

THE YOUNGLOVE CONVEYOR

FOR EMPLOYEES AND FRIENDS OF YOUNGLOVE CONSTRUCTION, L.L.C.

► Leaders in the design and construction of bulk materials handling facilities

Builders of value... Builders of trust... Since 1896

Critical Lift Planning

“Kenny’s 2 Pennies” by Kenny G. Gubbels, Senior Project Manager

With the demand of higher throughputs at agricultural facilities constantly increasing, manufacturers, facility designers, and construction crews are facing more challenges than ever in building these facilities. Everything nowadays is larger, heavier, taller, farther away, more awkward, and with tighter tolerances than ever before. In our industry, almost every major item that shows up on the job site has to be hoisted or lifted into place with a piece of equipment; and most of the time that’s done with an on-site crane.

With the increased size of equipment, bridges, etc., “critical lifts” on the job site are becoming an every-other-day occurrence. Per OSHA, a critical lift for crane hoists is defined as lifting a load greater than 75% of the rated capacity of the crane (based upon the crane configuration).

Critical lift planning needs to start way before ground is ever

broken on the project. The engineer, manager, and superintendent need to be involved to define critical lifts during the design and estimating phase, as these lifts can have major effects on the project.

For me, critical lift planning starts when requesting quotations on equipment, bridges, hopper tanks, etc. Always ask for the weight of the quoted item. Even an estimated weight from the supplier is better than nothing or guessing. Having this information will help in selecting the cranes needed for the project, the size and span of the bridges you should be designing around, or how far the equipment or materials can be shop assembled before being shipped to the job site. This will determine what lifts will be critical.

Once you have a handle on sizes and weights, you can start to look at the best crane options to complete the job. There are many variables here, so I will just cover the basics.

I typically start by looking at what the crane will be sitting or floating on (and barge crane picks are where the real fun begins!). This will determine a lot about the selection of the crane for the critical lift. For example, if the ground will not support the load



of the crane, it will have to be matted with a crane deck before operating the crane; or you may have to build roads or do large amounts of dirt work to position the crane where you’ll need it for a critical lift.

Second, I look at the size, type, and number of cranes required for the critical lift. This typically comes down to what equipment is available in the area you are working in and what type of lift you are making. For example, if a load has to be lifted and carried a distance to a set point, a crawler-type crane may be the best choice. If a quick in-and-out critical lift is required, a hydraulic crane may be the best choice due to the

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“Critical lift planning needs to start way before ground is ever broken on the project.”

PATIENCE

By Ken I. DuBois, President



In the construction industry, the word “patience” is certainly an atypical one. Construction is founded on action-based principles—work hard, work harder, and can’t you work harder than that?! If hard work does not sound appropriate, how about, “Get your butt moving faster, faster, faster!” (We offer a PG rating or less in our *Conveyor* articles.)

Clearly we push the limits when trying to become more efficient in order to finish our projects in accelerated time frames. This allows the facilities we construct to begin producing sooner; and, the sooner a project is completed, typically the larger our profit will be. So how does patience factor into the equation in our industry?

In my 21 years in the construction industry, I would estimate the first half was centered on the principles I mentioned in the first part of this article. Since then, being patient has become a more predominant principle. It may very well be that having four kids in the second half of my professional career has had something to do with that!

The less patient I am with my kids, the more it seems I am pushing a rope. When I raise my voice a few levels and demand a changed behavior, it may work for the moment; but it rarely changes future behavior. When I calmly and firmly describe a behavior that needs to be modified by my kids, they all (even my 4-year-old, Ava) seem to turn the corner and, in the

future, remember what the proper behavior is to be (versus remembering Dad’s loud voice!).

Several years ago I polled numerous Younglove Superintendents on what they felt their top strengths were. I figured I would get a lot of top responses on planning, motivating, communication, hard work, or other traditional leadership topics. Several of these items were mentioned, but the one receiving the most top marks was patience. Patience was in the top one or two of almost every Superintendent’s list.

Our job site leaders clearly need to be strong in the requirements to construct the projects; i.e., forming techniques, concrete placement methods, weld symbols, proper equipment installation details, etc. However, leading their crews effectively requires several “tools”; and, without patience, it is difficult to put many of the others into practice.

From the office, patience probably looks and feels different than on the job site. We have to be patient when evaluating and providing proposals for projects. We need to be patient while awaiting feedback after sending out a bid. There has been more than one instance where an initial discussion with a prospective client has taken years before the project became a reality. We need to practice patience when receiving negative feedback from an owner, supplier, subcontractor, or even the job sites.

While patience can look different at home, work, or play, we must continue to work toward improving this personality trait. When my patience seems to be at an appropriate level, I know I feel more at ease in my decision making—and I know the people around me definitely reap the benefits. (Just ask my children!)

(continued from Page 1)

quick set-up time. Or perhaps it’s a two-crane pick—hydraulic and crawler. All of these factors need to be risk managed and reviewed.

Third, I start the process of completing a critical lift planning document. This is a formal document required by OSHA that sets out the details of the pick. This would include general information (date, job site, lift description, lift location, lift height, etc.), personnel information (the crane operator, lift superintendent, riggers, etc.), and lift criteria (rigging techniques, lift hazards, number of cranes, etc.). This document will also cover crane capacities when lifting, maximum wind speeds during lifts, ground conditions, and communication to all parties involved with the lift.

Depending on the complexity of the critical lift, sometimes it is best to consult a heavy lift engineering firm to complete this document and provide an engineered lifting plan, complete with engineer-stamped drawings.

Not only is OSHA wanting this documentation, but your insurance company will also want this information on any high-risk lifts of high-value materials or equipment. Typically you should contact your insurer before any high-dollar lifts are made. Many times they have a team of risk managers that will want to review your critical lift plan. A complete and detailed critical lift plan will result in less push back and Monday-morning quarterbacking from the insurance company.

Finally, after the critical lift plan is complete, a pre-lift meeting is held on the job site with all parties involved. The critical lift plan is reviewed (and sometimes modified), and then the lift can begin! ■

Sinclair Milling Up and Running

Feed Mill; Sinclair Milling, Inc.; Parkersburg, Iowa

*Ken DuBois, Project Executive; Carlos Rodríguez, Project Manager; Dar Bierman, Project Superintendent
Tricia Welch, Project Design Leader*

With a two-phase start-up, the new Sinclair Milling facility is up and running in Parkersburg, Iowa. Production of mash feed started in late 2015, and pelleting production started during the first part of 2016. This mill is now under Sinclair Milling's operation.

As mentioned in previous issues, this was our first project for Sinclair Milling. We would like to thank them for their confidence and trust in Younglove Construction; and we are looking forward to working with Jim Luebbers, Roger Baker, and team again, as we hope this facility will be the first of many in a great partnership.



SAFETY OUTLOOK

500 and Counting!

By Randy J. Hooey, CSP, Director of Safety



team. The goal of our company is

Those of us at Younglove are proud of our safety culture and what that culture has helped us achieve as a

to send everyone home each day, proud of their achievements and injury-free.

Our commitment to safety with regard to job site planning, leadership training, employee training, and continuously reviewing safety expectations to make sure we walk the talk has been crucial for our safety success.

Thanks to everyone with Younglove for helping us build our outstanding safety culture. We are a safety leader in our industry with an injury rate below **1.5**. Currently, **our people have worked over 500 days without a loss day injury.**

Once again, thanks to everyone for our safety success.

Great job, everyone!

West Memphis Equipment Installation and Conveyor Bridge Construction Complete

Barge Terminal; Louis Dreyfus Company; West Memphis, Arkansas
Ken DuBois, Project Executive; Jon Branning and Kenny Gubbels, Project Managers
Terry Reinert, Project Superintendent; Joe Newman, Project Design Leader

The West Memphis truck-to-barge facility is nearing completion. It hasn't come without its many challenges of rising and falling river levels, but we have now finished pouring all of the concrete and are focusing on installing the equipment and half-mile-long conveyor bridge.

All of the tunnel equipment, including the receiving drag and

belt conveyors and supports, are installed, wired, and ready to go. The receiving bucket elevators are set, stacked, and braced back to the silo structure and leg tower. We have also erected and installed the leg towers and conveyor bridges at the roof.

The cone hoppers have been hung and welded in each of the four silos. The aeration required in

two of the silos has been installed and ducted back to the fans, and we've installed

the reclaim drag and belt conveyors below the silos. The transitions between each piece of equipment are currently being fabricated. In between the cone hopper completion and equipment installation, the painting subcontractor was able to squeeze in and finish up the painting of the cone hoppers.

The grain dryer and steel tank were erected by our subcontractors, and equipment installation is proceeding. We've installed the wet and dry bucket elevator legs and dry grain drag conveyors (one below the grain dryer and one at the roof for distribution to the silos). It won't be long before Terry's crew begins installing the belt and cups for each of the bucket elevator legs.

Installation of the equipment associated with the steel tank is also nearly complete, and we've installed the reclaim gates and belt conveyor. Younglove has erected and set the support tower and



Above: Setting the conveyor bridge over the 92-foot-diameter steel tank

Right: Erecting the 250-foot-long span of the levee bridge



LDC.
 Louis Dreyfus Company

conveyor bridge feeding the steel tank structure. The belt conveyor was installed on the conveyor bridge prior to setting it with the crane, so only the spouting and transitions to and from this belt conveyor remain there.

Out at the river, one of our sub-contractors completed the barge loadout tower and spout and installed all of the bents and towers at the half-mile-long conveyor bridge. Following this work, Younglove had a crew build the conveyor bridges with the conveyor installed before setting them. We started out building these bridges at the river by the barge loadout tower and spout and then headed inland toward the silo structure. Younglove's crew set the 250-foot-span bridge over the levee on April 25th. This was the longest spanned, most complicated, and most carefully planned crane pick on this project—so completing it was a major milestone!

Going forward on the rest of this project, the electrical sub-contractor will be completing wiring and terminations. Younglove's crew will be finishing up construction on the sample building and installing truck probes, fabricating and finishing the spouting and transitions between the different pieces of material handling equipment, completing punch list items, and preparing for the automation and controls subcontractor and start-up of the facility.

We look forward to finishing up another successful project for Louis Dreyfus Company so they are able to receive grain this fall and ship it down the river to another one of their great facilities!

Ardent Mills Silo Gearing Towards May Slip

Midds Silo; Ardent Mills, LLC; Decatur, Alabama

Ken DuBois, Project Executive; Carlos Rodríguez, Project Manager

Steve Johanson, Project Superintendent

Brian Hickson, Project Design Leader

The new Ardent Mills silo project in Decatur, Alabama, is now in the midst of pre-slip activities. After dealing with some delays due to weather and relocation of existing utilities, Steve Johanson and crew were able to finish pouring the mat slab for the 30-foot-diameter silo.

The silo slip is schedule for the third week of May, followed by the

completion of an overhead slab, roof, and crossover bridge to the existing mill.



This project should be completed early summer of 2016.



Mat slab rebar placement

22 Employees Honored for Years of Service with Younglove

Service Awards Chosen

- Taylor Semi-Hollowbody T3 Series Electric Guitar
- Sony Camera with Interchangeable Lens
- Troy-Bilt Bronco Riding Lawn Mower
- Old Town Saranac 160 Canoe
- Lenovo 2-in-1 Touch-Screen Laptop
- Cabela's Commercial-Grade Vacuum Sealer
- KitchenAid Stand Mixer
- Blueridge Historic Series Acoustic Guitar
- HP Pavilion 17.3" Laptop
- Samsung Home Theater System
- Makita Electronic Polisher/Sander with Polishing Kit
- Seiko Lady's Watch
- T-fal Hard Anodized Cookware Set
- Cabela's Comfort Trac Rubber Boots
- Insignia™ 24" HDTV
- Cuisinart Programmable Coffee Maker with Hot Water System
- Karaoke System
- RCA Home Theater System
- Motorola Radio Pack
- Homelite Gas Chainsaw

At Younglove, we know our success is based on the loyalty of our employees. Many of these talented, hard-working, and dedicated people have been with us for a number of years. Each year we honor those who have achieved milestones in their service to us, and this year we honor the 22 employees shown on these pages. As a small token of our appreciation, we were pleased to present each of these individuals with a gift of his or her choosing.

*Congratulations,
and thank you for your
hard work and dedication!*



Dar Bierman
Project Superintendent
35 Years



John Severe
Design Technician
35 Years



Allan Beatty
Truck Driver
30 Years



Fred Frahm
Foreman
30 Years



David Milian
Foreman
30 Years



Mona Bangert
Jobsite Administrator
20 Years



John "Kenny" Fuller
Asst. Superintendent
20 Years



Terry Reinert
Project Superintendent
20 Years



Jarret Bierman
Asst. Superintendent
15 Years



Thomas Cravens
Foreman
10 Years



Oscar Zamora
Millwright
10 Years



John Dorman
Operator
5 Years



Greeley Guerra
Project Superintendent
5 Years



Felipe Gutierrez
Millwright
5 Years



Eustacio Hernandez
Carpenter
5 Years



Larry Keesis
Lead Foreman
5 Years



Jacinto Mendieta
Laborer
5 Years



Francisco Montez, Jr.
Welder
5 Years



Jose Mota
Laborer
5 Years



Rodolfo T. Perez
Millwright
5 Years



Frank Romero
Foreman
5 Years



Jose Sanchez
Carpenter
5 Years

John Severe

retired from Younglove on March 25 after serving for 35 years as one of our Design Technicians.



John began working for Younglove in 1980. From that time until 1996, he worked on no less than 104 projects. In January of 1996, the company began assigning a specific Design Leader for each project. From 1996 through 2016, John was the Design Leader in charge of an additional 26 projects. That's more than 130 projects! (And that doesn't even include the prospects he worked on!)

Several have described John as being a dedicated, hard-working, and conscientious employee whose drawings were always very organized and clear. His knowledge, experience, and strong work ethic will truly be missed by the company.

*Congratulations, John!
Enjoy that retirement!*



Jim Nelson

joined the Younglove team as a Design Technician beginning April 1. He obtained his degree from Northeast Community College in South Sioux City, Nebraska, in 2014 and has since put his drafting skills to use at Tyson Meats and C.W. Suter Services.

Welcome aboard, Jim!

Continuing Education

By Karl L. Pittmann, Project Manager



Work, family, an active social calendar, and the general chaos of day-to-day life can make it feel impossible to find time to squeeze any type of education into our lives. I sit here and stare at the piles of books I purchased for my PE exam. Half of them have not been opened; the other half I only opened to browse through them. I keep telling myself I'll get started when one job comes to a close and the next one isn't so busy; but then, on the other hand, my wife and I are expecting our second child late this summer—just before the exam. So when will I have time to study?

With everything going on in our lives, education probably never crosses our minds. We live in such a fast-paced society and are attached to our jobs through technology in such

a way that we truly never “get away”. The idea of “work-life balance” seems, at times, almost impossible. But at the same time, that technology is a blessing when it comes to education. Not only can we take on-line courses, but we can view new and up-to-date codes and safety changes. The construction industry is an ever-changing, fluid business where codes and standards can change overnight.

For our industry in particular, we have several avenues we can take for continuing education. Some of them might have to be searched out, while others are easily accessible. The Grain Elevator and Processing Society (GEAPS) offers on-line courses though K-State for information on the grain and milling industry. Saturday courses are available for electrical codes (www.electrical.nebraska.gov/pdf/2015-2016-CE.pdf). The National Fire Protection Association (NFPA) offers on-line courses. There's the World of Concrete in Las Vegas. WITCC (our local community college) offers courses. And there are many others.

The point: It is never too late to take a course. Whether it is to get a better understanding of the industry you are in or to be more informed on codes and standards or new safety requirements, there is always something you can learn.

“Intellectual growth should commence at birth and cease only at death.”

— Albert Einstein

Jodi Miller

took on the reins of Chief Financial Officer as of April 1. Jodi is not new to our company, as she's been with the Klinger Companies since 2000. She was originally hired on as the Accounting Manager and was promoted to Controller in 2004.

Jodi attended Briar Cliff University in Sioux City, Iowa, where she majored in Accounting and minored in Business. She then went on to achieve her CPA certification.

Congratulations, Jodi!



The position of Chief Financial Officer was formerly held by **Bob DeSmidt**, who began working for the company back

in 1977. Over the years, his position expanded into also taking on the role of human resource director and reviewing all of our contract language and insurance work.

After a long and successful career with us, Bob has decided to begin retiring in a “phased-down” manner during 2016. He has already spent the last several months training others in the various aspects of his position; and, beginning in June, Bob will begin working part time as he continues to work on some special projects and mentor the staff taking over his duties.

*Congratulations, Bob,
on a job well done!*



Fries Farms Project Complete

Feed Mill and Grain Storage; Fries Farms, L.L.C.; Surrency, Georgia

Loren Field, Project Executive; Jared Myers, Project Manager; Dave Wilberg, Project Superintendent

Pat Ebner and John Severe, Project Design Team

Younglove is pleased to announce this facility in Surrency, Georgia, has been commissioned and turned over to Fries Farms to operate.

We would like to thank Fries Farms for the opportunity to design and construct this facility and to be a part of their growth and team.



**Claxton Chicken
Fries Farms, L.L.C.**



Top: New feed mill

Bottom: Grain storage annex, 100-foot-diameter silo, new receiving, and grain dryer

Left: Feed mill and warehouse

Great Progress Made at Pomeroy

Feed Mill; NEW Cooperative, Inc.; Pomeroy, Iowa

**Ken DuBois, Project Executive; Karl Pittmann, Project Manager; Dave Johansen, Project Superintendent
Kelly Henrichs, Project Engineer; Tricia Welch, Project Design Leader**

As Spring hits its stride, so does our crew in Pomeroy, Iowa.

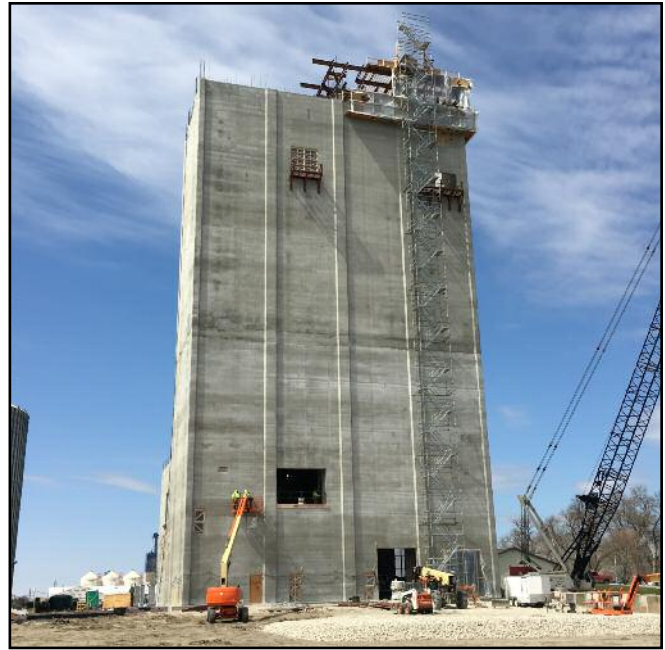
Dave Johansen and crew have the mill tower up, and installation of the bin hoppers is in full swing.

The crews are busy installing floors, stairs, and other structures. Dirt work around the site for the tilt panel foundations began in early May.

Dar Bierman and his crew will be joining us to help with installation of the tilt panels around the site, which will include the warehouse/high bay, tank farm,

boiler room, air compressor room, loadout canopy, and receiving/grinding building.

As equipment starts to roll in, the crews are eager to begin installing it. The block masonry work has been completed, and painting in the pellet tower is under way.



PROJECT UPDATE

Younglove Awarded Mar-Jac Project

Feed Mill; Mar-Jac Poultry AL, LLC; Spruce Pine, Alabama

**Jared Myers, Project Executive; Joey Posivio, Project Manager; Jim Hornung, Project Superintendent
Pat Ebner, Mohammad Fotouhi, and Brian Hickson, Project Design Team**

We are pleased to announce that Younglove has been selected to construct the new poultry feed milling facility for Mar-Jac Poultry in Spruce Pine, Alabama.

After some lengthy site development delays, dirt work is cruising forward while Jim Hornung and crew mobilize to begin site set-up and construction. The site will include a railroad loop track so unit

trains of corn can be received. The track will cross an existing ravine in one area, which will require approximately 70 feet of fill placement to bring it to the proper grade.

The all-concrete feed milling facility will be comprised of a receiving tunnel with both rail and truck pits; slipformed mill tower and silo six-pack for grain and soy meal



storage; and tilt-panel grinder room, receiving building, boiler room, and warehouse. Over 11,000 cubic yards of concrete will be placed by the time the project is complete. Completion is scheduled for late fall of 2017.

Younglove first worked for Mar-Jac in Maysville, Georgia, in 2004. We're pleased to once again be teaming up with them on this exciting project!

Start-Up Begins at International Nutrition

Rebuilt Animal Feed Pre-Mix Plant; International Nutrition, Inc.; Omaha, Nebraska
Bill Bradbury, Project Executive and Project Manager; Terry Dunnette, Project Superintendent
Tricia Welch, Project Design Leader

The new animal feed pre-mix plant for International Nutrition is very close to being completed. Terry Dunnette and crew are now finishing up miscellaneous final work items and assisting the Owner in start-up of the facility.

The facility has seven mixers and bagging lines. Four of the mixers are on load cells, which greatly simplifies the plant flow and reduces the handling of dust-producing

ingredients prior to the mixers, where mineral oil is then added.

For the bagging systems, the City of Omaha required that an OSHA Nationally

Recognized Testing Laboratory (NRTL) certify each of the

four main bagging system assemblies. CSA (1 of 17 NRTLs) was brought in to inspect and certify each of these lines.

Thanks to International Nutrition for allowing us to be



Office entrance



Receiving driveway with bulk storage bins above

involved with them in the design and construction of their new manufacturing facility.



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 Builders of trust*

The Younglove Conveyor is published twice a year by

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 P.O. Box 8800 (51102)
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The Younglove Conveyor, Vol. 16, Issue 1

Younglove...Since 1896

YOUNGLOVE MISSION STATEMENT

Our mission is to provide premier construction services, including design, construction, and project management. We build enduring value and trust using a dedicated team approach to continuously improve customer satisfaction, safety, quality, and our work environment.



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PROJECT UPDATE

Work Wrapping Up in Corning, Arkansas

Feed Mill; Peco Foods, Inc.; Corning, Arkansas

Loren Field, Project Executive; Karl Pittmann, Project Manager; Jim Hornung, Project Superintendent

Pat Ebner and Brian Hickson, Project Design Team

As Jim Hornung and crew put the final touches on the Corning, Arkansas, project, let's look back to where we started. It was almost two years ago when Younglove was awarded its third project for Peco Foods. Jim and crew mobilized to the site in May/June of 2014.

That winter the crews worked to get both the mill and grain silos slipped before the spring of 2015. By August of 2015, Peco Foods was able to start grain receiving in their three 650,000-bushel bins. By January 2016, start-up in the mill was under

way, with Peco making their first batch of pelleted feed in February.

Today Peco has full control over the site, with Younglove assisting in tuning the mill.



As this was my first project with both Peco and Younglove, I take personal pride in the work

Jim and crew have done to make this project so successful.

We look forward to future opportunities to work with Peco Foods, Inc.