done for concrete to gain strength.

## FIXING OBJECTS TO WALLS

- Light weight object: 2.5 mm screws, pins or similar devices may be used.
- Heavy object (shelves, water tanks etc.): Plastic pins with 45 mm screws or similar devices are recommended.
- Very heavy object: During erection, metal pins may be inserted in plaster pallets. Alternatively, threaded pins fastened with epoxy resin may be used.

## SPECIAL FEATURES

The panel receives its outer place strength and rigidity by truss action. Outer shortcrete layers are the chaired members.

### **Structural Stability**

The monolithic structure of the panel in conjunction with concrete enables a structure built with it to withstand earthquakes, hurricanes and high winds.

*For load bearing structure of G+3 or higher in seismic prone areas, analysis report from recognized Institute is recommended for its safety against earthquake forces.*

### **Durability**

- Concrete of adequate grade and cover as per IS 456:2000 provides required durability to this structure.



- Exterior coating may be applied to provide additional protection to the reinforcement against corrosion in aggressive environment.

**Behavior in earthquake**

Buildings made using panels are particularly lightweight, so have a low seismic mass, but are at the same time rigid due to two sheets of reinforced plaster that interact to create an enveloping shell of the whole structure.

**Water Tightness**

Externally the walls shall be protected by an approved render applied to minimum 35 mm sprayed 25 MPa concrete. DPC/radar barrier shall be installed at ground level to prevent rising damp. DPC shall also be used around window sills and a sealant shall be applied around window or door frames.

**Thermal Performance**

QuikBuild panels are an efficient and thermally advantageous solution for all construction needs. These panels are the rigid foam insulation that provides long term thermal resistance that does not need to be adjusted for age.

**Acoustic Performance**

The panels have superior sound dampening capability compared to masonry walls and this can be further enhanced by increasing the core thickness. Up to 50 dB insulation.

**Behavior in moisture/humidity**

The panel is excellent for preventing condensation/absorption on interior walls. The external walls/roof can use waterproofing mortar for additional protection.

**Optimize Energy Performance**

- QuikBuild panels are an efficient and thermally advantageous solution for all construction needs. The panels are manufactured in varying thicknesses to meet the environmental design criteria to deliver a range of R-value specifications.

**Recycled Content**

- About 10% to 20% of the materials are recycled.

**PRECAUTIONS**

- Do not overload partition walls on one side only. Instead, spray the concrete on both sides alternatively
- If the panel is cut during erection and its meshwork has no wire-crossing points, panels should be joined with flat meshwork (min. width 225 mm)

**APPLICATIONS**

- The technology is used in the construction of exterior and interior load-bearing and non-load bearing walls and floors of buildings of all types of construction.

## MAJOR WORKS COMPLETED

- Christ College, Kilacherry (T N) in February 2012
- Meridian Hotel, White Field, Bangalore in May 2013
- Bethany School, Koramangalka, Bangalore in October 2013
- Sure Energy Systems Pvt. Ltd., Hyderabad (AP) in November 2013
- VTRC Ponmeni, Madurai (TN) in December, 2013
- Vineetha Industries, Adugodi, Bangalore in January 2014
- SERC Taramani, Chennai (TN) in February 2014
- VME Reality, Chembarabakkam (TN) in May 2014
- KPCL Wood House, Kovalam (TN), August 2014
- Champs Empowering Education, Hyderabad (AP) in August 2014

## CERTIFICATION

Performance Appraisal Certificate No. 1019-S/2015 issued to Beardsell Ltd, Chennai by BMTPC.

## STANDARDS/REFERENCES

- Axial Compression Test and Static Flexural Test on Panels as Wall elements and Roof or Slab elements respectively by IIT Madras
- Pull off test on plastered surface of structural concrete insulated panels at Bangalore by Civil-Aid Techno-clinic Pvt. Ltd. Bangalore
- Report on Shaking Table Test of a 1:2.35 Scale 4-Story Building Constructed with 3D Panel System University of Technology, Iran.
- IS 456:2000 – Code of practice for plain and reinforced concrete
- IS 875(Part 1):1987– Code of practice for design loads for buildings and structures

# Concrewall Panel System

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

The Concrewall System is an industrial system for the construction of structural walls of reinforced concrete for building in single panel up to G+3.

The system is composed of a factory produced panel of undulated (wave shape) polystyrene covered on both sides by an electro-welded zinc coated square mesh of galvanized steel and linked by 40 connectors per sq m made of high-elastic-limit, 3 mm dia wires realizing a 3 dimensional hyper-static reinforced steel. (Figs 1 & 2)

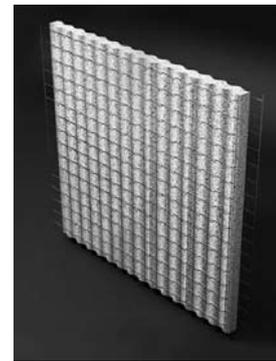


Fig.1: Single (core)

The panels are assembled on site and in-situ concrete (double panels, floors, stairs) and shotcreted concrete sprayed (single panel) to realize the following different elements of the system:

- Vertical structural walls
- Horizontal structural elements
- Cladding element
- Internal walls.



Fig.2: Cross-section

## PANEL TYPES

**Single Bearing Panel** – Used as Load Bearing Wall

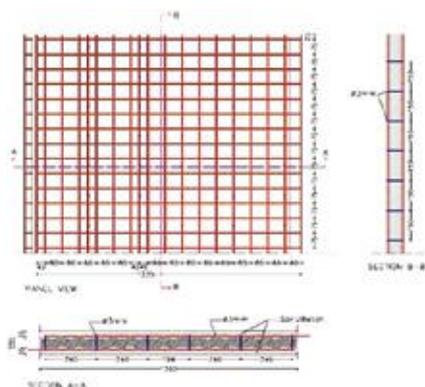


Fig. 3 Single Bearing Panel

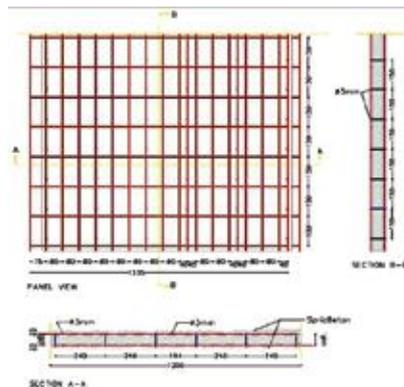


Fig. 4 Single Non-load Bearing Panel



### Mesh

Width	: 1235 mm
Longitudinal wires	: 2.5/3.0 mm $\varnothing$ @ 80 mm c/c (max)
Transverse wires	: 2.5/3.0 mm $\varnothing$ @ 75 mm c/c (max)
Connectors & cross wire	: 3.0 mm $\varnothing$ @ 150 mm c/c

### EPS

Density	: $\geq 15 \text{ kg/m}^3$
Thickness	: 40 mm to 240 mm
Wave Depth	: 15 mm

**Single Non Load Bearing Panel****Mesh**

Width	: 1235 mm
Longitudinal wires	: 2.5/3.0 mm $\varnothing$ @ 80 mm c/c (max)
Transverse wires	: 2.5/3.0 mm $\varnothing$ @ 75 /150 mm c/c (max)
Connectors & cross wire	: 3.0 mm $\varnothing$ @150 mm c/c

**EPS**

Density	: $\geq 15$ kg/m <sup>3</sup>
Thickness	: 40 mm to 280 mm
Wave Depth	: 5 /15 mm

**Single Floor Panel**

Used as floors or roofs span upto 5 m x 5m and supported by the walls in all the sides. The panels are finished on site by 50 mm of casted concrete in upper side and 30 mm of projected plaster in the lower side.

**Mesh**

Width	: 1235 mm
Longitudinal wires	: 2.5 / 3.0 mm $\varnothing$ @ 80 mm c/c
Transverse wires	: 2.5 / 3.0 mm $\varnothing$ @ 75 mm c/c
Connectors & cross wire	: 3.0 mm $\varnothing$ @ 150 mm c/c

**EPS**

Width	: 1200 mm
Thickness	: 80 mm to 200 mm
Density	: $\geq 15$ Kg/m <sup>3</sup>

**Floor Panel with Joists****Galvanized steel wire mesh**

Longitudinal wires	: 2.5 mm $\varnothing$ every 70 mm
Transversal wires:	: 2.5 mm $\varnothing$ every 70 mm
Cross steel wire:	: 3.0 mm $\varnothing$ (approx. 68 per m <sup>2</sup> )
Polystyrene slab density	: $\geq 15$ kg/m <sup>3</sup>

This panel is used for the floor and the roof system and it is reinforced in the joists with concrete casting on the site.

The reinforcement of the panel is integrated during the panel assembly by additional reinforcing bars inside the joists as per the design.

These are suitable for slabs having spans up to 8 m and with live loads up to 4 kN/m<sup>2</sup>.

**MATERIAL REQUIREMENTS****Raw Materials**

- Steel for both wire mesh and connectors
- Zinc Coating – The zinc covering is variable with the diameter of the wire mesh. Standard wire mesh shall be of 2.5/3.0 mm  $\varnothing$  and zinc coating galvanizing shall be of 60/90 gm/m<sup>2</sup> with a tolerance of  $\pm 5$  gm/m<sup>2</sup>.

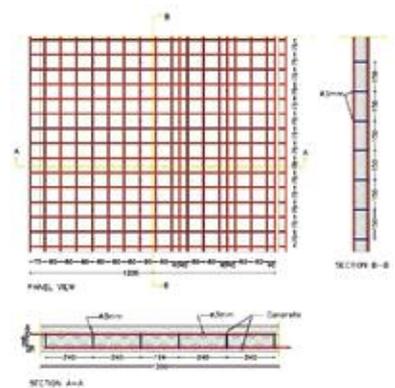


Fig. 5 Single Floor Panel

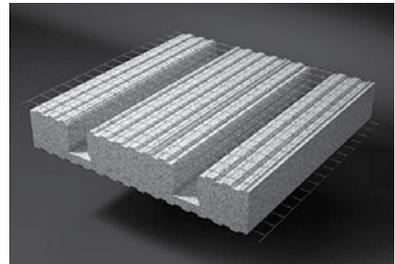


Fig. 6 Floor Panel with Joists



**Mechanical characteristics**

Tensile strength (2.5mm $\varnothing$ )	: 750 N/mm <sup>2</sup>
Yield strength (2.5mm $\varnothing$ )	: 680 N/mm <sup>2</sup>
Tensile strength (3.0mm $\varnothing$ )	: 700 N/mm <sup>2</sup>
Yield strength (3.0mm $\varnothing$ )	: 600 N/mm <sup>2</sup>
Elongation	: > 8%

**Chemical characteristics**

% C	: < 0.24
% P	: < 0.055
% S	: < 0.055
% Ceq	: < 0.52



- **Expanded Polystyrene** – Self-extinguishing type EPS in accordance with IS 4671:1984 (UNI EN 13163:2013) having density not less than 15 kg/m<sup>3</sup>.

**PRODUCTION PROCESS**

Concrewall Panels of different dimensions are produced with two raw materials namely steel wire in coils and polystyrene blocks.

1. **Galvanized wire:** It includes the following phases:
  - Perfect straightening and cutting of the required wires
  - Assembly by electrical welding of the wires of different dia to make mesh of pre-established lengths
2. **Polystyrene blocks EPS:** The most complete hypothesis shall include the following:  
Shape the dried blocks and cut sheets of a specific form and dimension according to the final type of product. The possible scraps are grounded and recycled, within certain limits, in the production of EPS blocks on the condition that these are first cleaned and are without any foreign substance, with particular attention to the presence of dust.
3. **Assembly:**  
Assembly of the Concrewall panel shall be made by electro-welding no.6 wires (in transversal and perpendicular position with respect to the panel surface) with two meshes, forming a sandwich including the EPS sheet between these, which has been previously inserted.
4. **Operations 'out of line':**  
The production line is complete after cutting and bending of the external overlapping meshes.

**INSTALLATION PROCEDURE**

1. **Foundations**  
Where Foundations for the Concrewall System are used, they should be levelled and stepped as this makes panel positioning easier.  
For concrewall panels, parallel sided timber or metal template of the width of panel shall be required to mark the position of the wall panels on the foundation and the spacing of the starter bar holes.
2. **Wall start up**
  - Line wall positions shall be marked and profiled.
  - A timber or metal template of the exact width of panel (from wire to wire) shall be used to mark the position of the panels with chalk or pencil lines.
  - On the panel lines, positions shall be marked to drill the starter bar holes. These should be in a zig zag pattern at 600 mm centres on each side of the panels. Starter bars should be at all panel joints and on the opposite side in mid panel plus at all wall corner joints.

- Starter bars should be either 6mm or 8 mm dia, 500 mm long with 100 mm drilled into the foundations and 400 mm above.
- Drill bits shall be used to give a tight fit with the starter bars.
- Once starter bars are in position, place the Concrewall panels between the starter bars starting from a corner. Starter bars shall be wire-tied to the panel mesh and the panels to each other on the overlapping mesh.

### 3. *Wall construction*

- All corners and wall joints should be reinforced with right angled wire mesh to the full height of the walls.
- To cut panels to fit for door & window openings, wire should be cut with a wire cutter or angle grinder. Measure and mark the cut lines before starting to cut.
- After the wire mesh has been cut, EPS shall be cut with a hacksaw blade or stiff blade hand saw.
- Added steel mesh reinforcement shall be required around door and window openings to ensure that no plaster cracks form in these areas. Mesh reinforcement strips shall be tied diagonally at every corner of openings before plastering.
- Once wall panels are in place and tied together, bracing shall be required to hold them vertical before plastering. This shall be done only on one side of the panels.
- Once the panels are plastered on one side, the wall bracing shall be removed after 24 hours. The panels are now sufficiently stiff so that plastering on other side can be done without bracing.

### 4. *Door and Window fittings*

- Before plastering metal 'cliscoe' type window and door frames (which should be sized to the width of the panels) may be fitted into the pre-cut panels.
- Metal 'cliscoe' type window frame fitted into future house panel before plastering.
- Metal lugs from the back of metal frames shall be wire tied to the panel mesh to keep the frames in position.

For any other kind of frames, suitable method in accordance with the manufacturer's specifications may be used.

### 5. *Plastering*

- Plastering shall be done by machine or hand. The indicative quantity of each material per cum. should be as follows:
- Cement: 350 kg
- Sand with mixed granulometry: 1600kg. Sand should be without clay or any organic substance and totally washed.
- Water – 160 litres. The quantity of water may be different according to the natural sand humidity. The parameters that should be constant are:  $W/C = 0.52$  and  $I/C = 4.50$ .
- Any problem of workability should be solved without adding water. The retraction cracks formation may be avoided by adding Polypropylene fibers in the mix ( $1\text{kg}/\text{m}^3$ ).
- In order to control the final plaster thickness, some guides should be used. These shall be removed as soon as the plaster 'sets up' and the spaces are filled and are smoother before the plaster gets dry.
- Spray application should be done in two steps with a first layer covering the mesh applied on both the sides of the wall and the finishing layer as soon as the first layer gets dry.

### 6. *Roof/floor panel*

- After the vertical panels are assembled, verticality of the walls should be checked and the bending meshes positioned on all the corners. Thereafter, horizontal bending meshes shall be placed to connect the floor/roof to the vertical panels. The bending meshes should be fixed throughout the perimeter of the floor/roof, at the level of intrados.
- When the horizontal bending meshes are fixed and checked floor/roof panel shall be placed on these.

The lower mesh of the panel shall be fixed by steel wire to the bending meshes.

- Between the edges of floor/roof panel and vertical panel, gap of 35 mm should be left to ensure structural continuity. The plaster applied on the walls shall be continued from one level to another level.

Placing of the Concrewall elements for the floor and/or roof should be done before the application of the external layer of plaster on the walls. Casting of concrete on the floor/roof panels (after placing the additional reinforcing bars, if required) should be done after the walls are plastered and a number of props shall be put to limit the deformation of the panel.

#### 7. *Plumbing and electrical fittings*

- Plumbing and electrical conduits shall be behind the panel wire mesh before plastering.
- The space behind the wire mesh shall be opened up by using a blow torch to partially melt the EPS along the lines of the conduits.
- As the EPS used in the panels is fire retardant, it will melt under the flame but not burn.
- The wire mesh shall be cut with wire clippers to make space for DB boards, switches and plug boxes.

### **ADVANTAGES**

#### *Fast Construction*

The speedy construction represent additional savings.

#### *Design Flexibility*

The building system gives full design flexibility as it offers a complete range of building elements such as load-bearing walls, curtain walls, floors and stairs.

#### *Ease of Use*

The panels are easy to use in the construction of any type of structure, and can be shaped to any geometric requirement i.e. flat or curved by simple cutting the panels at site.

### **LIMITATION OF THE TECHNOLOGY**

Economical for mass housing only.

### **SPECIAL FEATURES**

#### *Structural Stability*

The System receives its outer plane strength and rigidity by truss action where the shotcrete layers are the chord members.

#### *Durability*

Durability shall be in accordance with IS 456:2000 which specifies exposure conditions, concrete strength and cover requirements

#### *Behavior in earthquake*

Being light in weight, earthquake forces are less in the structure. With proper design and detailing, the structure can be made safe.

#### *Fire Safety*

During the fire ignited inside the building (temp. raised up to 163°C), no distress/distortion of panels was observed in any part of the unit except breaking of a window glazing.

#### *Water Proofing*

No dripping or leakage of water through slab during 24 h of ponding was observed except for minor damp patches on the ceiling at few places.

The inner face of the wall was observed to be free from which was found to be within the permissible limits dampness or sweating during 10 h of jetting at regular intervals of 30 min.

#### *Thermal Performance*

The reduction in outside and inside temperature was recorded up to 5.8°C indicating a good thermal comfort.

#### *Acoustic Performance*

Sound intensity was measured outside and inside the unit to know the difference in sound levels using sound level meter. The results showed reduction of sound level by 35dB indicating a good acoustic comfort.

#### *Behavior under high winds*

The design of roof to wall connections shall be to a specific design to ensure that the roof structure is properly restrained against uplift.

### **WORKS COMPLETED**

*Following 3 plants in India have been set up using Schnell Machineries*

- West: Maad Constructions Co Ltd, Pune, Maharashtra
- East: Jindal Steel & Power Ltd, Angul, Odisha
- North: Synergy Thryslington, Mohali, Punjab

#### *Buildings Constructed*

- Industrial Township at Angul, Odisha
- Mass Housing, G+3 Buildings, at Vasai, Maharashtra
- Hostel & Hospital Buildings in Punjab & Himachal Pradesh
- Anganwadi Buildings across India by Vedanta Group
- In-fill Wall used in different regions

#### *Use with Other Systems*

- In-fill Walls for Steel-frame & Floor Buildings
- Use with AI/Plastic Monolithic Formwork

### **CERTIFICATION**

Performance Appraisal Certificate No. 1031-S/2017 issued to M/s Schnell Home, Italy by BMTPC.

### **STANDARDS/REFERENCES**

1. IS 456:2000 – Code of practice for plain and reinforced concrete
2. IS 4671:1984 – Specifications for expanded polystyrene for thermal insulation purposes
3. BS 476(Part 22):1987 – Fire resistance



# Glass Fibre Reinforced Gypsum (GFRG) Panel Building System

*(Suitable for Low Rise to High Rise Structures)*

## ABOUT THE TECHNOLOGY

Glass Fibre Reinforced Gypsum (GFRG) Panel also known as Rapidwall is made-up of calcined gypsum plaster, reinforced with glass fibers. The panel was originally developed by GFRG Building System Australia and used since 1990 in Australia for mass scale building construction. In recent times, these panels are being produced in India and the technology is being used in India.

The panel, manufactured to a thickness of 124mm under carefully controlled conditions to a length of 12m and height of 3m, contains cavities that may be unfilled, partially filled or fully filled with reinforced concrete as per structural requirement. Experimental studies and research in Australia, China and India have shown that GFRG panels, suitably filled with plain reinforced concrete possesses substantial strength to act not only as load bearing elements but also as shear wall, capable of resisting lateral loads due to earthquake and wind. GFRG panel can also be used advantageously as in-fills (non-load bearing) in combination with RCC framed columns and beams (conventional framed construction of multi-storey building) without any restriction on number of storeyes. Micro-beams and RCC screed (acting as T-beam) can be used as floor/ roof slab.

The GFRG Panel is manufactured in semi-automatic plant using slurry of calcined gypsum plaster mixed with certain chemicals including water repellent emulsion and glass fibre rovings, cut, spread and imbedded uniformly into the slurry with the help of screen roller. The panels are dried at a temperature of 275°C before shifting to storage area or the cutting table. The wall panels can be cut as per dimensions & requirements of the building planned.

It is an integrated composite building system using factory made prefab load bearing cage panels & monolithic cast-in situ RC infilled for walling & floor/roof slab, suitable for low rise to medium rise (single to 10 storeys) building.

## CLASSIFICATION

**Class – 1 – Water resistant grade** – GFRG panel for external walls, in wet areas and / or as floor and wall formwork for concrete filling.



**Class – 2 – General Grade** – GFRG panels for structural application or non-structural application in dry areas. These panels are unsuitable for use as wall or floor formwork and

**Class – 3 – Partition Grade** – GFRG panel as non-structural internal partition walls in dry areas only.



**APPLICATION**

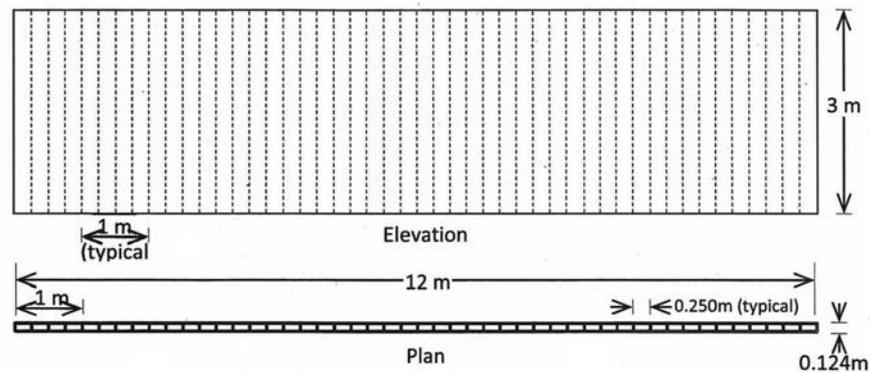
GFRG panels may generally be used in following ways:

- i) As load Bearing Walling – With cavities filled with reinforced concrete is suitable for multi – storeyed housing. In single or two storeyed construction, the cavities can remain unfilled or suitably filled with non – structural core filling such as insulation, sand, quarry dust, polyurethane or light weight concrete.
- ii) As partition walls in multi storeyed frame buildings. Panels can also be filled suitably. Such walls can also be used as cladding for industrial buildings or sport facilities etc.
- iii) As compound walls / security walls.
- iv) As horizontal floor slabs / roof slabs with reinforced concrete micro beams and screed (T-beam action). This system can also be used in inclined configuration, such as staircase waist slab and pitched roofing.

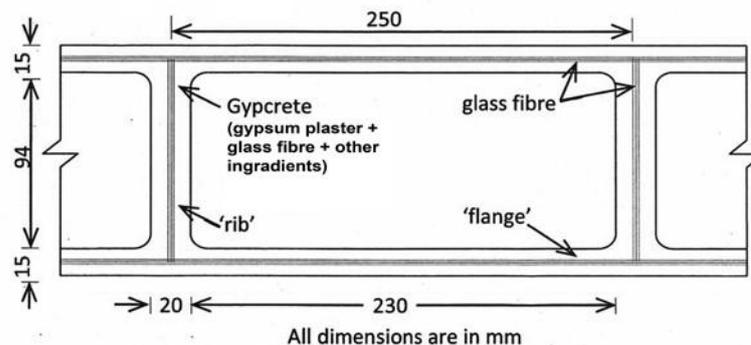
**DIMENSION**

Typical Dimension of GFRG building panel are 12.0m x 3.0m x 0.124m

Each 1.0m segment of the panel contains four cells. Each cell is 250mm wide and 124mm thick (as shown below)



Typical Cross Section of GFRG Panel



Enlarged view of a Typical Cell of GFRG Panel

## MECHANICAL PROPERTIES (UNFILLED PANELS) : TEST RESULTS

Mechanical Properties	Nominal Value	Remarks
Unit weight	0.433 kN/m <sup>2</sup>	
Modulus of elasticity, $E_g$	7500 N/mm <sup>2</sup>	
Uni-axial compressive strength, $P_{uc}$	160 kN/m (4.77 MPa)	Strength obtained from longitudinal compression / tension tests with ribs extending in the longitudinal direction.
Uni-axial tensile strength, $T_{uc}$	34 – 37 kN/m	
Ultimate shear strength, $V_{uc}$	21.6 kN/m	
Out-of-plane moment capacity, Rib parallel to span, $M_{uc}$	2.1 kNm/m	
Out-of-plane moment capacity, Rib perpendicular to span, $M_{uc}$ , perp	0.88 kNm/m	
Mohr hardness	1.6	
Out-of-plane flexural rigidity, $EI$ , Rib parallel to span	$3.5 \times 10^{11}$ Nmm <sup>2</sup> /m	
Out-of-plane flexural rigidity, $EI$ , Rib perpendicular to span	$1.7 \times 10^{11}$ Nmm <sup>2</sup> /m	
Coefficient of thermal expansion, $C_m$	$12 \times 10^{-6}$ mm/mm/°C	
Water absorption	1.0% : 1 hr 3.85% : 24 hrs	Average water absorption by weight % after certain hours of immersion.
Fire resistance : Structural adequacy / integrity / insulation	140/140/140 minutes	CSIRO, Australia/ IS 3809:1979
Sound transmission class (STC)	40 dB	ISO 10140-3:2010*

\* ISO 10140-3:2010 - Acoustics – Laboratory measurement of sound insulation of building elements – Part 3: Measurement of impact sound insulation

Source: GFRG/Rapidwall Building Structural Design Manual

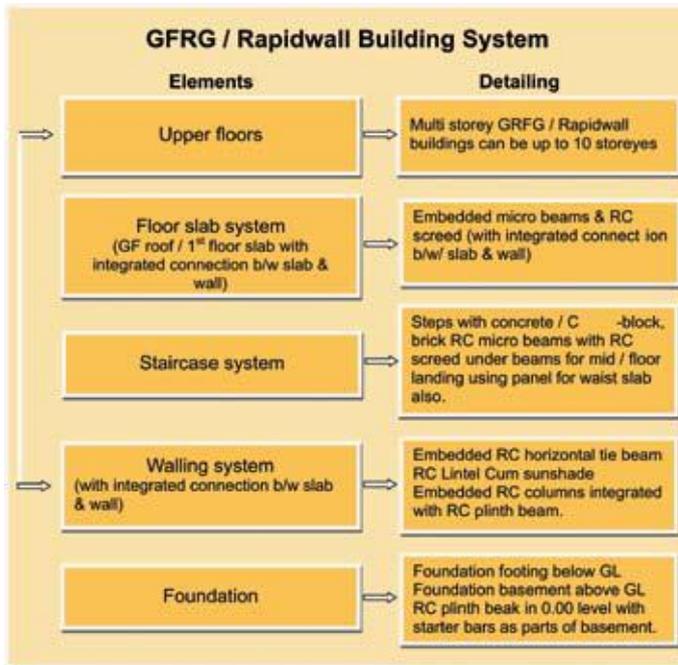
## DESIGN

The design capacities of GFRG panel is based on limit state design procedures, considering the ultimate limit state for strength design, treating the 3.0 m high GFRG panel as the unit material and considering the strength capacity as obtained from the test results. The design shall be carried out by considering all possible loads (as per relevant Indian Standards) to which the structure is likely to be exposed in its service life. It shall also satisfy the serviceability requirements, such as limitations of deflection and cracking. In general the structure shall be designed on the basis of the most critical limit state and shall be checked for other limit states.

Detailed design Guidelines are available in “Use of Glass Fibre Reinforced Gypsum (GFRG) Panels in Buildings - Structural Design Manual” prepared by IIT Madras and published by BMTPC. It may be obtained on request from BMTPC.

Experimental studies and research have shown that GFRG Panels, suitably filled with reinforced concrete, possess substantial strength to act not only as load bearing elements, but also as shear wall, capable of resisting lateral loads due to earthquake and wind. It is possible to design such buildings upto 10 storeys in low seismic zone. (and to lesser height in high seismic zone). However, the structure needs to be properly designed by a competent structural engineer. Manufacture of GFRG Panels with increased thickness (150 mm – 200 mm) with suitable flange thickness can facilitate design and construction of taller buildings.

The basis arrangement of GFRG Panel Building System is as follows:



## TRANSPORTATION

The GFRG panels are transported from factory to site, generally through trucks or trailers. The panels are kept in a vertical position using “stillages” so as to avoid any damage during transportation. The panels after reaching the site are taken out from trucks using cranes. Forklifts can be used for easier movement of panels.



## CONSTRUCTION

The foundation used for the construction is conventional and is designed generally as strip footing depending upon the soil condition.

For superstructure – plinth beams are cast all around the floor, where walls have to be erected. The superstructure is entirely based on prefabricated panels. The procedure mainly include fixing of wall panels and roof panels using mechanical means, preferably a crane and filling the required joint with reinforced cement concrete as per structural design.



Waterproofing is an essential requirement of the construction at different stages. Detailed guidelines for waterproofing are required to be followed during construction.

## LIMITATION

- The shorter span of slab (floor / roof) should be restricted to maximum of 5 m.
- The system is ideal if the same floor / roof is replicated for all floors in multi storeyed structure. For any variations,

a structural designer needs to be consulted.

- The panels are not suitable for curved walls or domes. In case it is essential, use masonry / concrete for that particular area.
- The electrical / plumbing system should be such that most of the pipes go through the cavities (in order to facilitate minimum cutting of panel)

## OTHER FEATURES

### Green Technology

It makes use of industrial waste gypsum, does not need any plastering, uses much less cement, sand, steel and water than conventional building materials. It consumes much less embodied energy and less carbon footprint.

### Reduced built area

Panels being only 124 mm thick, for the same carpet area, the built up area and the building footprint is much less than conventional buildings. This is particularly advantageous in multi storeyed mass housing.

### Versatility

Panels can be used not only as walls but also as floors, roofs and staircase.

### Speed of Construction

Using the system, the construction of a building is relatively faster as compared to the conventional building. One building of two storeyed (total 185 sqm with four flats) was constructed in IIT Madras in one month.

### Lightness of structures bringing safety against earthquake forces

These panels are very light weight (43 kg/m<sup>2</sup>). Even after filling some of the cavities with concrete, the overall building weight is much less, contributing to significant reduction in design earthquake forces and savings in foundation and overall buildings cost especially in multi – storeyed buildings.

## FEW BUILDING CONSTRUCTED IN INDIA

- Residential buildings at Udipi Karnataka owner Mr. Satish Rao, built by Harsha Pvt. Ltd., Udipi, Bangalore.
- Utility Building for Konark Railways at Madgao, South Goa, built by Harsha Pvt. Ltd., Udipi, Bangalore.
- Residential building at Udipi by Harsha Pvt. Ltd.
- 3 storey residential building at Calicut by NMS Rapidwall Construction Company, Calicut (2014).
- Two storeyed building at IIT Madras.
- Residential building at RCF Mumbai.
- Model house at Cochin.
- Demonstration houses (36 DUs) at Nellore, Andhra Pradesh.

## CERTIFICATION REFERENCES

- Performance Appraisal Certification PACs No. 1008-S/2011 issued to M/s Rashtriya Chemicals and Fertilizers Limited, "Priyadarshini", Sion, Mumbai.
- Performance Appraisal Certification PACs No. 1009-S/2012 issued by FACT – RCF Building Products Ltd., FACT Cochin Division Campus, Ambalamedu, Kochi.
- GFRG / Rapidwall Building Structural Design Manual, prepared by IIT Madras, published by BMTPC, New Delhi.
- Schedule of Item & Rate Analysis for GFRG Construction, BMTPC, New Delhi (*to be published*).
- IS 3809:1979 – Fire Resistance Test of Structures



## Light Gauge Steel Structural Systems





# Light Gauge Steel Framed Structures (LGSF)

*(Suitable for Low Rise to Medium Rise Structures)*

## ABOUT THE TECHNOLOGY

Light Gauge Steel Framed Structures (LGSF) is based on factory made galvanized light gauge steel components, designed as per codal requirements. The system is produced by cold forming method and assembled as panels at site forming structural steel framework of a building of varying sizes of wall and floor.

The basic building elements of light gauge steel framing are cold formed sections which can be prefabricated at site using various methods of connection. The assembly is done using special types of screws and bolts.

Cold formed sections are widely used in construction including residential floors, industrial buildings, commercial buildings, hotels and are gaining greater acceptance in the residential sector. LGSF is a well established technology for residential construction in North America, Australia and Japan and is gaining ground in India.

LGSF is typically ideal for one to three storey high buildings, especially for residential and commercial buildings. Due to its flexibility, fast construction and durability, this technology has great potential for countries like India.

LGSF can be combined with composite steel / concrete deck resting on light steel framing stud walls. Apart from having potential for mass housing, modular buildings can be used for long term temporary or permanent structures such as schools and classroom, military and civil housing needs, post – disaster relief structures and industrial buildings. Advisable maximum span for LGSF buildings should be 7.5 m.

## SPECIFICATIONS FOR THE SYSTEM

### Structural Section

**Main Section are Studs & Track Studs** serve as a general all purpose framing component used in a variety of applications including external curtain walls, load bearing walls, headers floors & roof joists, soffits and frame components.



**Track** is used as closure to stud and joists end as well as head and sill conditions. It is also used for blocking and bridging conditions.

Load bearing steel framing members shall be cold – formed to shape from structural quality sheet steel complying with the requirements of one of the following:

- i) ASTM A 653 / A 653 M -13 Grade 33, 37, 40 & 50 (Class 1 and 3) or
- ii) ASTM A 792 / A 792 M -13 Grade 33, 37, 40 & 50; or
- iii) ASTM A 875 / A 875 M – 13 Grade 33, 37, 40 & 50; or
- iv) Sheets, that comply with ASTM A 653 except for tensile and elongation with requirements, shall be permitted, provided, the ratio of tensile strength to yield point is at least 108 and the total elongation is at least 10 percent for a 5 mm gauge length or 7 percent for a 20 mm gauge length.

**Wall frame**

Consists of top track (U shape configuration) with a depth compatible with that of the studs of the same nominal size. Minimum height of track flanges shall be 19 mm.

**Load Bearing Walls**

C section studs with depth of 90 and 200 mm and thickness between 2.7 mm and 2.0 mm shall be provided at a distance of 300 mm / 400 mm / 610 mm to ensure efficient use of cladding material. Multiple studs are used at heavily loaded application such as adjacent to openings or in braced panels. C section with 94 x 50 mm is used for noggins.

Alteration shall be required for the local details at the head & the base of the wall to ensure that loads are adequately transferred without local deformation of the joists & studs.

**Non Load Bearing Walls**

It is similar to that of load bearing walls except that noggins and diagonal bracing are not required to stabilize the studs.

**Deflection Limit of Walls**

Suggested deflection limit for external walls subject to wind loading are as follow:

Full height glazing	Height / 600
Masonry wall	Height / 500
Board / reduced finish	Height / 360
Steel cladding	Height / 250
Other flexible Cladding	Height / 360

**Wall cladding**

Wall cladding shall be designed to resist wind load. Sheet has to be screwed to the joist / purlin with maximum spacing of 300 mm c/c. All the joints of sheet in longitudinal direction require a minimum lap of 150 mm in order to make them leak proof.

Following materials are generally used on wall cladding:



- Gypsum board conforming to IS 2095 (Pt. 1): 2011
- Heavy duty cement particle board conforming to IS 14862:2000.

### Bracing

Bracing and bridging shall have configuration and steel thickness to provide secondary support for the studs in accordance with the relevant specification for the design of Cold – formed steel structure of members.

### Floor frame

For speed of construction, floor joist may be pre-assembled to form floor cassettes. This works well for regular floor places but care shall be taken when the geometry of the building requires the cassettes to vary in size with location or when non – right angle corners are required. Resistant may be provided to the top flange of the joists by the flooring board. The floor should be designed for the combined effect of dead and imposed load.



The construction of a suspended floor comprising cold formed steel floor joists is similar to that for a floor using timber joists. The strength to weight ratio of light steel joist is higher than that of other material. Steel joists are stable and do not suffer, the long term problems of drying out, creep and Shrinkage. Joists are generally positioned at 300, 400 & 600 mm centres, depending on the spacing capabilities of the floor materials used.

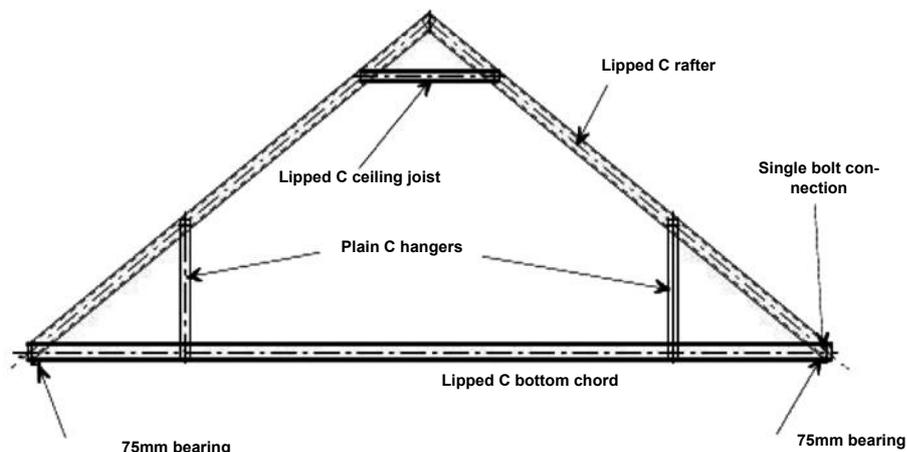
### Roof frame

Flat roof is made up of joists, where steel decking form a flat roof, a minimum fall of 1:4 should be introduced to ensure that any moisture runs off. To avoid local ponding to rain water, the pitch may need to be increased to overcome the effective reduction in roof angle caused by the deflection of long span roof purlin or decking.

### Roof truss

Use of Light Steel roof truss is economical for larger span building. In attic or open roof truss creates usable roof space, uses fewer components than Fink truss and provides an economical solution, since it utilizes the high strength of the steel members.

The trusses are placed at 600 mm maximum spacing and are battened and tiled in a conventional manner.



## Screws

Screws as per the details given below shall be used:

- Panel Assembly – Low profile screws
- LGS-LGS Wall panel to roof cassette – 12-14x15mm
- LGS to concrete – Tapcon screw 14-12x60mm Hex head
- Wire mesh = EPS board – SDS Hex head with Ceresin without washer
- HRS-LGS – Hex head
- CP board 6mm – WT 8 CSK Phillips
- Gypsum board – Flat head self-driven type
- Deck sheet/Wire mesh – SDS WT, CSK, Flat head

## Extended Polystyrene Panel

Shall be of minimum density of 15 kg/m<sup>3</sup>.

## Wire Mesh

Shall be made of 4 mm dia wire of UTs 480 MPa with spacing 150 mm x 150 mm or 1.4 m dia of spacing 40 mm x 40 mm.

## Shotcrete

Shotcrete when used shall be of minimum grade M 25 Grade of concrete.

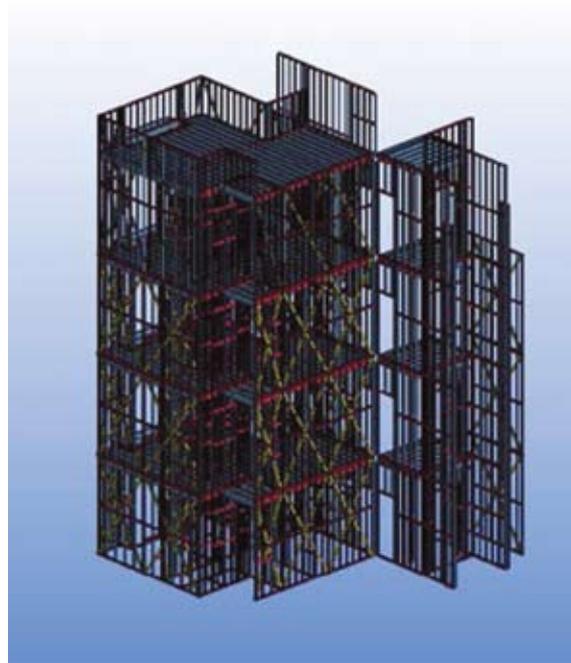
## DESIGN

The LGSS is designed based on provision of the following standards:

- Indian Standard IS 801: 1975 Code of Practices for use of cold formed and welded section and light gauge steel structural members in general building construction.
- British Standard BS 5950 (Part 5):1998 – Structural use of steel in Building Part 5 – Code of Practice for design of cold formed thin gauge structure.
- British Standard BS 5950 (Part 1): 2000 Structure use of steel work in Building Part 1 with loading requirement as per IS 875 (Part 1)
- Indian Standard IS 875 - Code of Practice for design loads  
Part 1 - Dead Loads - Unit Weights of Building Material and Stored Materials  
Part 2 - Imposed Loads  
Part 3 - Wind Loads
- IS 1893 (Part 1):2002 Criteria for Earthquake Resistant Design of Structures - Part 1 : General Provisions and Buildings

## MANUFACTURING

The sections are manufactured using Centrally Numerical Control (CNC) automatic four Pinnacle Roll Forming machine having production speed of 450-900 m/hr with very high precision.



## CONSTRUCTION

Foundations for light steel framing are essentially the same as for any form of construction, although dead loads applied by the light steel frame will be much lower than in the concrete or masonry construction.

Construction phases of steel buildings resembles the phases of conventional reinforced concrete buildings. The sections manufactured as per design are numbered properly. The profiles are sent to site either as profile or panellized parts, considering the distance of the construction site and transportation conditions. Profiles are assembled by trained assembly team at the construction site in line with the architectural plan. Only special studs are used during assembly, no welding is done. Once the assembly is done, the frame is filled with insulation materials (fibreglass, rockwool etc). Walls are then covered with standard boards or similar approved materials.

The sequence of construction comprises of foundation laying, fixing of tracks, fixing of wall panels with bracings as required, fixing of floor panels, fixing of roof panels, decking sheet, fixing of electrical & plumbing services and finally fixing of insulation material & walling panels.

Electrical Gas and plumbing, services are installed through pre-punched service holes in the web of the steel forms. Plastic grommets and silicon seals are used to fasten and protect wiring and pipes from corrosion and damage arising from vibrations

Electrical cables running within floor insulation layer in the separating floor construction should be protected with cartridge fuses or mini circuit breaker.

Wall panels are generally made by using heavy duty Cement Particle Board and Gypsum board. It can also be made using high density extended polystyrene core plastered from outside using wire mesh and chicken mesh. Galvolume sheet of appropriate thickness can also be used as cladding. This technology is certified by BMTPC under PACS.

## ADVANTAGE

LGSF is based on established system of light gauge steel structures and designed as per codal provisions with loading requirements as per Indian Standards. The merits of the system encompasses:

### **High Precision**

- Fully integrated computerised system with CNC machine provides very high accuracy upto 1 mm.

### **Structural**

- High strength to weight ratio. Due to low weight, significant reduction in design earthquake forces. Chance of progressive collapse are marginal due to highly ductile and load carrying nature of closely spaced studs/joists.

### **Speed in Construction**

- Construction speed is very high. A typical four storeyed building can be constructed within one month.



**Saving in foundation**

- Structure being light, does not require heavy foundation.

**Mobility**

- Structural element can be transported any place including hilly places to remote places easily and structure can be erected fast.
- Structure can be shifted from one location to other without wastage of materials.

**Environment friendly**

- Steel used can be recycled when required.

**CERTIFICATION - OTHER REFERRED STANDARDS**

IS 801: 1975	Code of Practices for use of cold formed and welded section and light gauge steel structural members in general building construction.
IS 2095 (Part 1) : 2011	Specification for Gypsum Plaster Boards - Part 1 Plain Gypsum Plaster Boards
IS 14862 : 2000	Specification for Fibre Cement Flat Sheets
ASTM – A653/ A 653 M -13	Specification for steel sheet, zinc coated (galvanized) on zinc – iron alloy coated by hot dip process.
ASTM – A 792/792 M -13	Specification for steel sheet, 55% aluminium zinc alloy coated by hot dip process
ASTM – A 875/875 M -13	Specification for steel sheet, zinc 5% aluminium alloy coated by hot dip process.

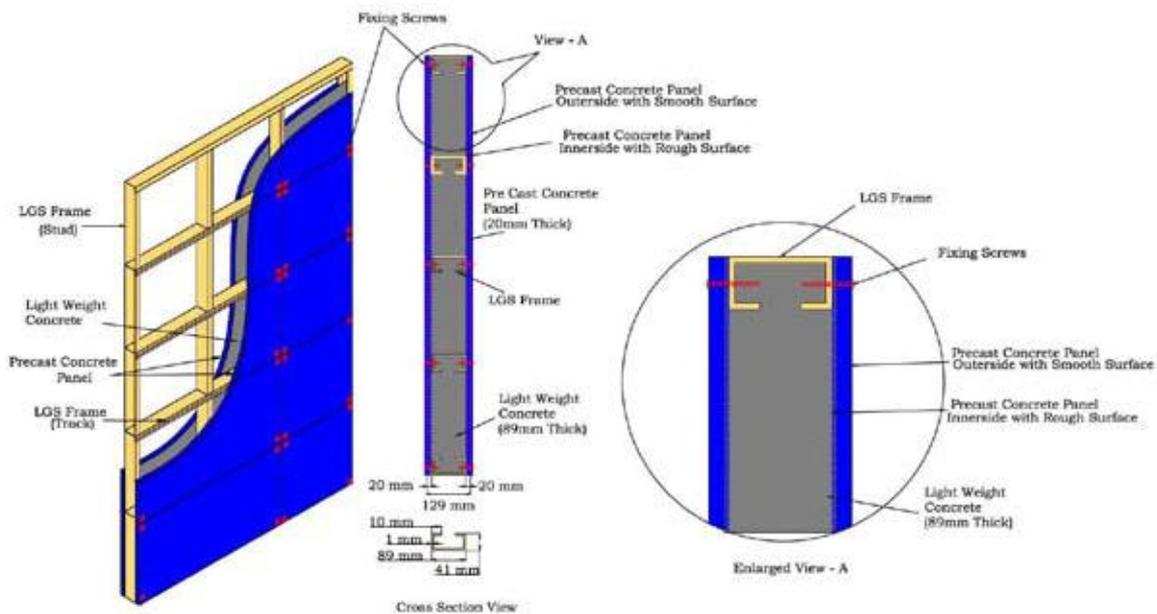


# Light Gauge Steel Framed Structure with Infill Concrete Panel (LGSFS-ICP) Technology

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

Light Gauge Steel Framed Structure with Infill Concrete Panels (LGSFS-ICP) Technology is an innovative emerging building and construction technology using factory made Light Gauge Steel Framed Structure (LGSFS), light weight concrete and precast panels. The LGS frame is a “C” cross-section with built in notch, dimpling, slots, service holes etc. produced by computerized roll forming machine. These frames are assembled using metal screws to form into LGSF wall and roof structures of a building. Provisions for doors, windows, ventilators and other cutouts as required are incorporated in the LGSFS.



**Fig.1 Structural Details of LGSFS-Infill Concrete Wall**

The LGS frames are manufactured in a factory and assembled into LGSF wall structures and then transported to the construction site and erected wall by wall on a pre-built concrete floor as per the floor plan of the building. Steel reinforced concrete panels of size 610 mm x 305 mm x 20 mm thick are manufactured at factory and transported to site. These panels are fixed on either side of the LGSFS wall using self-drilling/tapping screws to act as outer and inner faces of the wall leaving a gap between them. This gap is then filled with light weight concrete using a special mixing and pumping machine. Electrical and plumbing pipes/conduits are provided in the service holes of the LGSFS before concreting is done. Self-compacting concrete is mixed and pumped into the gaps between two panels. The concrete flows and fills the gap and provides adequate cover to the LGS frames and joints. The concrete shall also adhere to the concrete panels. After curing, LGSFS with in-fill concrete and panels (LGSFS-ICP) forms a monolithic sandwich composite wall structure with thermal and sound insulation properties.

The roof structure of LGSFS-ICP building is constructed using metal/plastic formwork system with steel reinforced concrete as per structural design. Standard procedures are employed to concrete the roof slab. After curing for 96 h, the formwork is de-moulded and the wall and roof are putty finished. Door and window frames are fixed to the

LGS frames and shutters fixed with necessary accessories. Finishing work such as laying floor tiles, fixing electrical and sanitary fixtures and painting is carried out using standard conventional methods.

After completion of ground floor, first, second and third floors of the building is constructed using the same procedure that of the ground floor. The staircase, chajja and parapet walls of the building are also constructed using LGSFS-ICP Technology.

## MATERIAL REQUIREMENTS

### 1. Raw Materials

- i. LSG Coil of galvanized steel shall conform to IS 277:1992.
- ii. Fasteners and Connectors
  - (a) Frame assembly screws: Shall be galvanized steel screws self-drilling type of size 10 x 25 mm having Truss-head and shall be as per ASTM C 1513-10.
  - (b) Wall Erection Screws: Shall be galvanized steel screws self-drilling type of size 8 x 25 mm having Hex Washer head and shall be as per ASTM C 1513-10
  - (c) Precast Concrete Panels Fixing Screws: Shall be of galvanized steel screws self-drilling type of size 8 x 50 mm having CS head and shall be as per ASTM C 1513-10.
  - (d) Wall and Foundation Anchor Bolt: Shall be of high tensile galvanized steel of size 10 x 100 mm/ 10 x 150 mm and 12 x 100 mm/ 12 x 150 mm and shall be as per ASTM C 1513-10.
- iii. Foaming Chemicals: Shall be made from protein foam concentrate and FC-lite foaming agent
- iv. Gypsum plaster board: Shall be of size 1830 mm x 1220 mm and 12.5mm to 20 mm thick and shall conform to IS 2095 (Part 1):2011
- v. Water Proofing Treatment: Shall be using integral waterproofing compound as per IS 2645:2003
- vi. Putty: Shall be as per IS 63:2006
- vii. Ordinary Portland cement (OPC) shall be of 43/53 grade as per IS 269:2015
- viii. Sand and Aggregates shall be as per IS 383:2016
- ix. Reinforced Steel: Shall be as per IS 1786:2008
- x. Structural steel: Shall be as per IS 800:2007
- xi. Steel fiber: Shall have length of 60 mm & dia. 0.75 mm and shall be as per EN 14889-1:2006
- xii. Glass fiber: Shall be made from Fiber mesh 303 E3 and shall be as per EN 14889-2:2006

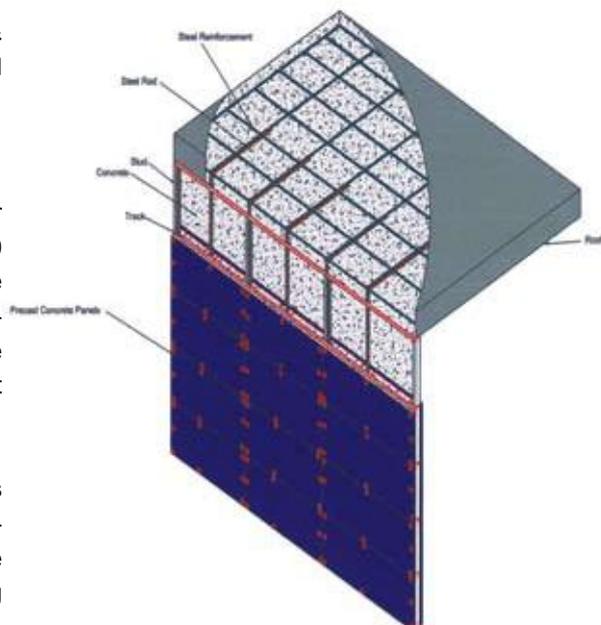
### 2. Light gauge steel frame/ structure

The Light gauge steel frame structure (LGSFS) comprises of “C” cross section studs (vertical members) and tracks (horizontal members) frames assembled together by means of mechanical screws. The joints between wall & roof junctions/wall to wall junctions are designed as rigid joints

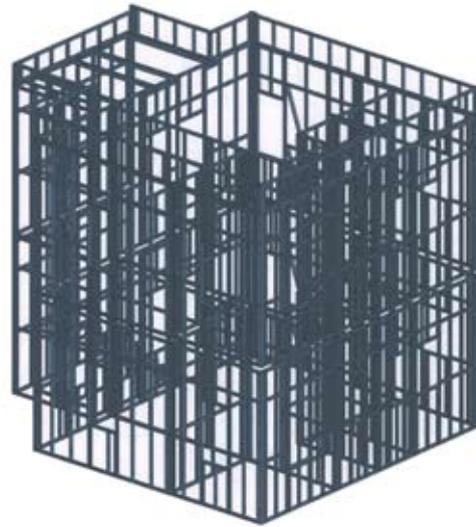
### 3. Precast concrete panels

Precast Concrete Panels are used as facing sheets for construction of walls. Self-compacting concrete of M20 grade is used. Metal modes, concrete mixing machine and vibration tables are used for manufacturing the panels. The panels are designed to withstand the concrete weight pumped in between the gap of the panels without failure and buckling.

The steel reinforced precast concrete panels (PCP), has one side rough surface and the other side smooth surface. The PCP's are fixed on either side of Light Gauge Steel Frame Structures (LGSFS)–studs and tracks using



mechanical fasteners. While fixing, the rough side of the panels are facing inside and smooth side is facing outside. Each PCP is fixed with 6 screws. Light weight concrete is pumped in to the gap between two PCPs. The concrete bonds with the rough surface of the panels. Thus, the LGSFS and PCPs are firmly joined to make a monolithic steel–concrete structure.



#### **4. Concrete/light weight concrete**

The concrete used for infill wall is light weight and free flow. The density shall be 1500-1800 Kg/m<sup>3</sup> after adding/mixing foam or EPS beads as per the design mix developed by the agency. The light weight concrete shall be of grade M5 to M10, as required. The light weight concrete shall be mixed and used at site.

### **MANUFACTURING PROCESS**

The manufacturing process of the constituents of LGSFS-ICP system is as follows:

#### **1. Light Gauge Steel Frame Structure**

Cold formed Light gauge steel frame super structure is manufactured out of min. 0.95 mm pre-treated factory finished hot dipped GI high tensile steel sheet (AZ 150 GSM Aluminium zinc alloy coated steel and having yield strength of 550MPa) which shall be as per IS 800:2007 and conforms to AISI specification and IBC 2009. The wind loads shall be as per IS 875 (Part 3):2015. The framing section is cold form ‘C’ type of 0.55 mm to 1.55 mm thickness in required length as per structural design requirements, duly punched with dimple slots at required locations as per approved drawings. The slots shall be along center line of the web and shall be placed at 250 mm min. away from both edges of the member. The frame is supplied in specified dimensions and fastened with metal strip of 25 mm x 25 mm x 0.50 mm to both adjoining walls.

#### **2. Precast Concrete Panels**

Precast concrete panels are manufactured using cement, sand, aggregates, glass & steel fibers, water and admixtures using a design mix and curing cycle developed by the agency. It is steel fibre reinforced precast concrete panel. It gets strength as steel reinforced concrete.

The overall dimensions of the panel are 1220 mm x 610 mm x 20 mm thick and the weight shall be around 36 kg. The panels are designed to have smooth or textured outside surface and rough inside surface. The panels are also designed to withstand green concrete load of 200 kg without failure and deflection shall be less than 1.0 mm.

The concrete used for the panels shall be of grade M20 having water absorption less than 8%.

Mix ratio of light weight aggregate for 1.0 cu.m is as follows:

Cement = 300 kg

Sand = 400 kg

Flyash = 300 kg

6mm-8mm Aggregate = 1350 kg

PPfibre + steel fibre = 4.14 kg

Water = 150 kg

Admixtures = 150 ml

#### **3. Concrete/Light Weight Concrete**

The wall or the roof is constructed using M20 grade concrete and M5 –M10 grade light weight concrete. The concrete used is light weight and free flow. The light weight concrete is mixed and used at site. The concrete/light weight concrete is pumped into the gap between the panels.

#### **4. Assembly/Connecting Screws and Anchoring Bolts**

LGS frames are assembled together to fabricate LGSF structures using self-taping screws. The LGSF structures such as wall, roof, truss and staircase are connected by using special screws which shall conform to ASTM C 1513. The anchoring boards used for connecting LGSF wall structure to the foundation shall conform to relevant Indian/American Standards.

#### **APPLICATIONS**

The technology is used for construction of Low rise residential buildings up to G+3 storey – EWS, LIG & MIG houses, Schools, Health centers, Community centers, independent houses and rehabilitation buildings.

#### **INSTALLATION/ CONSTRUCTION OF LGSF STRUCTURES**

##### **1. Construction of Foundation and Plinth**

The foundation and plinth is constructed confirming the floor plan of the building. The foundation depth, width, steel reinforcement, grade of concrete etc. is determined by structural analysis report prepared on the basis of soil condition, height of building, number of storeys, special live load requirement, if any.

##### **2. Assembly of LGS Frames and Construction of Wall**

The LGS frames manufactured using numerically controlled roll forming machine using CAD design shall be transported to the construction site. The frames shall be assembled into wall structure. All the wall structures shall be connected together one by one as per the building plan by connecting screws. The wall position shall be marked on the floor and the wall structure placed on the marking. After completing the same, straightness, square and the levels shall be checked by magnetic spirit level. The bottom track shall then be connected with the floor using anchor bolts at every 600 mm bolts.

##### **3. Fixing of Pre-cast Panels**

The precast concrete panels shall be fixed on the LGSF wall structure on studs and tracks by using metal screws. The panels shall be fixed first on the outer side of the LGSFS wall. Electrical/plumbing pipes/conduits shall be fixed as per the electrical and plumbing layout. After completion, the panels shall be fixed inside the LGSFS walls and allocations for electrical and plumbing cutouts shall be marked on the panel.

##### **4. Concrete Mixing and Pumping**

Self-compacting concrete of required grade/light weight concrete shall be mixed using concrete mixing machine and then pumped into the gap between two panels using a special pumping unit. Care shall be taken to pump the concrete gradually and uniformly on all the walls. Concreting shall be done till the gap is completely filled up to the top of the LGSFS wall.

##### **5. Construction of Roof Slab**

The roof slab of the building shall be constructed by using metal/plastic shuttering and conventional concreting. Necessary steel reinforcement as per design shall be provided over the formwork and concreting shall be done to required thickness. Balcony and chhajja etc., wherever required shall also be constructed using formwork. After curing the slab, shuttering shall be removed and bottom of the roof slab putty finished.

##### **6. Reinforcement**

Deformed steel bars of 8mm/10mm dia. as per design shall be used.

##### **7. Staircase and Railing**

Staircase and balcony railing shall be fixed using conventional methods.

##### **8. Fixing Electrical and Plumbing Fixtures**

The panels shall be cut at the marked locations for fixing electrical and plumbing fixtures.

##### **9. Fixing of Doors, Windows & Ventilator Frames and Shutters**

The doors, windows & ventilator frames shall be fixed on the cutouts provided in the LGSFS. The frames shall be

made of WPC, uPVC and other materials, as required. Thereafter, the doors and windows shutters shall be fixed to the frames. The shutters shall be made of glass fibre/ HDF sandwich composite materials.

#### **10. Fixing Floor Tiles**

Floor tiles of desired quality and make shall be fixed to the floor, as required. Similarly, wall tiles of desired quality and make shall be fixed in the kitchen, bath and toilet using conventional methods, as required.

#### **11. Surface Finishing and Painting**

Cement based putty shall be applied on the outside and inside walls and then painted with desired colour.

### **SPECIAL FEATURES**

#### **Structural Stability**

Due to low weight, significant reduction in design earthquake forces. Chance of progressive collapse are marginal due to highly ductile and load carrying nature of closely spaced studs/joists.

#### **Durability**

Buildings shall be designed as per codal provisions of IS 456.

#### **Behavior in earthquake**

The buildings shall be designed for loads in accordance with IS 875 (Part 1 to 5) and IS 1893 (Part 1).

#### **Behavior in wind**

The wind loads shall be as per IS 875 (Part 3).

#### **Fire Safety**

During fire performance oriented test, it was observed that there was some minor cracks on the surface of all the walls.

#### **Rain**

During the ponding on roof slab for 24 hours, no dripping or leakage of water through roof slab or drop patches were observed on underside of the roof slab.

During rain simulation of external face of the wall by jetting for 12 hours, no leakage of water, dampness or sweating were observed on inner face of the wall.

#### **Thermal Performance**

There was a reduction in temperature upto 4°C inside the unit indicating that it has got a good thermal comfort.

#### **Acoustic Performance**

The unit has got a good acoustic comfort.

#### **Light weight**

Weight of the LGSFS-ICP building is about 20-30% lighter when compared to conventional building thereby resulting in material and energy savings.

#### **Limitation of Use**

- LGSFS-IPC Technology may be used for construction upto G+3 storey Buildings only.
- For more than G+3 storey buildings, hybrid construction methods shall be used.

#### **Critical Details**

- 10 mm thick plaster on external walls shall be provided to take care of water proofing.
- Guard bars and wooden/steel windows shall be provided. Aluminium sliding windows shall be avoided.
- Sun shades shall be provided for all windows/external doors as per design.

**WORKS COMPLETED**

1. Police Constable Quarters (G+1) building for Karnataka State Police Housing Corporation Ltd., Bangalore in 2012.

**CERTIFICATION**

Performance Appraisal Certificate No. 1028-S/2016 issued to M/s Society for Development of Composites, Bangalore by BMTPC.

**STANDARDS/REFERENCES**

- Design and Construction of “2 Police Constables Quarters (G+1) building for Karnataka State Police Housing Corporation Ltd., Bangalore” by the manufacturer
- Technical Report on “Light Gauge Steel Frame Structure with Infill Concrete Panels for Fast Tack and Disaster proof Housing”
- Structural Analysis Report for “G+2 storey building constructed using LGSFS-ICP Technology” by M/s Nagesh Consultants, Bangalore
- IS 277:2003 – Specifications for Galvanized Steel Sheets (Plain & corrugated)
- IS 383:2016–Specifications for fine and coarse aggregates for concrete
- IS 456:2000 –Code of practice for Plain & Reinforced concrete
- IS 800:2007 – Code of practice for general construction in steel
- IS 801:1975 – Code of practice for use of Cold Formed Light gauge Steel structural members in General building construction (First Revision)
- IS 875 (Parts 1,2,4&5):1987 – Code of Practice for Design Loads (other than earthquake) for buildings & structures
- IS 875 (Part 3):2015 – Code of Practice for Design Loads (other than earthquake) for buildings & structures
- IS 1786: 2008–Specifications for high strength deformed steel bars and wires for concrete reinforcement
- IS1893:2002 – Criteria for Earthquake Resistant Design of Structures (Part 1) - General Provisions and Buildings
- IS 1904:1986 – Code of Practice for design and construction of foundations in soils: General requirements.
- IS 2062:2011– Specifications for hot rolled medium & high tensile structural steel
- IS 2095 (Part 1):2011–Specifications for Gypsum plaster boards– plain
- IS 9012:1978 – Recommended practice for shotcreting
- ASTM C1513-10 – Standard specification for steel tapping screws - cold formed steel framing connections
- EN 14889-1-2006 – Fibre for concrete, steel fibres - definitions, specifications and conformity
- EN 14889-2-2006 – Fibre for concrete, polymer fibres - definitions, specifications and conformity

## Steel Structural Systems





# Factory Made Fast Track Modular Building System

*(Suitable for Low Rise to High Rise Structures)*

## ABOUT THE TECHNOLOGY

Factory Made Fast Track Modular Building System comprises of prefabricated steel structure with different walling components. About 70 percent of the work is done in the factory with minimal usage of concrete, which enables system to deliver the building within a few days of work at site. The steel moduled are pre-fitted with flooring, ceiling tiles, electrical and plumbing fittings. The assembled steel modules are transported to the site for installation which is done using crane and other required machineries. Once all the components are assembled and erected at site, factory made 3-D Expanded Polystyrene (EPS) wall panels are fixed and shotcreting is done from both sides.

The uniqueness of system is the efficient and simultaneous activities of site preparation and building construction in factory, rather than two phased customary process.

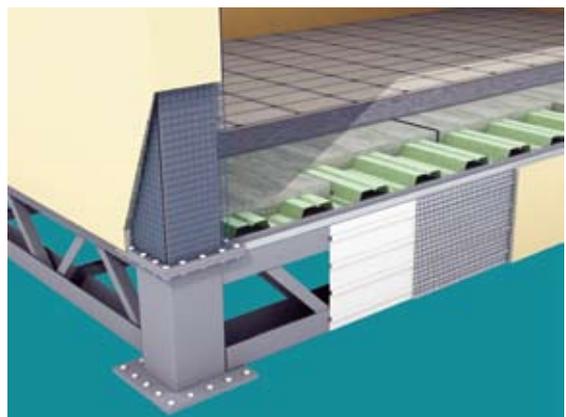
## DETAILS OF STRUCTURE

### Foundation

Foundation shall be either strip or raft as per site conditions. The design and construction of foundation shall be carried out as per IS 1904:1986 and other related Indian Standards, as applicable.

### Steel Structure

The structure consists of steel pillars, modules and other components designed for worst loading conditions as per IS 800:2007 and IS 801:1975. In addition, the structure shall be designed in accordance with IS 1893(Part 1) & IS 875 for seismic and wind load considerations, both individually and in combination, as applicable. Steel pillars shall be made by welding MS plate of 16mm thickness and steel tubes of size 200mm x 200mm having wall thickness varying from 3mm to 16mm depending upon the number of floors. The smaller pillar is fixed with sub-assemblies for modules. All the columns shall be checked for their safety and computations shall be done for the same for satisfying requirements of IS 800 and IS 801.



### Steel Staircase

Steel staircase shall be designed and fabricated using HR steel sheet of thickness 3mm / 4mm with MIG welding process. Staircase is pretreated for surface cleaning using steel cleaning agent and painted with two coats of anti-corrosion primer and fire proof paint.

### Flooring

The floor is made up of deck sheet and wire mesh of size 100mm x 100mm x 3mm thickness. The deck sheet is fixed on the modules ready after providing with utilities like plumbing and electrical etc. Flooring, roofing and ceramic tiles are fixed as per relevant specifications.

### Walling

Walling is completed by using factory made EPS based wire mesh welded 3D panels. The panels are easy to install and manufactured using insulated polystyrene core covered on both sides by hot GI coated round wire square mesh, duly connected by 33 connectors per m<sup>2</sup>.

### Door and Window

The structure can accommodate any types of door and window frames and panels. Metal door frame pressed from 1.2/1.5mm thick galvanized steel sheet with mitered and welded construction may also be fixed. The doors used, however, should satisfy the performance requirements as per relevant Indian Standards. For doors not covered by any Indian Standards, third party certification may be adopted. Performance characteristics for dimensions & squareness, general flatness, impact indentation, flexure test, edge loading, shock absorption, buckling resistance, slamming and misuse as per relevant parts of IS 4020:1998 shall be required before accepting any doors for use.

### Utilities

- i) Once the steel structure module is ready for electrical and plumbing work as per the drawings, these utilities are planned & executed based on the services/utilities layout design and requirement of the floor area.
- ii) After completion of services/utilities, the module is covered with deck sheet. Wire mesh and MS studs of required size are fixed on the deck sheet before laying of PCC flooring. After decking, PCC of M25 grade is laid for a total depth of 76mm and flooring tiles are fixed wherever required depending upon utilization of area. With all fittings the module is ready for shifting to the site.



## TRANSPORT OF MODULES AND PILLARS ALONG WITH ACCESSORIES

All the handling/transportation at site for erection are done by means of mechanical equipments such as tower & mobile cranes and trucks etc. Due care should be taken to avoid any damage to these modules, pillar and other elements. Special lifting points are provided in these modules so that handling stresses are kept to a minimum. Transportation are carried out in mainly two stages:

- i) From manufacturing plant to stacking yard.
- ii) From stacking yard to erection site. The transportation is carried out by using trucks of desired capacity and length. Erection are carried out by cranes of suitable capacity at site.

## PERFORMANCE EVALUATION

### Structure

Seismic Performance Evaluation of a G+7 CRC framed structure model for ground motion compatible to Seismic Zone V was performed at SERC, Chennai and found to be satisfactory.

### Walling Component

Evaluation on the behavior of reinforced EPS Panel under flexural and Axial Compression load on 100 mm and 150 mm thick panels were satisfactory. Other performance characteristics are:

Thermal transmittance of Single Panel	0.537 w/m <sup>2</sup> k
Acoustic Behavior	37 dB (noise reduction)
Water Penetration	No penetration after 3h
Resistance to impact with softbody and hardbody	Impacts of 90 & 1200 J –No crack

## CERTIFICATION

Under Performance Appraisal Certification Scheme, PAC No. 1011-S/2013 has been issued for the system to M/s Synergy Thrislington, A1 Phase- I, Industrial Area, Mohali.

## STANDARDS/REFERENCES

- Performance Appraisal Certificate PAC No. 1011-S/2013, issued by BMTPC, New Delhi
- Inspection Report of the visit for Performance Appraisal Certification.
- Report of Seismic Evaluation of Model of G+7 CRC framed structure for a ground motion compatible to zone V spectrum by SERC, Chennai.
- IS 800:2007 - General Construction In Steel - Code of Practice
- IS 801:1975 - Code of Practice for Use of Cold Formed Light Gauge Steel Structural Members In General Building Construction
- IS 875(Part 1):1987 - Code of Practice For Design Loads (Other Than Earthquake)For Buildings And Structures Part 1 Dead Loads - Unit Weights of Building Material And Stored Materials (Incorporating IS 1911 : 1967)
- IS 875(Part 2):1987 - Code of Practice for Design Loads (Other Than Earthquake) For Buildings And Structures: Part 2 Imposed Loads
- IS 1893(Part 1):2002 - Criteria for Earthquake Resistant Design of Structures - Part 1 : General Provisions and Buildings
- IS 4020(Part 1 to 16): 1998 - Door Shutters - Methods of Tests
- SP 7:2016 - National Building Code of India 2016.

# Speed Floor System

(Suitable for Low Rise to High Rise Structures)

## ABOUT THE TECHNOLOGY

The Speed Floor System is a suspended concrete flooring system using a roll formed steel joist as an integral part of the final concrete and steel composite floor. It is essentially a hybrid concrete/steel tee-beam in one direction and an integrated continuous one-way slab in other direction. The joists of different depths are manufactured from pre-galvanized high tensile steel in a one pass roll former, where it is roll formed, punched, pressed and slotted in a fully computerized machine. The joist depth and the concrete thickness are varied depending on the span, imposed loads and other functional considerations. The Speedfloor composite floor system is suitable for use in all types of construction. The Speedfloor joists are designed and custom manufactured to suit particular job conditions.



## DESIGN

The design of the speed floor system is based on NZS 3404 (Part 1 &2), AS/NZS 4600 and the Australian Composite Standard AS 2327 (Part-I). The design load shall be taken as prevalent in IS 875 (Part 1 & 3). Earthquake forces shall be taken in accordance with IS 1893 (Part-1).

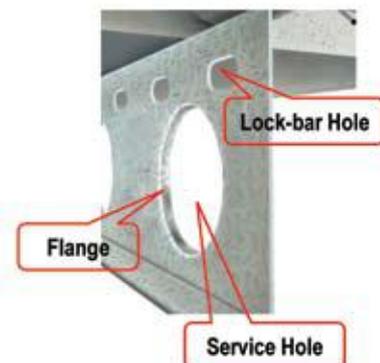
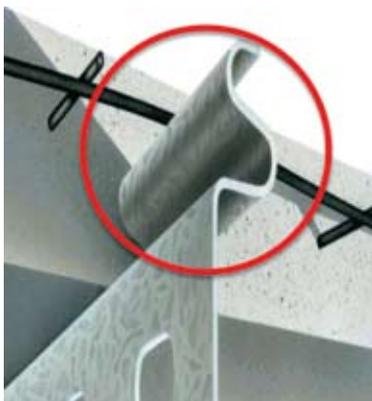


The section properties and design parameters are calculated from the section geometry, supplementary full scale tests and finite elements analysis.

## THE JOIST

The joist is manufactured from G 350 Z 275 pre-galvanized steel conforming to AS 1397:2001. Size may be any one of the following i.e. 200mm, 250mm, 300mm, 350mm and 400mm, depending upon the design requirements. Concrete thickness may be 75mm or 90mm as required.

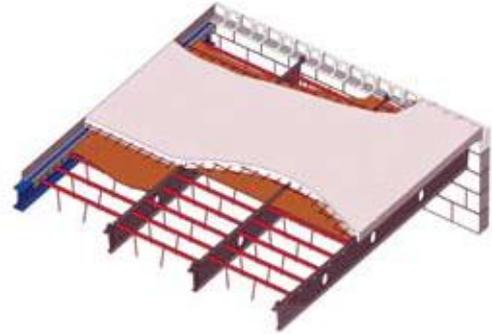
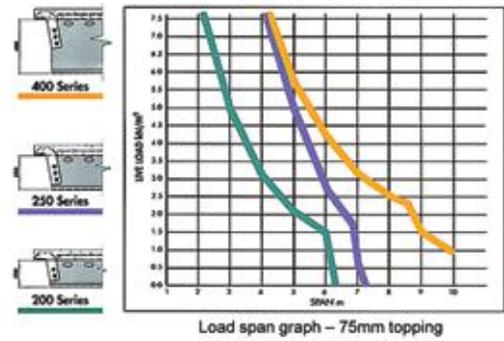
The joist weight vis-à-vis the depth are given below:



Depth (mm)	Weight (kg/ In m)
200	9.41
250	10.59
300	11.76
350	12.94
400	14.12

The **top section** of the joist is embedded in concrete and has following functions:

- It is the compression element of the non-composite joist during construction
- It is a 'chair' for the welded mesh or the reinforcement which develops negative moment capacity in the concrete slab over the joist
- It locks in and supports the slab shuttering system (lock bar and plywood forms)
- It becomes a continuous shear connector for the composite system. The bottom section of the joist acts as a tension member both during the construction phase and when the joist is acting compositely with the slab.



The **mid section** or web of the joists has the flanged service hole and the lock-bar hole punched into it. The flanging of the service hole provides stability to the web and services can pass through without requiring protection from the sharp edges of the punched material.

The **bottom triangular** section of the joist acts as a tension member both during construction phase and when the joist is acting compositely with the slab.



### THE LOCKBAR

The lockbars support the temporary plywood formwork between the joists during construction. They shall be spaced approx. 300mm apart and engage in the slotted holes punched in the top section of the joist. They also maintain the exact spacing of the joists.



The standard lockbars when installed will position the joists 1230mm, 930mm or 630mm apart. There are also special adjustable lockbars that will position the joists in increments of 50mm from 330mm to 1530mm. Other type of lockbars are provided for special situations such as cantilevers or lowered soffits.

### TEMPORARY PLYWOOD FORMWORK

High density paper overlaid 12mm shuttering plywood conforming to IS 4990:2011 or equivalent is used as formwork to produce a good finish to the underside of the slab. The rigid plywood sheets are used in conjunction with the lockbars and when locked in place, provide lateral stability to the entire Speedfloor system during the construction phase.

### REINFORCING MESH

Welded reinforcement mesh made of 8mm dia bar ( $f_y$  415 N/m<sup>2</sup>) placed @ 200mm c/c in both directions, is laid and tied into place. No chairs are required as it is held off the plywood forms by the top section of the joist, which becomes embedded in the concrete.

## CONCRETE

- i) Minimum grade of concrete shall be M25 as per IS 456:2000. It should preferably be batched at 60mm and super plasticized to 110mm slump to provide good placement and shrinkage characteristics. A curing compound should be used and an expanding agent may be introduced in consultation with the engineer to further control shrinkage during the curing period.
- (ii) The concrete should initially be placed evenly and continuously over the area to be formed. Special attention should be given to ensure the concrete is screened and finished to the specified thickness so that designed deflections are achieved in the Speedfloor joists and the supporting structures.
- (iii) In structures for carparking, an expanding agent is generally used to reduce the effect of shrinkage during initial cure and a curing compound is used to help control the curing process.

## ACCESSORIES

### **Edge angles**

A standard edge form is available in two heights – 75mm & 90mm. Special heights and specially shaped edge angles may be manufactured but would require longer lead times.

### **Jointers**

Precut sections of galvanized sheet steel may be provided to overlay joints in the ply to ensure they are flush and remain well supported while the concrete is poured.

### **Lockbar Hanger Angles**

A galvanized steel angle with pre-punched lockbar holes is used for situations where the lockbars need support on slab edges parallel to the joists.

## LIMITATIONS

The system is used as framed steel structure in all types of construction for laying RCC roof.

Maximum length of joist which can be used is 10m.

## DURABILITY

The technology provider shall provide necessary structural warranty ensuring durability of the system to the user, on demand.

## INSTALLATION PROCESS

Installation process is as follows:

- (i) Lightweight bundles of joists is lifted into position and then individual joists are placed by hand.
- (ii) Speedfloor joists are generally placed at 1250 mm c/c.
- (iii) Joists are held in place using the lockbars which slip into slotted holes.
- (iv) The lockbars is placed at 300mm apart to support plywood formwork. The propping is not required.
- (v) Full sheets of 12.5mm plywood formwork is to be laid from above creating a working platform. Cam action of lockbars secures plywood.
- (vi) Mesh is placed on top section of joist thereby embedded in the concrete poured thereafter.
- (vii) After three days of concreting, lockbars and plywood are removed from the underside revealing a clean surface ready for services or a fire rated suspended ceiling.



## MAINTENANCE REQUIREMENTS

Speedfloor is a composite floor system using both steel and concrete. The two materials must be treated and maintained separately.

**Steel :** If the joists are in a clean and dry environment, they may not require any maintenance. If it is exposed to aggressive environment, they shall require maintenance to ensure that the expected performance is achieved. Guidelines given below should be followed for maintenance

- a) Keep surfaces clean and free from continuous contact with moisture, dust and other debris.
- b) Periodically inspect the joists for any signs of corrosion. Remove any by-products of the corrosion by mechanical means and spot prime the exposed steel substrate with an appropriate steel primer. Repaint the area using an appropriate paint.

**Concrete:** During the service life of the Speedfloor system, if any cracks appear in the concrete floor, they should be filled using an epoxy injection grout or equivalent, to completely close the crack and prevent moisture ingress.

For detailed Installation process, manufacturer's Installation Manual shall be referred.

## APPLICATIONS

The Speed floor composite flooring system is suitable for use in all types of construction including:

- Steel frames structures
- RCC frame buildings
- Poured insitu or precast concrete frames
- Light gauge steel frames
- Conventional Structural brick wall constructions etc

The range of end uses include :

- General individual Houses
- Multi-storey residential blocks
- Single and multi-storey retail developments
- Mezzanine floors
- Car parks and storage buildings
- Multi-storey office complexes etc.



## STANDARDS/REFERENCES

IS 277:1992	Specifications for Galvanized Steel Sheets (Plain & Corrugated)
IS 456:2000	Code of Practice for plain & reinforced Concrete (Fourth revision)
IS 875 (Parts 1 to 3):1987	Code of Practice for Design Loads (other than earthquake) for buildings & structures
IS 1893 (Part-1):2002	Criteria for Earthquake Resistant Design of Structures - Part-1: General Provisions and Buildings
IS 2062:2011	Specifications for hot rolled medium & high tensile structural steel
IS 11384:1985	Code of Practice for Composite Construction in Steel and Concrete
AS/NZS 1170-2 (Parts 0 & 2) : 2002	Structural Design Actions—General principles and Wind actions
AS 2327(Part1):1996	Design of simply supported Composite structures
NZS 3101(Part1):2006	Design of Concrete Structures
NZS 3404 (Part1):1997	Design of Steel Structures
AS/NZS 4600:2005	Design of Cold Formed Steel Structures
AS/NZS 4671: 2001	Specifications for Steel reinforcing materials



## Precast Concrete Construction Systems





# Waffle Crete Building System

(Suitable for Low Rise to Medium Rise Structures)

## ABOUT THE TECHNOLOGY

Waffle-Crete Building System consists of large, structural, ribbed panels of reinforced precast concrete, bolted together and the joints between the panels are caulked to form the walls, floor and pitched or flat roofs of buildings.

The surface of each panel consists of 51 mm thick slab or skin, stiffened with the ribs around the perimeter and across the panel, giving an overall panel thickness of 152 mm or 203 mm.

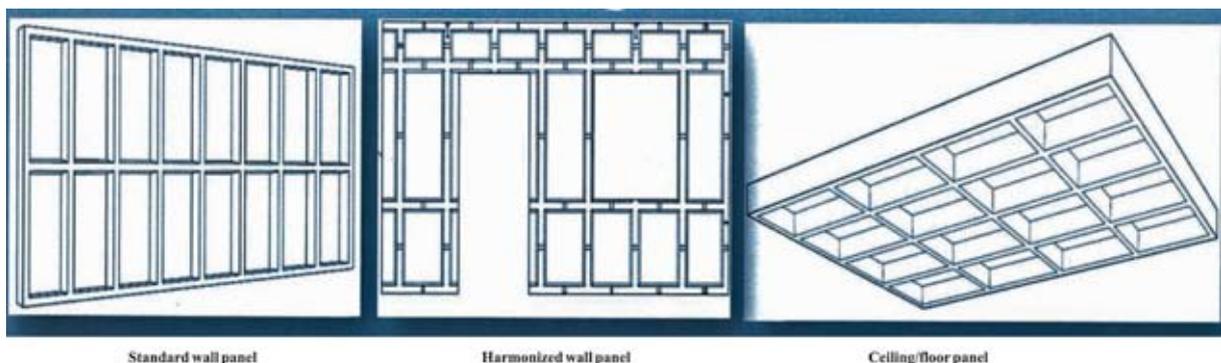
In single storey buildings, floors are constructed using precast reinforced concrete floor panels supported on precast concrete grade beams on well- compacted earth. The walls are constructed of 152 mm thick wall panels of precast reinforced dense concrete.



For buildings of more than one storey, the walls are supported on foundations designed as per the soil condition. A concrete apron are laid around the perimeter of buildings where there is a danger of water or wind erosion of the ground adjacent to the building. Metal or timber window and door frames are incorporated into the wall panels during casting or fitted after erection into openings that are formed in the panels during casting.

Internal walls consist of either reinforced precast concrete ribbed panels, conventional masonry walls or concrete walls. Where precast concrete panel or masonry internal walls are used in single storey buildings, these are normally be erected on a concrete surface bed or on concrete strip footings and not on *suspended floor*.

Services like water supply and electricity shall be normally accommodated in preformed slots in the ribs of panels, before the walls are lined. The casting can be done in casting yard while foundation is done, which reduces the construction time. Curing time is reduced by trapping the moisture generated from the concrete. The building after construction can be shifted from one place to another as the structure is joined using bolt connections.



Standard wall panel

Harmonized wall panel

Ceiling/floor panel

The Waffle-Crete system consists of the following core elements:

- Lightweight insulated precast insulated molds
- Insulated curing covers that are used in conjunction with Waffle-Crete molds
- Specialized equipment are designed for use with Waffle-Crete molds and covers
- A construction methodology for casting and erecting concrete panels with molds and equipment.

Concrete panels cast in molds and then covered with a curing cover are removed from the mold and erected. Modular panels and bolted connections speed up the erection process. The system can be utilized for a variety of structural applications.

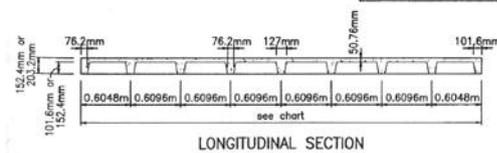
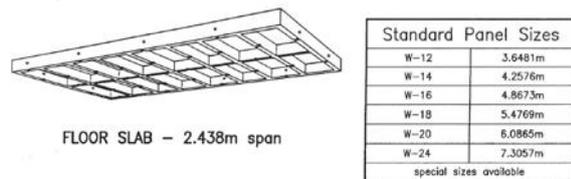
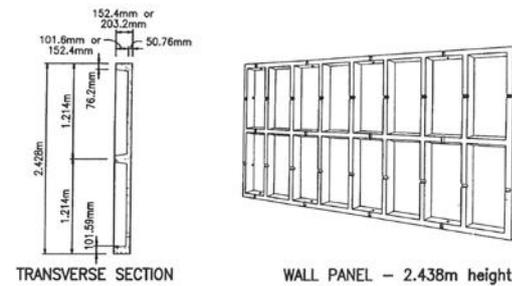
## TYPE OF PRECAST CONCRETE PANELS & WALLS

**1. Standard reinforced precast concrete wall**, floor and roof panels are 2.43 m wide and are manufactured in lengths of 3.65 m, 4.26 m, 4.87 m, 5.48 m, 6.09 m & 7.31 m. The surface of each panel shall consist of a 51 mm thick slab, stiffened with tapered ribs around the perimeter and across the panel. The ribs shall be at approx. 1214 mm centres in one direction and 610 mm in the other and give an overall panel thickness of 152 mm or 203 mm, as required.

**2. Harmonized** reinforced precast concrete wall panels are 2.58 m high and are manufactured in lengths of 3.65 m, 4.26 m, 4.87 m, 5.48 m, 6.09 m & 7.31 m. All harmonized panels shall be 152 mm or 203 mm thickness. The surface of these panels shall consist of a 51 mm thick slab, stiffened with ribs around the perimeter and across the panel. The ribs shall be at approx. 610 mm centers, with two horizontal ribs along its length, one approx. 836 mm from the bottom and the other 418 mm from the top. These panels are used for window/door and window cut-outs.

### 3 Accessory Panels

- Eave panels are used as decorative building trim and also cover waffle voids that may be exposed on the edges of cut roof panels.
- Grade beams are used to cast a first floor foundation. Grade beam panel are keyed to fit floor panel ribs.
- Stair panels are included an adjustable blockout to cast concrete stairs of variable width up to 2.44 m. Stair molds are available in 3.66 m & 6.10 m lengths with 164 mm risers.



### 4 Waffle-crete Floor Slabs

Thickness of concrete of topping may vary for different requirement of fire ratings. Floor slabs with a 60 minute fire-resistance rating shall require a minimum of 38 mm concrete topping and floor slabs with a 120 minute fire-resistance rating shall require a minimum concrete topping of 75 mm or cladding to the underside.

The joints between the plasterboard shall be sealed according to the manufacturer's recommendations. Floor slabs with a 30 minute fire-resistance rating shall not require a concrete topping. Thickness of concrete topping may vary for different requirement of fire-ratings.

### 5 Type of Walls

5.1 There are six types of internal and external walls which are used in conjunction with brick or concrete masonry walls etc. The wall panels are 152 mm or 203 mm thick overall.

- i. **Type 1** 152 mm or 203 mm panels, unlined.
- ii. **Type 2** Wall panels lined on one side with 12.5 mm thick gypsum plasterboard on 38 mm x 38 mm timber studs at 600 mm centers fixed to the panel ribs with screws into nailer blocks cast into concrete at 600 mm centers.
- iii. **Type 3** Wall panels lined on one side with 12.5 mm thick gypsum plasterboard of 63.5 mm x 35 mm x 0.71 mm thick on galvanized steel studs spaced at maximum 450 mm centres fixed to the ribs of the panels with 18 gauge steel galvanized wire wound around threaded 6 mm dia. galvanized steel fasteners hand-driven into a previously drilled hole in the rib of the floor panel.
- iv. **Type 4** Wall panels lined on one side with two layers of 12.5 mm thick gypsum plasterboard on galvanized steel studs with staggered joints similar to those used in Type 3 wall fixed to the panel ribs in the same manner as wall Type 3.
- v. **Type 5** Wall panels lined on one side with 12.5 mm thick gypsum plasterboard on top hat section galvanized steel channels fixed to the panel ribs as for wall Type 3 and insulated with 150 mm thick glass fibre.
- vi. **Type 6** Wall panels lined on one side with 12.5 mm thick gypsum plasterboard on timber studs fixed to the panel in the same manner as for wall Type 2 and insulated with 50 mm thick glass fibre.

## MATERIAL REQUIREMENTS

Rebar Fe 415/485 are in accordance with IS1786:2008 and of dia. 12 mm, 16 mm & 20 mm.

Wire mesh is made of 6 mm dia. bar as per IS1786:2008 @ 300 mm c/c.

Connection bolts M 16 x160 mm, M 16 x 380 mm & M 16x310 mm conforming to ASTM A 307 Gr A/IS 1363 (Part1-3):2002.

Anchor bolts HIT V M16 & HY 200R chemical conforming to ASTM A 307 Gr A/ IS 1363 (Part 1- 3):2002.

Concreting to be of M 30 grade concrete in accordance with IS 456:2000, without fly ash and coarse aggregate shall be not more than of 20mm size. Water-cement ratio to be 0.40. Mix design with admixtures conforming to IS 9103:1994 shall have compressive strength of 19 N/mm<sup>2</sup> in 18-24 h.

Swift lift Anchor have two anchors in each wall panel and four anchors in each floor panel. Spacing of anchors to be according to cut-outs provision in respective panel.

Gypsum board conforming to IS 2095 (Part 1):2011.

## MANUFACTURING PROCESS

Process of manufacturing of the panels is as follows:

- i) Waffle-Crete components shall either be cast on site or in casting yard. An inverted panel or a concrete surface bed shall be used as a base on which the components shall be casted.
- ii) The heavy quality insulated plastics and aluminium molds shall be blocked off at any point if a particular non-standard sized panel is required.
- iii) Holes for bolted connections between components shall be usually formed during the casting of the components.
- iv) Metal, RCC or timber window and door frames shall be fitted in the block-outs left for the purpose.
- v) Steel rod and mesh reinforcement shall be placed in the mold as specified by the professional engineer responsible for design of the building. Spacer blocks shall be used to correctly locate the reinforcement to ensure that the specified concrete cover is achieved.
- vi) Concrete of minimum grade of M 35 MPa shall be poured into the molds from ready mix trucks / dumpers or other suitable means.
- vii) Specially designed vibrator shall be used to strike off and compact the concrete in one operation.

- viii) The insulated plastics and aluminium cover to the molds keep the heat and moisture during curing of the panels.
- ix) The concrete components shall be lifted using specially designed lifting beam, or with cable slings and embedded lifting anchors at appropriate positions.
- x) The panels shall be stacked horizontally on top of each other, supported on timber spacers and stored in the casting yard until required at site.
- xi) Panels shall be de-molded after checking the results by rebound hammer
- xii) Molds shall be stacked in the casting yard and curing of panels shall be done
- xiii) The panels shall be transported to the erection location by trailer
- xiv) The panels shall be lifted using crane and fixed on the location by connection bolts
- xv) After connection bolts are fixed, panels shall be covered with high strength chemicals
- xvi) Thereafter, finishing items like flooring, door & window fixing and painting etc. shall be done.



## ERECTION PROCEDURE

- (i) The properties of the soil on site shall be established by a professional engineer and the foundations and floors designed accordingly.
- (ii) The conventional cast-in-situ concrete foundations and surface beds with thickened edge beams or footings, shall be constructed on site in accordance with IS 1904:1986. The surface beds shall be laid on well compacted earth.
- (iii) When suspended floor panels and foundations are used, the grade beams shall be located under the longitudinal external walls of the building. They shall be placed in position on the surface of the ground on well compacted and levelled earth, laid end-to-end with butt joints.
- (iv) Where the span between the grade beams on either side of the building is such that it is necessary to use two or more floor panels across the width of the building, the ends of the panels at the joints where they meet shall be supported by additional grade beams, laid parallel to the external grade beams.
- (v) A continuous damp-proof membrane of a suitable plastic material, at least 0.25 mm thick, shall be provided under conventional concrete foundations and surface beds.
- (vi) The wall panels shall be hoisted and set in a vertical position, onto hardwood shims on the panel floor, concrete footing or surface bed, to create a space of uniform thickness under the bottom ribs of the wall panels, for the grouted joint.
- (vii) After levelling and aligning the wall panels on the shims, these shall be bolted to the floor panels and grade beams, or to the cast-in-situ concrete surface bed or foundations.
- (viii) Where threaded galvanized steel or stainless steel rods are used instead of anchor bolts, the ends of the rods

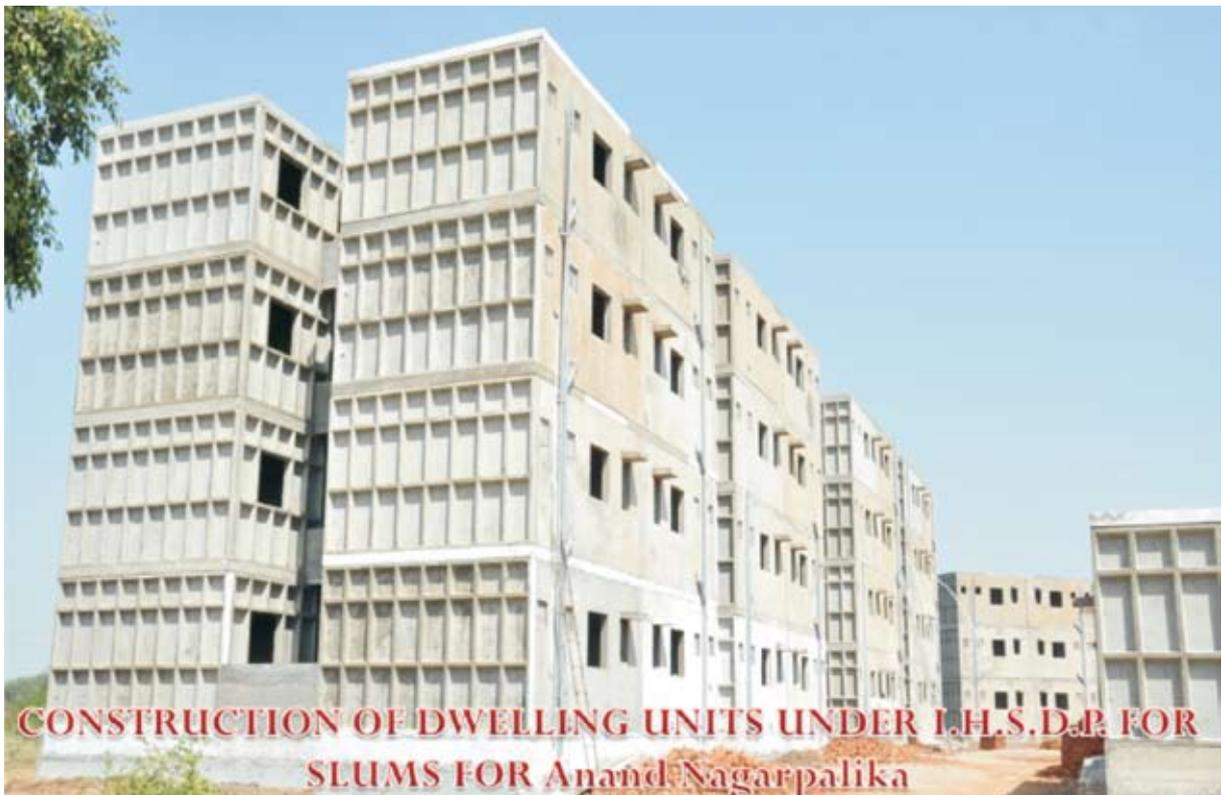


shall be embedded in epoxy grout in holes drilled into the concrete, in strict accordance with the manufacturer's instructions.

- (ix) Sand-cement grout having a compressive strength of 35MPa at 28 days shall be used in all horizontal joints between precast concrete components, unless otherwise specified by the engineer. A vibrator rod shall be used to ensure that the grout completely fills the joints.
- (x) Intermediate floors shall always consist of panels which are bolted together. There are three types of floor to wall connections. In the first case the floor panel shall be supported on top of an external wall, in the second case two floor panels shall be supported on an internal wall and in the third case a floor panel shall be supported on a ledger beam.
- (xi) Staircases which are of precast concrete shall be deigned in the normal manner and bolted to the supporting structure. At the beginning of a rise, the staircase shall be bolted with a 19 mm dia. vertical expansion anchor through a 76 mm x 76 mm 38 mm recess in the first step to the supporting structure. At the upper end of the rise, the staircase shall be fixed with a minimum of three 19 mm dia. x 254 mm long expansion anchors through the floor.
- (xii) On the outside of the building, the grout shall be partially raked out of the horizontal joint all round between the bottom of the external walls and the floor, concrete surface bed or footing to allow for the insertion of butyl rubber rope, followed by a bitumen impregnated foam plastics backer rod or bond breaker and caulked with one component polyurethane sealant.
- (xiii) The adjoining vertical ribs of the external panels shall be bolted together with 12.7 mm dia. galvanized steel or stainless steel bolts at 1.2 m centres through preformed or drilled holes for 152 mm thick panels or 20 mm dia. bolts at 1.2 m centres for 203 mm thick panels.
- (xiv) The vertical joints between external wall panels shall be caulked on the outside of the building with one component polyurethane sealant a bitumen impregnated foam plastics backer rod or bond breaker.

#### **Roof Construction and Gable Wall**

- (i) Triangular wall in-fill panels shall be hoisted into position on hardwood shims on top of the end walls of the building and bolted together through the adjoining outer horizontal ribs with 12.7 mm dia. galvanized steel or stainless steel bolts at 1.2 m centres.



- (ii) Precast concrete roof panels which span between the gable ends shall be hoisted into position on the sloping tops of the gable wall panels and bedded in 6 mm thick 4:1 sand: cement mortar, to form a pitched roof. The pitch shall generally be 30°.
- (iii) Galvanized steel plates, 60 mm long x 100 mm wide x 10 mm thick, at 2.4 m centres and cast into the ribs on the underside of the roof panels on either side of the ridge, shall be connected at the apex by welding a steel rod at the joint between each pair of plates.
- (iv) Depending on the structural design of the building and span of roof, the roof shall be supported at its apex by a ridge beam spanning between the gable wall infill panels at each end.
- (v) The adjoining roof panels shall be bolted together with 12.7 mm dia. galvanized steel or stainless steel bolts at 1.2 m centres, through preformed or drilled holes in the ribs of the panels. Before fully tightening the bolts, butyl rubber rope shall be inserted into the joint between the panels, followed by a bitumen impregnated foam plastics backer rod or bond breaker and the joint shall be caulked externally with one compound polyurethane sealant or equivalent.
- (vi) Flat roof shall consist of 152 mm or 203 mm thick precast reinforced ribbed wall panels bolted together and covered with a conventional waterproofing system on screed. Precast roof copings shall be bolted to the roof panels with 12 mm dia. bolts at 1219 mm centers.
- (vii) Internal walls on suspended floors shall usually be constructed of timber with 12.5 mm thick gypsum plasterboard cladding on both sides. Conventional burnt clay or concrete masonry internal walls shall usually be erected on conventional concrete surface beds and foundations.
- (viii) Internal walls shall also be plugged and screwed by means of steel brackets and bolts to the adjacent vertical ribs of the external walls at T-junctions and bolted or plugged and screwed to concrete surface beds or precast floors.

#### ***Windows, Doors, Services and Attachment of Fittings***

Timber or steel window and door frames shall be fitted into preformed openings in the wall panels and sealed all round with silicone sealant, unless they have been cast in during manufacture of the panels.

Electrical and plumbing services shall be installed in the preformed notches on inside of the wall panels, or through sleeves cast into the ribs.

Sanitary fittings, cupboards, shelving, and other heavy fittings shall be attached to the walls with galvanized steel bolts taken through holes drilled in the backing skin of the wall panels, or with expansion bolts fixed to the panel ribs.

#### ***Protection against corrosion and finishes***

Steel bolts, anchor bolts, nuts, washers, threaded rods, brackets and cleats used at connections and joints in external walls, roofs, floors and foundations are hot-dip galvanized in accordance with IS 4759:1996 and coated with a metal primer, a good quality bituminous paint or epoxy painting or they are of stainless steel.

The exterior surface of roofs and external walls shall be painted with two coats of suitable exterior grade acrylic emulsion paint. Painting of remainder of the building shall be carried out in accordance with the manufacturer's requirements.

### **APPLICATIONS**

The system is used for low rise mass housing projects, commercial buildings, manufacturing facilities, retaining walls etc.

### **SPECIAL FEATURES**

#### ***Structural Stability***

The strength of connections between components and with recessed bolts shall be determined by test before use. In addition to conventional structural design aspects, the design of the building shall address the following:

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- Stability of gable walls
- Bracing of façade walls against wind loads
- Structural integrity and resistance to progressive collapse due to accidental damage to local elements.

#### **Durability**

The structural design shall comply with all the relevant Indian Standards, including IS 456:2000, IS 875 (Part 1, 2 & 3):1987, IS 4326:2013, IS 1893 (Part 1):2002, IS 13920:2016 & National Building Code of India 2016. Reference shall also be made to the design recommendations given in Waffle-Crete's design manual and specifications.

#### **Behavior in earthquake and wind**

All precast concrete floor, wall and roof panels and grade beams shall also be designed for loading conditions during de-molding, transportation and erection.

#### **Fire Safety**

Floor slabs with a 60 minute fire-resistance rating shall require a minimum of 38 mm concrete topping and floor slabs with a 120 minute fire-resistance rating shall require a minimum concrete topping of 75 mm or cladding to the underside

#### **MAJOR COMPLETED PROJECTS**

- 464 Dwelling units under IHSDP for slums of Anand Nagarpalika (Gujarat)
- 480 Dwelling units of Dahod Nagarpalika (Gujarat)
- 512 Dwelling units Housing (G+3) at Bharuch Nagarpalika, Bharuch (Gujarat)

#### **CERTIFICATION**

Performance Appraisal Certificate No. 1021-S/2015 issued to M/s Shaival Reality Pvt. Ltd., Ahmedabad.

#### **STANDARDS/REFERENCES**

- South Africa Agreement Certificate No. 97/260 for Waffle-Crete Agreement System of Waffle-Crete International Inc
- IS 158:1981 – Ready mixed paint, brushing, bituminous, black, lead free, acid, alkali and heat resisting
- IS 456:2000 – Code of Practice for Plain and Reinforced Concrete
- IS 875 (Parts 1, 2 & 3):1987 – Code of Practice for Design Load of Buildings and Structures
- IS 1363:2002 – Hexagon Head Bolts, Nuts and Screws of Product
- IS 1367:2002 – Technical Supply Conditions for Threaded Steel Fasteners
- IS 1786: 2008 – High strength deformed bars and wires for concrete Reinforcement
- IS 1893 (Part 1):2002 – Criteria for Earthquake Resistant Design of Structures (Part 1). General Provisions and Buildings.
- IS 1904:1986 – Code of practice for design and construction of foundations in soils – general requirements
- IS 2095 (Part 1):2011 – Specifications for gypsum plasterboards –Plain gypsum plaster boards
- IS 4326:2013 – Code of Practice for Earthquake Resistant Design and Construction of Buildings
- IS 4759:1996 – Hot Dip Zinc Coating on Structural Steel Products
- IS 7215:1974 – Tolerances for Fabrication of Steel Structures
- IS 9103:1999 – Concrete admixtures - Specification
- IS 10505: 1983 – Code of practice for construction of floors and roofs using precast concrete waffle units.
- IS 13920: 2016 – Code of practice for ductile detailing of Reinforced Concrete Structures subjected to seismic forces.

# Precast Large Concrete Panel System

(Suitable for Low Rise to High Rise Structures)

## ABOUT THE TECHNOLOGY

Precast Large Construction Panel (PLCP) system consists of various precast elements such as walls, beams, slabs, columns, staircase, landing and some customized elements that are standardized and designed for stability, durability and structural integrity of the building. Precast residential building construction involves design, strategic yard planning, lifting, handling and transportation of precast elements. This technology is suitable for construction of high rise buildings resisting seismic and wind induced lateral loads along with gravity loads. The building framing is planned in such a way that maximum number of repetitions of moulds is obtained. These elements are cast in a controlled factory condition. The factory is developed at or near the site which provides an economical solution in terms of storage and transportation.

## TYPES OF PRECAST ELEMENTS AND MOULDS

Two main types of precast concrete elements, namely precast reinforced concrete elements and precast pre-stressed concrete elements are used as per the details given below:

### ***i. Precast reinforced concrete elements***

These shall consist of reinforcement bars and/or welded wire meshes within the elements to provide the tensile strength and resistance against cracks such as façade walls, beams, columns, slabs, refuse chutes, staircases and parapet walls.

### ***ii. Precast pre-stressed concrete elements***

These shall consist of pre-stressing tendons within the elements to provide a predetermined force needed to resist external loadings and cracks such as hollow core slabs, beams and planks.

Typical size of precast elements is given below:

Sr. No.	Precast Components	Typical Sizes*
1	Wall Panels	5m x 2.85m
2	Slabs	3m x 5m
3	PODS	1.52m x 1.36m x 2.83m
4	Beam	0.20m x 0.40m x L
5	Staircase	As per design
6	Columns	0.90m x 0.35m x 2.85m

\* Sizes of panel slabs may vary as per the architectural and construction requirement.

### ***iii. Moulds***

Moulds for precast elements shall be of steel and concrete. For design of the moulds for various elements, special importance should be given to easy de-moulding and assembly of the various parts. At the same time rigidity and strength and water tightness of the mould are also important taking into consideration forces due to pouring of green concrete and vibration. The type of moulds used for pre-casting various elements with various methods is given below:

Sr. No.	Mould Type	Uses
1	Conventional moulds	Ribbed slab, beams, window panels, box type units and special elements
2	Battery moulds	Interior wall panels, shell elements, roof and floor slabs
3	Tilting moulds	Exterior wall panels where special finishes are required on one face or for sandwich panels
4	Long line prestressing beds	Double tees, ribbed slabs, piles and beams
5	Extrusion machine	Roof slabs and hollow core slabs

**Battery Mould****Tilting Mould****POD Mould**

## MATERIAL REQUIREMENTS

**Ordinary Portland Cement:** Shall be of 43 grade as per IS 269:2015.

**Fine aggregate (M Sand):** Shall be as per IS 383:2016 & IS 1542:1992 and 4.7 mm.

**Coarse Aggregates:** Shall be as per IS 383:1970 and of 20 mm, 40 mm size

**Steel reinforcement:** Shall be as per IS 1786:2008

**Concrete:** The grade of concrete shall be M 30 and slump for walls, floors and roofs shall be as per IS 456:2000.

**Brick masonry:** Shall be designed as per IS 1905:1987

**Solid Block work:** Shall be as per IS 2185 (Part 1):1979

**Aluminium:** Shall be as per IS 733:1983

**Glass:** Shall be as per IS 2835:1987

**Non-shrunk non-metallic grout:** Cement based flowable grout shall have compressive strength of 65 N/mm<sup>2</sup>, flexural strength of 9 N/mm<sup>2</sup> at 28 days and E-modulus of 37000 N/mm<sup>2</sup>.

**Water proofing membrane:** Fibre reinforced repair mortar shall have compressive strength of 45 N/mm<sup>2</sup> at 28 days and density 2250 kg/m<sup>3</sup>

**Baker Rod:** Closed cell polymer based product shall have compressive strength of 0.45 kg/cm<sup>2</sup> min. at 25% deflection, density 22 kg/m<sup>3</sup> min. and water absorption 0.14 gm/cm<sup>3</sup> max.

**Corrugated sleeve:** Hot dipped galvanized prime steel sheet shall be as per IS 277:2003.

## APPLICATIONS

The system is used economically for mass housing projects and commercial buildings, etc.

## INSTALLATION

### 1. Precast Installation

Proper planning and preparatory works shall be required before the actual installation of precast concrete elements in order to ensure quality installation. The following items shall be planned in advance:

- i. Method of sequence of assembly and installation: Precast elements should be identified based on their location number and the tagged.
- ii. Method of providing temporary support: Elements should be supported temporarily before these get stabilized. Generally structural members with adjustable ends shall be used for securing the panels. Shims should be used to adjust the panels to ensure dimensional correctness.
- iii. Installation tolerances: Installation tolerances should be based on codal provisions and design considerations should be clearly indicated.
- iv. Handling and rigging requirements: Elements should be checked for handling stresses before lifting and the cranes should have sufficient capacity to handle the precast panels. At least 10% impact should be considered while calculating the lifting capacity of the crane.

At site locations, panels shall be first unloaded and stacked or directly lifted by the crane. The element shall then be installed on the site and supported by temporary jacks. The cranes shall be released for next lifting once the temporary supports are in place. Shims shall be used to carefully align the element before grouting. The panels shall be grouted after the final adjustments are done.

## **2. Waterproofing**

External joints shall be sealed with baker rods and sealants after filling the joints with grout to avoid the leakage. Additional waterproofing treatment shall be provided at external joints and wet areas to ensure water tightness.

## **3. Mechanical, Electrical & Plumbing Fittings**

- Mechanical, electrical & plumbing fittings shall be kept open or concealed as per the requirements. For concealed fittings, provision for grooves, blockouts shall be made in casting moulds.
- The conduits and electrical boxes shall be embedded and fixed in moulds before casting. For open fittings, these shall be fixed after erection at site.
- For firefighting systems, provision of National Building Code (NBC) and local Building Byelaws shall be adhered to.

## **4. Fire Rating**

- Precast concrete shall be designed for fire rating of 1 to 2 h based on codal requirements.
- Minimum precast concrete wall thickness of 120 mm shall be provided for 1 h fire rating as per IS 456:2000.

## **5. Finishes**

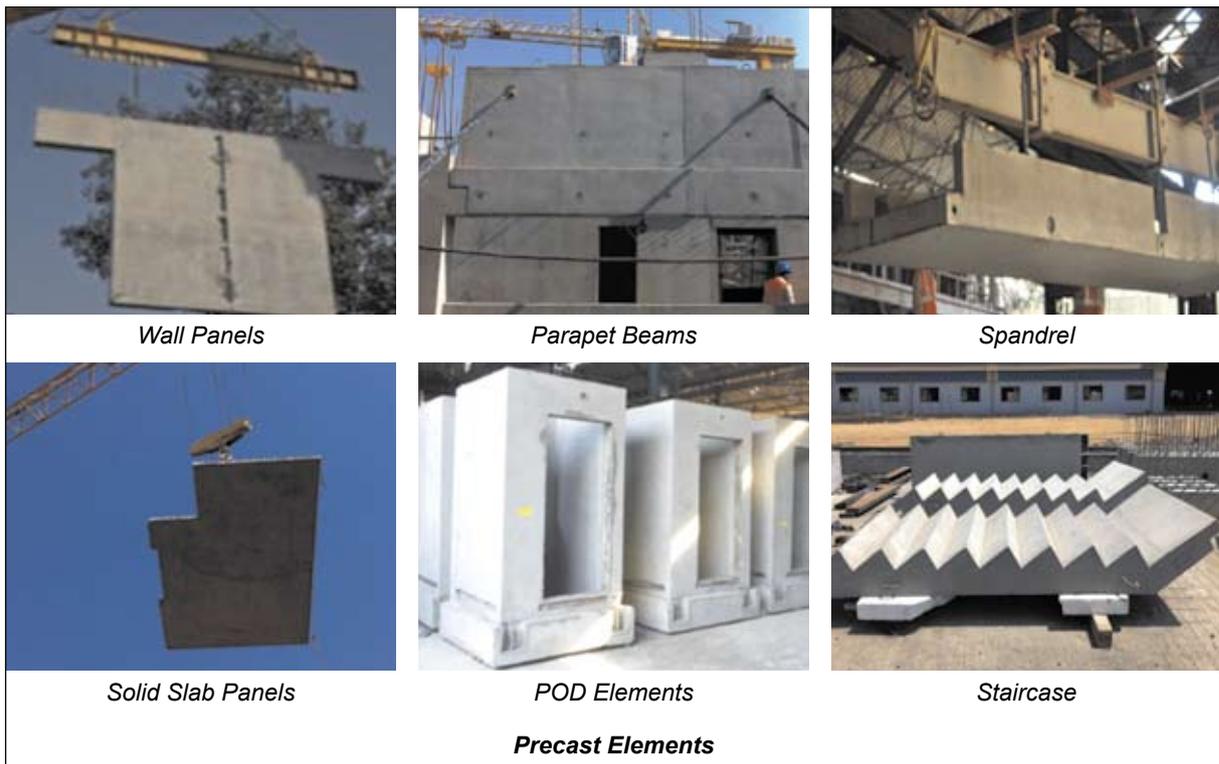
- Variety of shapes, colours, textures and finishes may be obtained with precast concrete.
- The surface treatments shall be done by rebating, grooving, surface coatings, cement based renders, oxide coloring etc.
- Precast concrete facades of various shapes, colours and textures may be moulded and installed.

## **IMPLEMENTATION OF PRECAST ELEMENTS**

### **1. Casting Concrete**

The procedure for casting concrete shall be as follows:

- i. Precast concrete elements shall be produced on horizontal/vertical, flat steel surfaced tilting tables.
  - ii. Prior to casting, electrical conduits and other required shall be fixed in position and the mould treated with mould release agent.
  - iii. Steel reinforcement shall be kept in position using adequate spacers to ensure correct position and concrete cover.
  - iv. After that side shutter shall be fixed. The high quality concrete shall be transported from batching plant to the precast yard through transit mixer.
  - v. Thereafter, concrete shall be carried to mould by gantry crane with concrete bucket.
  - vi. During casting, table vibrators (as & when required) shall be used to achieve the best compaction. Top surface shall be finished with hand operated trowel which gives smooth finish.
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- vii. Care should be taken on embedded items while concreting.
- viii. After casting, all exposed surfaces shall be covered with a tarpaulin (as and when required) to avoid vaporization. Casted elements shall be de-moulded once the strength meets the design requirements and the units are then shifted to the stockyard. Thereafter, curing shall be carried out for 5 days.

## 2. Curing

The curing of the prefabricated elements may be done by the normal methods of curing by sprinkling water and keeping the elements moist. This can also be done in the case of smaller elements by immersing them in specially made water tanks.

## 3. Screed Concrete for Flooring

The surface for screed concrete shall be clean, free from dust, loose materials, lumps and foreign material.

The screed shall generally be provided over the entire slab. In this case the entire slab shall act as a continuous structural diaphragm providing optimum load transfer mechanism for lateral loads. The screed shall be treated as a part of the compression zone for gravity loads on the slab. The design shall consider composite action between the slab & screed and compressive strength of screed in slab. Further, the interface shear between the slab & screed shall be checked for verifying adequate shear transfer capacity at the interface.

- i. Screed on haunches may be provided, only if the conduits are exposed, with the mutual agreement between the project authority and the technology provider. In such cases, additional water proofing treatment of a reputed company shall be provided at the precast slab and site concrete stitch.
- ii. Electrical conduits or any other embedment shall be laid as per approved drawings before screed concrete flooring.
- iii. The reference level from main survey pillars shall be transferred and marked on side channels.
- iv. While marking level, sloping direction in flooring shall be taken care as per approved drawing.
- v. Before laying the concrete, cement slurry shall be spread on the slab surface for better bonding and filling of gaps between wall and slab soffit junction.
- vi. The concrete should be placed from one end and shall be compacted immediately after placing and levelled uniformly.
- vii. The vibrator should be applied smoothly and concrete compacted well.

- viii. The concrete shall be allowed to set so as to be in dry condition.
- ix. The trowelling shall start after concrete is set and reach dry condition.
- x. Curing shall be done by using bunds over the screed surface/wet hessian cloth.

#### **4. De-moulding and Stacking**

##### **4.1 Lifting of elements from mould**

- i. It must be ensured that all the elements should have identification mark.
- ii. It must be ensured that all side shutters are loosened so that the elements may be lifted without any damages.
- iii. Before demoulding, it must be ensured that compressive strength of the cubes should meet the specified requirements.
- iv. The lifting clamps/clutches shall be fixed to lifting beam at proper positions.
- v. Then the elements shall be lifted carefully to the stocking area.

##### **4.2 Stacking of elements**

- i. The surface of stacking area should be horizontal.
- ii. The wooden runner shall be placed perpendicular to lifting points and the elements placed over runner.
- iii. Number of the elements per lot should not exceed man height.
- iv. In case of vertical stacking, the gap between the elements should be 150mm to 200 mm.
- v. Stacking shall be done in such a way that slabs of longer span should be placed below that of shorter span.

#### **5. Transportation of Elements**

##### **5.1 Loading of slab over trailer**

- i. It must be ensured that the identification mark on the slab should be the same as per dispatch list.
- ii. Any damage occurred during loading should be informed to the concerned authority.
- iii. The lifting clamps/clutches shall be fixed to the lifting beam at proper position.
- iv. The lifting beam shall be placed over the precast elements and ensured that the clutches are locked properly before lifting.
- v. Instruction regarding loading height, positioning of precast elements over the trailer should be followed as per capacity of trailer.
- vi. The wooden rubber shall be placed in between the slabs at 500 mm from each end.
- vii. Some of precast elements should be placed vertically and transported through "A" frame fixed vehicle.
- viii. The slab shall not be overhanging from trailer.
- ix. The slab shall be tied firmly to the trailer by means of belt/rope as moving the load without proper tie will cause damage.
- x. While transporting elements vertically, the vehicle should be loaded equally on both sides.

##### **5.2 Unloading of slab from trailer and placing in site yard**

- i. Every slab shall be inspected for dimensions/identification mark and damages etc. prior to unloading at site.
- ii. The stacking area should be levelled and hard enough for stacking the elements.
- iii. There should be proper access for trailer movement.

#### **6. Erection**

The process of erection and installation of panels during the construction cycle by using tower cranes shall be as follows:

- i. Before starting erection a survey of the area to receive precast elements shall be done to monitor any difference in dimensions or levels exceeding the tolerances. In case of unacceptable tolerances, necessary action shall be taken for rectification.
- ii. Installation shall be done by tower crane with sufficient capacity. Panels shall be shifted from the stack rack/truck from yard to the nearest point of construction site and shall be kept above the truck during the construc-

- tion or inside the storage racks as per the site situation.
- iii. The necessary access for the truck to reach the nearest point of the tower shall be prepared before starting erection of the panels.
  - iv. Once the truck reaches the tower, chain and lifting clutch with required capacity and guide rope shall be attached to the precast panels to allow the workers to control the load to its final place.
  - v. As the elements are lifted to its final position above the cast-in-situ slab/precast panel, vertical and horizontal alignment of the panel shall be adjusted. The gap between the element and adjusted elements shall be maintained as per the drawings within the allowable tolerances. Shims and spacers shall be used for levelling and adjustment.
  - vi. Temporary propping jacks shall be provided for restraining the walls laterally until grouting.
  - vii. After completion of fixing, alignment of the panels shall be checked again.
  - viii. Minor damages, if any to the precast panels shall be repaired by approved materials.
  - ix. After completion of installation and alignment, elements shall be handed over for inspection.
  - x. The joints between the precast wall panels shall be filled with joint filler material.
  - xi. Precast slab shall be erected above the wall panels without any scaffolding system. The electrical conduit/fitting shall be done. After electrical works are completed, screed concrete shall be laid over the precast slab.
  - xii. Installation of the next floor shall start only after completion of screed concrete of the previous floor.
  - xiii. The sequence of erection shall be as follows:
    - Installation of precast wall panels above cast-in-situ slab
    - Provide temporary props/jacks for restraining of the walls laterally.
    - Grout the connection between the wall panels & ground floor slab and the joint between each wall panel.
    - Installation of precast slab panels above the erected precast wall panels.
    - Screed concrete above the slab after placing of electrical conduits / fittings
    - Installation of the wall panels over the floor slab.
    - Installation of the roof panels such as parapets etc.



## SPECIAL FEATURES

### **Structural Stability**

The overall behavior of a precast structure is dependent on the behavior of the connections which must provide:

- Resistance to all design forces
- Ductility in case of excessive deformation
- Resistance to volume changes and related forces
  - Adequate durability
  - Required fire resistance
  - Feasible production considerations
  - Feasible construction considerations

The overall design of the structure shall be done in accordance with IS 875 (Part 1 to 5): 1987, IS 456:2000, IS 1893(Part 1): 2002, IS 13920:2016 and IS 15916:2011, as applicable.

Large panels shall be in accordance with the provisions of IS 11447:1985.

### **Durability**

Structural load bearing walls shall be designed as per codal provisions of IS 456:2000 and IS 13920:2016 as applicable.

### **Behavior in earthquake and wind**

The components of the structure shall be designed for loads in accordance with IS 875 (Parts 1-5):1987 and IS 1893 (Part 1):2002. In addition members shall be designed for handling, erection and impact loads that might be expected during handling and erection.

### **Fire Safety**

Period of fire resistance of RCC buildings is based on NBC requirements. To meet the fire rating requirement, provision specifications.

### **WORKS COMPLETED**

1. Construction of (G+23) Pragati Towers at Mumbai in 1972 (2024 units).
2. Construction of (G+12/G+14) Provident Sunworth Project at Bangaluru in 2015 (5952 units).

### **CERTIFICATION**

Performance Appraisal Certificate No. 1027-S/2016 issued to M/s Larsen & Toubro Ltd., Mumbai by BMTPC.

### **STANDARDS/REFERENCES**

- Suitability of Precast Concrete Large Panel system for Mass Housing Projects by IIT Madras
- Design & Construction Methodology Review for Rehab Bhiwada Precast Project, Mumbai by IIT Madras
- Verification of Thermal Performance Reports – Evaluating RCC Wall apartments in Ahmedabad & Chennai by Indian Institute of Science, Bangalore.
- IS 456:2000 – Code of Practice for Plain and Reinforced Concrete
- IS 875 (Parts 1-5):1987 – Code of Practice for Design loads (other than earthquake) of buildings and structures
- IS 1786: 2008 – High strength deformed bars and wires for concrete reinforcement
- IS 1893 (Part 1):2002 – Criteria for Earthquake Resistant Design of Structures (Part 1) - General Provisions and Buildings
- IS 1904:1986 – Code of practice for design and construction of foundations in soils – general requirements
- IS 2062:1992 – Hot Rolled Medium and High Tensile Structural Steel
- IS 7215:1974 – Tolerances for Fabrication of Steel Structures
- IS 9103:1999 – Specifications for Concrete admixtures
- IS 11447:1985 – Code of practice for construction of large panel prefabricates
- IS 13920:2016 – Code of practice for ductile detailing of Reinforced Concrete structures subjected to seismic forces.
- IS 15916:2011 – Code of practice for design and erection using prefabricated concrete



# Industrialized 3-S System using Precast RCC Columns, Beams & Cellular Light Weight Concrete Precast RCC Slabs

(Suitable for Low Rise to High Rise Structures)

## ABOUT THE TECHNOLOGY

The industrialized total prefab construction technology, being used since 1972, is based on factory mass manufactured structural prefab components conforming to provisions of relevant Indian Standards. The major precast elements are:

- RCC hollow columns with notches
- RCC solid beams (T/L/Square Shape)
- Staircase
- RCC precast slab
- AAC precast slab
- AAC precast block



In the system, precast dense concrete hollow column shell of appropriate sizes are used in combination with precast dense concrete rectangular / 'T' shape / 'L' Shape beams with light weight reinforced autoclaved cellular concrete/Precast RCC slabs for floors and roofs. The hollow columns are grouted with appropriate grade of in situ concrete. All the components and jointing of various structures are accomplished through on-site concreting along with secured embedded reinforcement of appropriate size, length and configuration to ensure monolithic continuous resilient, ductile and durable behaviour. Autoclaved Aerated Concrete (AAC) slabs can be used as floor / roof slabs. Joints are filled with reinforced screed concrete (minimum 40 mm thick) of M20 grade minimum. RCC screed is laid over entire area of slab before flooring / water proofing.

## BASIC MATERIAL REQUIREMENTS

### RCC hollow columns & Beam

#### Concrete

Shall conform to appropriate grade based on environmental and structural requirements condition as per IS 456 : 2000

#### Reinforcement

Shall be of Fe 415 Grade or Fe 500 Grade as per IS 1786:2008

### AAC Precast Slab

Grade 1 of Density 551 – 650 Kg/m<sup>3</sup> of IS 6073:2006

### AAC Precast Block

Density 451-550 Kg/m<sup>3</sup> for internal wall, 551-650 Kg/m<sup>3</sup> for external wall as per IS 2185 (Pt. 3) :1984



## OTHER REQUIREMENTS:

### EVALUATION OF STRUCTURAL REQUIREMENT OF JOINTS

#### Against vertical load

- Full Scale load test on assembly of precast elements by Tor Steel Research Foundation in India, Bangalore

found it safe.

- Structural Design evaluation for HIG – II Buildings at Powai by Shri H.P. Shah; Stanford University found that based on the design concept, design calculation and detailing; the structure is safe against vertical loads, seismic loads and the wind loads.
- Scrutiny of design for S+24 type buildings by IIT Mumbai found it safe.
- Scrutiny of design details for Delhi project by IIT Roorkee found jointing & connections ensuring monolithic, durable & ductile behaviour.

**Against seismic and wind load**

A Test was performed by CBRI on full-scale building to establish behaviour of various joints under all design loads including seismic Zone IV. The experimental results on Full Scale Building Structure demonstrated the desired performance and behaviour of the 3S system under all loading condition as envisaged.

When designed for use in Zone V, independent verification may be needed.

**DURABILITY**

- Anti corrosive treatment given to reinforcement used in AAC slab panels for durability, was evaluated by CBRI, Roorkee with satisfactory results.
- Concrete and cover requirement are as per durability clause of IS 456 : 2000, to ensure adequate durability.



**FIRE RESISTANCE PROPERTY OF BLOCK / SLAB AS DWELLING UNIT**

AAC blocks / Slabs used will have fire rating as per the NBC norms for dwelling units.

**THERMAL BEHAVIOUR**

Kvalue – 0.122 k cal/h/m<sup>2</sup>c of AAC blocks\*

**ACOUSTIC COMFORT TEST**

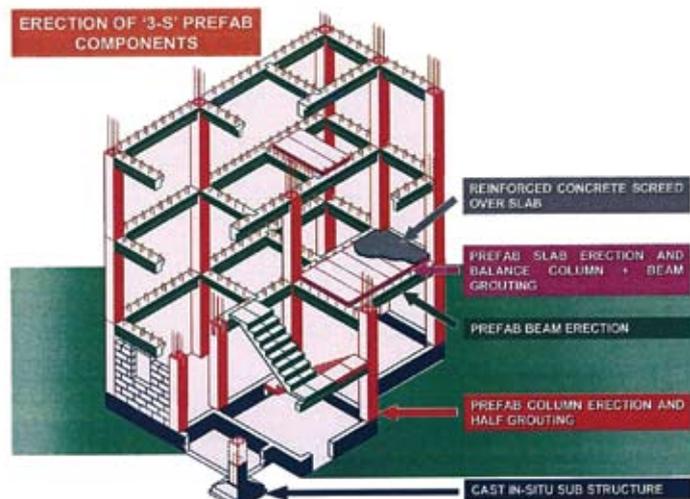
For 100 mm ACC Wall, Sound absorption is 38 – 40 db\*

**IMPACT RESISTANCE**

Not tested\*

**EASE OF FIXING SERVICES (ELECTRICITY & PLUMBING)**

With pre-planning, electricity & plumbing services can easily be placed.



**Pictorial view showing various elements / stages of work**

**AVAILABILITY OF PLANTS & MACHINERY**

Plants & Machineries for production of Components available in Pune, Mumbai, Bangalore and Delhi

## ECONOMY OF SCALE

- For a new plant to be setup, a minimum project of 5000 dwelling units may be needed.
- In places, where plant is already set up, smaller project may also be viable.

## ESSENTIAL REQUIREMENTS

- Precasting yard / factory set up is required with facilities such as Casting Yard, Computerised batching plant, Moulds, Transportation facility, Stacking yard for materials & components, Lifting and loading facility, Laboratory to test raw material & finished products, Water tank of enough holding capacity as required for 2 – 3 days, Service road, etc.
- Utmost attention is required for process engineering before taking up any field work. Close co-ordination between design crew, field staff and quality crew is essential.

## LIMITATION

The project is taken as turnkey project by the agency M/s B.G.Shike & Co., Pune. No other agency is involved in this propriety system.

## MAJOR CONSTRUCTION WORK DONE

1. Multistoried prefab residential buildings comprising over 400 Lacs sft built area have been completed since 1974
2. Residential EWS, LIG, MIG and HIG housing projects at Kharghar, Navi Mumbai for CIDCO.
3. Residential mass housing project of MHADA, Powai, Mumbai.
4. S+24 Multistoried Residential Building for mill workers & transit accommodation for 1000 families at Mumbai.
5. Mass Housing Project at Delhi for DDA.
6. S+14 multi storeyed MIG & HIG type buildings at Versova, Mumbai for MAHADA.
7. Multistoried residential buildings of Transit, LIG, MIG & HIG type of 10,650 families at SION Mumbai.
8. Several projects are being taken up / completed in the state of Maharashtra, Karnataka, Andhra Pradesh, Tamil Nadu & Delhi.



## STANDARDS/GUIDELINES REFERRED:

IS 456:2000	-	Code of Practice for plain and reinforced concrete.
IS 875 (Pt.3):1987	-	Code of Practice for Design Loads (Other than Earthquake) for Buildings and Structures - Part 3 : Wind Loads
IS 1786:2008	-	High strength deformed steel bars and wires for concrete reinforcement-
IS 1893 (Pt.1):2002	-	Criteria for Earthquake Resistant Design of Structures - Part 1 : General Provisions and Buildings
IS 1950:1962	-	Code of practice for sound insulation of non-industrial buildings
IS 2185 (Pt.3):1984	-	Specification for Concrete Masonry Unit - Part 3: Autoclaved Cellular (Aerated) Concrete Blocks
IS 3792:1978	-	Guide for heat insulation of non-industrial buildings
IS 6073:2006	-	Autoclave Reinforced Cellular Concrete Floor and Roof Slabs - Specification
IS 13920:2016	-	Ductile detailing of reinforced concrete structures subjected to seismic forces - Code of practice
NBC 2016	-	National Building Code, 2016



## APPENDICES



## Appendix-1

F.No.JS/Works/OM/2016  
Government of India  
Ministry of Urban Development

Maulana Azad Road,  
Nirman Bhawan,  
New Delhi

Dated: 30/05/2016

### OFFICE MEMORANDUM

**Sub: Adoption of New & Emerging Technologies in construction work of value not less than Rs.100 crores in Metropolitan cities, undertaken by CPWD, DDA and NBCC – reg.**

The subject of using Modern Technologies in the construction works of CPWD, DDA and NBCC under the Ministry of Urban Development has been under consideration of the Ministry. CPWD has recommended to MOUD, adoption of the following three Technologies, which are validated by Building Materials and Technology Promotion Council (BMPTC) under the Ministry of Housing and Urban Poverty Alleviation:

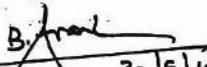
1. Monolithic Concrete Construction System using Aluminium Formwork.
  2. Industrialized 3-S System using Cellular Light Weight Concrete Slabs & Precast Columns (Precast/ prefab)
  3. Monolithic Concrete Construction System using Plastic - Aluminium Formwork.
2. CPWD has recommended that the adoption of the above 3 new technologies will result in the following benefits: -
- (a) Significant reduction in air & noise pollution and construction waste
  - (b) Optimum use of water
  - (c) No use of timber/ plywood for shuttering
  - (d) Form finish elements, good workmanship, assured quality and durable construction
  - (e) Increased labour productivity due to working in controlled environment
  - (f) All weather site execution

- (g) Cost saving due to compressed completion time and rental cost reduction
- (h) Better site organization, utilization of resources

3. CPWD has stated that adoption of the above mentioned 3 technologies will ensure neat and tidy work place with minimal environmental pollution and will be in sync with the objectives of 'Swatch Bharat Mission'. Further, adoption of these technologies will result in skill up-gradation of workers.

4. Accordingly, the Ministry of Urban Development has decided that CPWD, DDA and NBCC would mandatorily adopt the 3 Technologies enumerated in para 1 above and validated by BMPTC at their construction sites initially in the Metropolitan Cities of India, and where the value of works is Rs.100 crores or more. It has also been decided that these organizations (CPWD, DDA and NBCC) will also invariably obtain Third Party Certification related to Green Building Concept from agencies recognized by MoEF, apart from installing rooftop solar power plants, wastewater recycling and rainwater harvesting in all such projects.

5. This issues with the approval of Hon'ble Minister for Urban Development.

  
30/5/16  
(B. Anand)  
Joint Secretary (W&H)

To

1. Vice Chairman, DDA, Vikas Sadan, INA, New Delhi- 110 023.
2. Director General, CPWD, Nirman Bhawan, New Delhi – 110 011.
3. CMD, NBCC Limited, NBCC Bhawan, Lodhi Road, New Delhi – 110 003.

Copy for information to :

1. PS to Hon'ble UDM, PS to Hon'ble MoS, PPS to Secretary(UD), PPS to AS(UD) & PPS to AS(SC).
2. All Joint Secretaries/Economic Adviser/OSD(UT)/JS&FA in M/o UD.
3. All Director/D.S. in M/o UD.
4. Office Memorandum file – US(W-3).
5. IT Cell for uploading in e-office.

Ps to. JS(H)  
114-C  
✓

## Appendix-2

  
**CENTRAL PUBLIC WORKS DEPARTMENT**  
**OFFICE MEMORANDAM**  
**DG/DSR/010**  
**ISSUED BY AUTHORITY OF DIRECTOR GENERAL, CPWD**

NIRMAN BHAWAN NEW DELHI

DATED 24/06/2016

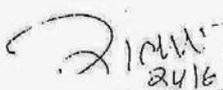
**Sub: -Correction slip No.5 to Delhi Schedule of Rates 2014.**  
**OFFICE MEMORANDAM**

It has been decided with the approval of DG, CPWD to include following new technology items in Delhi Schedule of Rates 2014. The nomenclature of these new technology items and their relevant Analysis of Rates are also included in CPWD DAR-2014.

S.No	Item No	Particulars of technology	Number of items
I	New technology item No. 1	Expanded Polystyrene core panel system	2 items
II	New technology item No. 2	Light gauge steel framed structure	5 items
III	New technology item No. 3	Aluminium formwork for monolithic construction	1 item

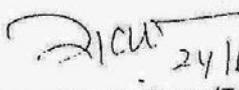
Particulars and details of these items detailing their nomenclature and relevant Analysis of Rates are uploaded on CPWD website.

This issues with the approval of DG, CPWD.

  
 24/6/2016  
 (R.B.Garg)  
 Executive Engineer (TAS-II)  
 CSQ, CPWD, Nirman Bhawan, New Delhi

No.133/SE(TAS)/CS-DSR-2014/2015-16/ 172-E  
 Copy to: All the SDG/ADG/CEs/CPMs through CPWD website <http://cpwd.gov.in>

Dated: 24.06.2016

  
 24/6/2016  
 Executive Engineer (TAS-II)  
 CSQ, CPWD, Nirman Bhawan, New Delhi





CENTRAL PUBLIC WORKS DEPARTMENT  
OFFICE MEMORANDAM

DG/DSR/011

ISSUED BY AUTHORITY OF DIRECTOR GENERAL, CPWD

NIRMAN BHAWAN NEW DELHI

DATED 17/08/2016

OFFICE MEMORANDAM

Subject: Adoption of New & Emerging Technologies in projects/ Works of value not less than 100 crores in Metropolitan Cities.

MoUD vide No. JS/Works/OM/2016 dated 30th May, 2016 has issued an office memorandum for use of following three technologies in CPWD works:-

1. Monolithic Concrete Construction System using Aluminium Formwork.
2. Industrialized 3-S system using Cellular Light Weight Concrete Slabs & Precast Columns (Precast/Prefab)
3. Monolithic Concrete Construction System using Plastic – Aluminium Formwork.

Adopting the above technologies, a Turnkey project item with scope and payment schedule is here by added to DSR 2016. The rates of the items are according to the scope of work as mentioned in annexure and are indicative only; the NIT approving authority may modify and add or delete these rates as per the work/ project requirements/conditions/scope.

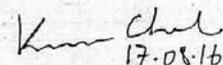
Construction shall be done on turnkey basis by adopting monolithic concrete construction system using customized aluminium /plastic aluminium form, or industrialized system using partly / fully precast slabs, beams and columns (Precast / prefab) with cast in situ joints for the superstructure and cast in situ methodology for foundation.

Payment shall be made stage wise; a payment schedule is provided as guideline. Payment schedule is indicative, NIT approving authority shall further breakup the payment stages but above percentage limits must not be exceeded for any particular stage.

The industrialized 3-S system using Cellular Light Weight Concrete Slabs & Precast Columns (Precast/Prefab) is restricted up to seismic Zone IV only.

The technology is new and idea of turnkey project/work based on these technologies is not experienced by the CPWD, hence experience/suggestions/ inputs are also invited for future refinements.

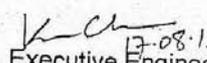
This issued with the approval of DG, CPWD.

  
17.08.16  
(Kunwar Chandresh)  
Executive Engineer  
CSQ, CPWD, Nirman Bhawan, New Delhi

No.133/SE/(TAS)/CS-DSR-2016/2016-17/ 198-E

Copy to: All the SDG/ADG/CEs/CPMs through CPWD website <http://cpwd.gov.in>

Dated: 17.08.2016

  
17.08.16  
Executive Engineer  
CSQ, CPWD, Nirman Bhawan, New Delhi

S.No.	Item	Unit	Rate in Rs.
<b>1</b>	<b>TURNKEY PROJECTS (Item)</b> Construction of multi-storeyed RCC residential buildings six storeys and above including planning and designing by incorporating stipulated specifications, internal and external services (E&M and Civil), external development, horticulture works on design built and handover basis adopting monolithic concrete construction system using customised aluminium/plastic aluminium form, or industrialised system using partly/fully precast slabs, beams and columns (Precast/prefab) with cast in situ joints for the superstructure as detailed in the Annexure all complete		
	<b>1.1</b> Foundation work upto plinth level (without basement) ( Complete in all respect as detailed in Annexure ).	Per sqm of plinth area of ground floor	
	<b>1.1.1</b> Isolated footing		4620
	<b>1.1.2</b> Raft foundation		10110
	<b>1.1.3</b> Pile foundation		14610
	NOTE: NIT approving authority will pick up any one type of the foundations. Rates of raft foundation not to be included in single basement.		
	<b>1.2</b> Single Basement ( Complete in all respect as detailed in Annexure ) NOTE: Single basement rate includes raft foundation in addition to items in the Annexure.	Per sqm of plinth area of basement	17770
	<b>1.3</b> Stilt portion ( Complete in all respect as detailed in Annexure )	Per sqm of plinth area of stilt.	9440
	<b>1.4</b> Super Structure ( Complete in all respect as detailed in Annexure )	Per sqm of plinth area of superstructure	16820
	<b>1.5</b> Development works ( Complete in all respect )	Per sqm of area developed	*

\* The scope and rate of development works shall be decided by the NIT approving authority as per requirements and site conditions.

**NOTE:**

1. These rates are indicative; the NIT approving authority may modify and add or delete these rates as per the work/ project requirements/conditions.
2. Development area means plot area minus plinth area at ground floor.
3. Mummy and appendages shall not be counted towards a storey.
4. The industrialised 3-S system using Cellular Light Weight Concrete Slabs & Precast Columns (Precast/Prefab) is restricted up to seismic Zone IV only.

Annexure**Scope of Work**

The work shall be executed on Turnkey (Design, Built and handover) basis from conception to commissioning, including all services (E&M and Civil), in situ & pre cast RCC components, in accordance with layout plan and architectural / structural / Services / landscaping / Horticulture works drawings. All drawings shall be prepared by the contractor and got approved from CPWD and also from the statutory bodies. However, the scope of the work shall include but not limited to as under.

**1. PLANNING****1.1 Architectural Planning.**

1.1.1 Architectural planning shall be done by the agency on the basis of requirement and Architectural control parameters supplied by CPWD Architect / Senior Architect / Chief Architect based on local byelaws/government norms, OM No. 22011/01/2008-W3 DG/Arch/6 dated 07/08/2013 etc. (NIT approving authority to give these parameters in NIT)

1.1.2 All Architectural provisions shall conform to local byelaws, ECBC and minimum three star GRIHA rating. Presentation drawings including 3D modeling, walk-through and building models may be prepared by the contractor to obtain approval from CPWD before submitting it to local bodies / authorities.

1.1.3 Contractor has to obtain all required statutory approval before starting the construction works from authorities concerned for example local bodies, NGT, PCBs, Ground water board etc.

1.1.4 Contractor shall carry out site survey of its own to verify the details including dimensions and levels of the available site.

**1.2 Structural Design**

1.2.1 Structural designs shall be carried out by the contractor based upon approved Architectural designs / drawings.

1.2.2 Structural design shall be done in accordance to National building code 2005 and referred IS Codes therein; International good practices and sound Engineering practices in that order of precedence.

1.2.3 All structural designs shall be got proof checked from agency to be decided by NIT approving authority.

1.2.4 The soil investigation shall be carried out by the contractor as per IS codes before commencing the design works.

1.3 Planning and designing of Mechanical, Electrical and Civil services.

1.3.1 Contractor shall plan and design all possible services including Civil, Electrical and Mechanical services etc. as per site requirements and Architectural requirements conforming to relevant IS codes and local by-laws.

1.3.2 Designs shall be got proof checked from agency to be decided by NIT approving authority.

1.4 Horticulture / landscaping works: contractor shall prepare Horticulture / landscaping works as per local byelaws and requirements specified.

## 2. CONSTRUCTION

Construction shall be done on turnkey basis by adopting monolithic concrete construction system using customized aluminum/plastic aluminum form, or industrialized system using partly / fully precast slabs, beams and columns (Precast / prefab) with cast in situ joints for the superstructure and cast in situ methodology for foundation. The different component shown in schedule shall have the following scope.

2.1 Foundation up to plinth level - Construction of foundation shall be done as per the approved structural drawings.

2.1.1 Isolated footing (cast in situ) - It includes Excavation, lean concreting, reinforcing, shuttering and casting of footing, columns, beams up to plinth level as per the approved concrete design mix, all complete.

2.1.2 Raft foundation (cast in situ) - It includes Excavation, lean concreting, reinforcing, shuttering and casting of raft foundation, columns, and beams up to plinth level as per the approved concrete design mix, all complete.

2.1.3 Pile foundation - It includes all types of piles (Pre cast, bored cast in situ etc.), pile caps, including reinforcement, concreting, columns, and beams up to plinth level as per the approved concrete design mix, all complete.

2.2 Single Basement including foundation - Construction of Single basement includes excavation, leveling of surface, lean concreting, reinforcement, shuttering and casting by concrete of design mix as approved, all works required for raft foundation and all columns beams, slabs upto roof level of basement, including concrete retaining wall all around in the basement up to the basement roof height (Height of the basement taken 3.35 metre below soffit of beam), Pressurized mechanical ventilation system, Firefighting with sprinkler system, Automatic fire alarm system, lifts serving basement, Water proofing of basement, flooring and finishing with electrical light fittings drainage system

etc, all complete but excluding equipments pertaining to DG set , Air-conditioning, Substation.

2.3 Stilt portion - Construction of stilt includes flooring and finish as per the specifications with all services required in the stilt portion (E&M and Civil) including Fire fighting, Automatic fire alarm system, lifts serving stilt floor and finishing all complete with electrical lighting, fan fittings, internal services etc. all complete but excluding equipments pertaining to DG set , AC, Substation.

2.4 Super structure shall be constructed adopting monolithic concrete construction system using customized aluminum/plastic aluminum form, or industrialized system using partly / fully precast slabs, beams and columns (Precast / prefab) with cast in situ joints or any combination thereof including all internal Civil, Electrical and Mechanical services including plumbing ,drainage, fire fighting, fire alarm, lifts , lighting etc, all complete but excluding equipment pertaining to DG set , Air-conditioning and sub-station etc.

2.5 Development work - The scope of development works shall be decided by the NIT approving authority as per requirements and site conditions and accordingly rates are to be worked out based upon area to be developed.

2.6 Specifications / Amenities - The Specifications / Amenities shall conform to MOUD office memo OM No. 22011/01/2008-W 3 DG/Arch/6 dated 07/08/2013

2.7 The construction in general shall be carried out as per the CPWD Specifications Vol-I and Vol-II 2009

### **3. HANDING OVER**

3.1 The contractor shall hand over the completed work / project to CPWD after removing all defects and after :

3.1.1 Obtaining completion certificate from local bodies.

3.1.2 Obtaining GRIHA certificate.

3.1.3 Water and sewer line connection.

3.1.4 Road / path connection.

3.1.5 Electricity connection.

3.1.6 Fire clearance certificate.

3.1.7 Obtaining certificate for lift operation.

3.1.8 And any such certificate / compliance that may be required as per prevailing Bye Laws, Rules / Regulations and Court Order / Judgment etc.

3.2 The contractor shall submit all such certificate and receipt to CPWD as mentioned above for their verification and acceptance.

**4. Measurement:-** Methodology of measurement shall conform to Annexure-III of CPWD Plinth Area Rates 01.10.12 (PAR 2012) for payment.

4.1 Foundation work upto plinth level (without basement) - Plinth area of the ground floor shall be measured for payment.

4.2 Single Basement upto plinth level - Plinth area of the basement floor shall be measured for payment. Considered height of single basement is minimum 3.35 meter below soffit of beam.

4.3 Stilt portion - Plinth area of the stilt floor shall be measured for payment.

**4.4 Super Structure:-**

4.4.1 Plinth area of the superstructure shall be measured for payment.

4.4.2 Plinth area of the stilt floor shall be measured separately for payment

4.5 Development works - Development area shall mean plot area minus plinth area at ground floor. Developed area shall be measured for payment.

*PAYMENT SCHEDULE (Guidelines only)*

S.No.	Description	Individual %age	Cumulative %age
1	Submission and approval of all architectural drawings, layout, building plans containing all details, specifications required for execution of work including development plans.	0.40	0.40
2	Submission and approval of foundation designs and complete structural drawings for superstructure, UG Tank complete and other works to be executed at site for its completion.	0.40	0.80
3	Submission and approval of all services plans from local bodies/Authorities etc.	0.10	0.90
4	EIA and Environmental Clearance	0.10	1.00
5*	Completion of structure work including foundation, superstructure and corresponding electrical and civil works etc.	50.00	51.00
6*	Finishing all complete including all civil ,electrical and mechanical works/services etc. fully functional	40.00	91.00
7	On completion of project	5.00	96.00
8	On handing over of flats as per scope of work.	4.00	100.00

(\* ) Payment schedule is indicative NIT approving authority shall further breakup the payment stages according to factual situation of project and for maintaining regular cash flow, but the sum total of percentages of the breakup stages shall not exceed the above percentage limits.

F.No.28012/7/2016-W-3  
Government of India  
Ministry of Urban Development  
(Works Division)

\*\*\*\*

Nirman Bhawan, New Delhi  
Dated the 28<sup>th</sup> December, 2016

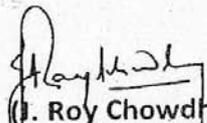
**OFFICE MEMORANDUM**

**Subject:- Adoption of New & Emerging Technologies in construction work of value not less than Rs.100 crores in Metropolitan cities, undertaken by CPWD, DDA and NBCC – reg.**

Reference is invited to Ministry of Urban Development's OM dated 30.05.2016 on the above mentioned subject wherein inter alia it was mandated that CPWD, DDA and NBCC would adopt 3 (three) new Technologies viz. (i) Monolithic Concrete Construction System using Aluminium Formwork, (ii) Industrialized 3-S System using Cellular Light Weight Concrete Slabs & Precast Columns (Precast/prefab) and (iii) Monolithic Concrete Construction System using Plastic – Aluminium Formwork, initially in the Metropolitan Cities of India, where the value of works is Rs.100 crore or more.

2. The matter has been considered further. It has been now decided that the aforesaid new technologies may be mandatorily adopted for all projects across the country, irrespective of location and project cost **with effect from 01.04.2017**. In case, it is not found feasible to implement these provisions in a particular project, specific permission should be accorded by DG, CPWD/CMD, NBCC/Vice Chairman DDA respectively on case to case basis, with detailed justification.

3. This has the approval of Hon'ble UDM.

  
(J. Roy Chowdhury)  
Deputy Secretary (Works)  
Tel. No. 23062425

To

1. Vice Chairman, DDA, Vikas Sadan, INA, New Delhi-110023.
2. Director General, CPWD, Nirman Bhawan, New Delhi -110011.
3. CMD, NBCC Limited, NBCC Bhawan, Lodhi Road, New Delhi-110003.

Copy for information to :

1. PS to Hon'ble UDM, PS to Hon'ble MoS, PPS to Secretary(UD), PPS to AS(UD) & PPS to AS(SC).
2. All Joint Secretaries/Economic Adviser/OSD(UT)/JS&FA in M/o UD.
3. All Director/D.S. in M/o UD.
4. Office Memorandum file – US(W-3).
5. IT Cell for uploading in e-office.





Nellore, Andhra Pradesh – 2016

**bmtpc**

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