

leader. “The increased lead times are something we can account for as long as we know and can plan for them.”

“Based on the size of projects, we are looking at subcontractors that can handle those projects and beginning discussions with them early to incorporate them as part of the team,” adds McAllister. “If we don’t engage subcontractors early, we run the risk of projects being delayed. Clients understand the market but look to us to manage the risk and keep them on schedule.”

Today, processors expect A&E/C firms to take on a co-leadership role in and contribute accountably to a deliberate process of achieving the fastest, safest, most economic start-

up, says Tom Wiersma, independent A&E consultant. Most clients have the experience to anticipate and build into their thinking the impacts of a tight labor market and the bottlenecked availability of some fundamental building materials. Therefore, to get started on the right foot, most food processors are more comfortable than ever with engaging a preferred architectural and engineering firm or AEC mobilization consultant early in the pre-project programming and scope phases.

### PREFAB AND MODULARITY

To help compensate for labor shortages and simplify construction, many A&E/Cs

## Reported new construction projects

The following charts list new construction projects reported by respondents to the 2020 Plant Construction Survey. For expansion and renovation projects and charts listing all projects combined, visit [www.foodengineeringmag.com/plant-construction](http://www.foodengineeringmag.com/plant-construction)

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
121 In-Flight Catering	San Francisco	CA	RTE meals	New	50	15	CMC Design-Build Inc.	11/19
7-Eleven	Bellingham	MA	Cold storage	New	15	2	CMC Design-Build Inc.	8/19
80 Acres Farm	Hamilton	ON	Produce growing/processing	New	30			10/19
<b>A</b>								
Aalco Distributing	Ft. Wayne	IN	Beverage distribution	New	105		ARCO National Construction	8/19
Actagro	Biola	CA	Agricultural enhancements	New	11		EA Bonelli + Associates	19
AgTech Scientific	Paris	KY	Hemp processing	New	2000			12/19
AgTech Scientific	Paris	KY	Hemp extraction	New	50			12/19
Ahold Delhaize	North Kingstown	RI	Meat	New	200	100	Dennis Group	3/20
Alexandron	Carmel	NY	Distillery	New			Epstein	19
Alpla	Bowling Green	KY	Contract bottler	New		50		19
Amazon UFF	Boston	MA	Cold storage	New	30	5	CMC Design-Build Inc.	10/19
Amazon UFF	Indianapolis	IN	Cold storage	New	30	5	CMC Design-Build Inc.	10/19
Amazon UFF	Las Vegas	NV	Cold storage	New	30	5	CMC Design-Build Inc.	2/19
Amazon UFF	Orlando	FL	Cold storage	New	30	5	CMC Design-Build Inc.	8/19
Amazon UFF	Philadelphia	PA	Cold storage	New	30	5	CMC Design-Build Inc.	8/19
Amazon UFF	Raleigh	NC	Cold storage	New	30	5	CMC Design-Build Inc.	8/19
Americold	Rochelle	IL	Cold storage	New	180	93		8/19
Appalachian Harvest Company	Morehead	KY	Greenhouse, produce	New		85		19
Archer Daniels Midland	Mendota	IL	Flour	New		250		6/19

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have been using a well-established practice that is commonplace today. The modular approach—much like pre-manufactured homes—is to build skids or ready-to-go equipment in a modular section, for example, a “CIP skid.” Just like modular electronics, these sections are plugged in and wired at the plant and are quickly operational, as they’ve already been built and tested at the shop.

With the current set of 3D design tools and today’s automation equipment and simulation software, more prefabrication can be done off site, says Harlan VandeZandschulp, P.E., president of Gleeson Constructors & Engineers LLC. Offsite design and prefab at an integrator’s or machine builder’s location can help keep labor costs down and decrease the need for more skilled people at the construction site when they’re already hard to find.

This modular approach isn’t just for automation or process equipment. “Whether modularizing building components, pipe racks or equipment skids, this prefabrication technique executes work in a more controlled environment,” says Catt. “This decreases risks to productivity, eliminates other potential negative impacts, and creates an additional work front. In many cases, modularization helps lower overall construction costs while improving quality and schedule.”

“Office and utility areas of manufacturing facilities are prototypes for modular construction, but we are beginning to see more activity in all areas,” says Keith Perkey, VP—Food & Beverage Division, The Haskell Company. “We are also beginning to see more use of technology throughout the construction process. Augmented reality is being used for field quality checks to match design models to field

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>A</b>								
Aurora Organic	Columbia	MO	Fluid milk	New	127	100	MSKTD	1/19
<b>B</b>								
Barrett Petfood Innovations	Little Falls	MN	Petfood	New	160	18		10/19
Ben E. Keith	New Brockton	AL	DC	New	425	100		9/19
Bi Nutraceuticals	Reno	NV	Botanical ingredients + D/W	New	140	3		19
Blue Diamond Growers	Modesto	CA	Nuts	New	55		E.A. Bonelli + Associates	20
BlueScope Properties Group/Coca-Cola	Apopka	FL	Beverage mfg/dist.	New	290		ARCO National Construction	7/20
BlueScope Properties Group/Goya Foods	Apopka	FL	Cold storage	New			ARCO National Construction	6/20
BNutty	Portage	IN	Peanut butter	New	16			8/19
Bowery Farms	Nottingham	MD	Leafy greens	New	85	20	CMC Design-Build Inc.	12/19
BrightFarms	Etowah	NC	Packaged salads	New	280	21		10/19
BrightFarms	Penn Twp.	PA	Produce	New	250	20		4/19
Buzz Food Products	Charleston	WV	Meat	New	10	0.5	Epstein	5/19
<b>C</b>								
Canada Royal Milk	Kingston	ON	Infant formula	New	350		E.A. Bonelli + Associates	19
Canada Royal Milk	Kingston	ON	Infant formula	New	272		MDG Architecture	19
Canada Royal Milk	Kingston	ON	Dairy	New	272		E.A. Bonelli + Associates	20
Carolina Botanicals	Tabor City	NC	CBD (hemp)	New		4		12/19
Centro Sperimentale del Latte	Franksville	WI	Probiotics/ingredients	New				7/19

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installation; sensors are being deployed in the construction materials and the construction workforce to improve both quality and safety.”

### NEW VS. EXPANSIONS AND UPGRADES

Food processors are raising the need to respond to consumer demands and are looking to increase production, change technologies and meet food safety regulations, says Tyler Cundiff, VP, business development—food and beverage market, Gray Construction. When possible, they want to reallocate existing space and make modifications. But sometimes, mods/upgrades to existing facilities may not be practical.

Our survey found an increase in new projects in 2019. Can you feel the frustration of an older facility? If you have an aging warehouse or plant, you have to ask: Is it providing the capacity, performance and efficiency you need to

make a profit today? Twenty years ago, it may have been sufficient, and now you wonder if it's just not worth applying bandages anymore, especially with limited capacity and flexibility, “head knockers” and ancient automation equipment. Is greenfield a viable solution?

“Clients are finding that the cost of upgrading/renovating their facility is not that far off from building new,” says Luke Waite, ESI Group USA regional manager. “They find they may have antiquated equipment or mechanical systems—or that current operations do not meet food safety requirements—that have to be updated, which can significantly drive the cost of an expansion/renovation project up.” A new facility allows clients a clean slate, so to speak, to meet the updated food safety requirements for product/people separation as well as sanitation, limiting any possible interruption of

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>C</b>								
Champion Petfoods	Edmonton	AB	Specialty pet foods	New	427		Gray	11/19
Chewy	Salisbury	NC	Petfood fulfillment center	New	700	55		4/19
Chicago Vegan Foods	Chicago	IL	Marshmallows, vegan foods	New		25		9/19
Chick-fil-A	Cartersville	GA	DC	New				5/19
Claxton Poultry	Sylvania	GA	Poultry deboning, packaging	New	35	12		5/19
Coastal Beverage	Wilmington	NC	Beverage distribution	New	174		ARCO National Construction	8/19
Coca-Cola Co.	Houston	TX	Bottling and DC	New	980	110	Haskell	6/20
Coca-Cola Co.	South Windsor	CT	Beverage distribution	New	201		ARCO National Construction	11/19
Common Collabs	Knox	IN	Cold-brew coffee	New	60	22		12/19
Constellation Brands	Mexicali	MX	Beer	New			Alberici, Gilbane	10/21
Cornerstone PB Holdings	Pine Bluff	AR	Poultry	New				12/19
Cosmos Corporation	O'Fallon	MO	Petfood	New	190			8/19
Creekstone Farms	Arkansas City	KS	Distribution center	New	41	35	Gleeson Constructors & Eng. LLC	11/19
CS Beef Packers	Kuna	ID	Ground beef	New				3/19
Cuisine Solutions	San Antonio	TX	RTE foods	New	290	120		3/19
Curaleaf	Lexington	KY	CBD ingredients	New		9		19
<b>D</b>								
Dakota Investments/Bimbo Bakeries USA	Tomball	TX	DC	New	20			19
Dandelion Chocolate	San Francisco	CA	Chocolates	New	28			7/19
Danone	DuBois	PA	Plant-based yogurt	New				4/19

their existing production while meeting consumer demands, says Waite.

If you're a homeowner, you may have encountered this little "surprise" when you decide to renovate or upgrade, but on a plant-size scale, the added costs of bringing everything "up to code" gets pricey real fast. "When tackling renovations, companies are finding that upgrading plants requires upgrading to modern regulations and standards," says Chris Jarc, P.E., vice president and manager of project management, Hixson Architecture & Engineering.

"If you are renovating an older plant, you are now required to consider accessibility (ADA) issues like employee welfares, path of travel and toilet facilities," says Jarc. "Additionally, energy codes have become more restrictive, and building officials are requiring the new codes be followed: There is no "grandfathering"

anymore. A 4,000-sq.-ft. renovation may end up requiring an additional 10% to 20% in costs to retrofit all of the regulatory-required items."

## WAREHOUSES, DCs KEY TO TODAY'S ONLINE WORLD

Changing consumer preferences certainly have had an impact on Haskell's projects, says Perkey. In many cases the core production operation remains the same, but the packaging options and the warehouse and supply chain elements of the projects have changed to meet the current consumer demands. "Overall the volume of warehouses and fulfillment center activity has been strong and we certainly have seen increases in project opportunities in this arena," says Perkey.

"Customization and personalization are merging to give consumers very real ways to get

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>D</b>								
Darigold	Boise	ID	Dairy bottling line	New/Ren.	26	16	Epstein	3/21
Diageo	Lebanon	KY	Distillery	New	72	107	Gray	6/21
Domino's	West Columbia	SC	Pizza dough	New	67			20
DOT Foods	Bear	DE	Cold storage	New	189		ARCO National Construction	5/20
DuPont Tate & Lyle Bio Products	Loudon	TN	Warehouse/DC	New				6/19
<b>E</b>								
EarthFresh	College Park	GA	Produce	New	140	22		7/19
<b>F</b>								
fairlife, LLC	Goodyear	AZ	Milk beverages	New	300		Stellar	7/19
Farmer's Select	El Paso	TX	Dairy	New			EA Bonelli + Associates	20
Florida Carribean Distillers	Winter Haven	FL	Cans	New	300			3/21
Flow Alkaline Spring Water	Verona	VA	Bottled water	New		16		4/19
Foremost Farms	Greenville	MI	Dairy	New	58		E.A. Bonelli + Associates	21
Freshly	Savage	MD	Meal kits	New	171			9/19
Frito-Lay	Osceola Cty	FL	DC	New	286	130		21
Fuji Vegetable Oil Inc.	Avondale (New Orleans)	LA	Palm, sunflower, coconut oils & DC	New		70		6/20
<b>G</b>								
Gathered Foods	Heath	OH	Plant-based seafood	New	43			12/19

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products they want,” says Woodard & Curran’s Snyder. The rise of Amazon has created demand for fast, efficient delivery. Big box stores have also survived and thrived. Mega food processors like Kellogg and Campbell are trying to find their niche in the changing retail supply chains. To achieve this supply chain flexibility requires complex warehouse operations that are in need of automation and ERP integration, says Snyder.

E-commerce is playing a major role in the design and construction of distribution facilities, says Steve Tippmann, executive VP for the Tippmann Group. These facilities have larger footprints, and owners are trying to locate them more in urban sites, closer to where the population is, because deliveries now are expected in a day or less. “The demand for cold storage is very high,” adds Tippmann. “It’s hard for manufacturers to find storage space across the country, so now they’re starting to build new cold storage projects attached to

their manufacturing plant, while cold storage providers are expanding more frequently.”

“We have worked with many clients who sell directly to the consumer. This is definitely fueled by companies like Amazon who have the capability to take on the distribution of products if suppliers can get a substantial amount of product to their facility,” says Jennifer Redmond, marketing director of Food Plant Engineering. “This system affects warehouse needs because suppliers are increasing the frequency of shipments rather than requiring longer-term storage.”

### WASTEWATER TREATMENT AS IMPORTANT AS THE FOOD PROCESS

Do you call the addition of a wastewater pretreatment or treatment facility to a processor’s campus new construction or an expansion? If one doesn’t already exist, adding one is certainly new, and while more money can be spent for an on-site wastewater pretreatment center

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>G</b>								
Gem State Dairy Products	Twin Falls	ID	Aseptic milk	New				3/19
GenCanna	Mayfield	KY	CBD ingredients for food	New	100	40		3/19
General Mills/Blue Buffalo	McDonough	GA	Pet food distribution	New		9		2/19
General Mills/Blue Buffalo	Richmond	IN	Pet food	New	400	200		8/19
Glanbia	St. Johns	MI	Diary/cheese	New	375	555		8/19
Golfo di Napoli Dairy	Warren	IN	Organic cheese	New	3	10		2/19
Good Catch Foods	Columbus	OH	Prepared foods	New	40		Food Plant Engineering, LLC	20
Gordon Food Services	Westfield	IN	DC	New	500			20
Great Lakes Cheese	Wausau	WI	Cheese	New	180	62	Dennis Group	5/19
Green Life Farms	Boynton Beach	FL	Leafy greens	New				5/19
Greenleaf Foods	Shelbyville	IN	Plant-based burgers	New	230	310		20
<b>H</b>								
Haribo	Pleasant Praire	WI	Candy	New	164		Epstein	19
Heineken	Meoqui	MX	Beer	New				12/19
Hormel Foods	Omaha	NE	Sausage products	New		140		11/19
Horse Soldier Bourbon	Somerset	KY	Bourbon	New		26		19
Hunt Advantage Group	Paris	KY	Cold storage	New	55		ARCO National Construction	9/19

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than a food processing line expansion, it certainly qualifies for a table entry on our yearly construction survey. In fact, Matt Williamson, director of engineering at ADF Engineering, says that on-site wastewater treatment continues to be a strong driver of capital spending.

“The majority of our greenfield projects have been faced with difficult site challenges, including wetlands, poor soils and lack of existing utility infrastructure,” says A M King’s Dan Crist, VP of operations. “Many food processing facilities are being designed and constructed with on-site wastewater treatment due to inadequate offsite utility infrastructure and/or local AHJ (authority having jurisdiction) requirements.”

And when a municipality has an existing wastewater requirement specification, it’s not uncommon for the municipality to set higher standards when it realizes that it can’t any longer handle the wastewater it’s getting. Alberici’s Oberlies is seeing an increase of waste-

water projects as municipalities place new demands on wastewater that existing pretreatment facilities can’t meet without upgrades.

For a processor with a lot of wastewater, Black & Veatch’s Ziskind says the use of digestion technologies provides a triple win. A manufacturer can hit the trifecta of reduced wastewater costs, water reclamation and energy generation. What’s not to like about that? Smithfield Foods has been doing this for some time.

### TO BE CONTINUED

While we’ve looked at the key issues—including COVID-19—facing food processors and A&E/Cs this year, there’s a lot more to cover. Be sure to watch for a follow-up story online where we will cover other design criteria and issues including FSMA, site-related issues beyond wastewater (such as weather and flood plains), trends in automation, and supply chains. 🌟

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>I</b>								
In-N-Out	Colorado Springs	CO	Distribution center	New	100	47	Haskell	12/20
InterChange Cold Storage	Mt. Crawford	VA	Cold storage	New	118		ARCO National Construction	6/19
International Farmaceutical Extracts	Danville	KY	CBD extracts, ingredients	New		6		19
International Farmaceutical Extracts	Danville	KY	CBD extraction	New		6		10/19
Interstate Warehousing	Anderson	IN	Cold storage	New	250	40	Tippmann Group	3/19
<b>J</b>								
J.M. Smucker Co.	Longmont	CO	Frozen sandwiches	New	432	215	Dennis Group	6/19
JBS USA	Ottumwa	IA	Pork	New	12	12	Epstein	2/21
Jet.com	Bronx	NY	Cold storage	New	185	20	CMC Design-Build Inc.	2/19
Jetton Biochemistry	Nampa	ID	Dairy powders	New				8/19
<b>K</b>								
KanPack	Arkansas City	KS	DC for fast food chains	New	203			4/19
KEG 1	Temple	TX	Beer DC	New	108	11		12/19
Kentucky BioScience International	Bowling Green	KY	CBD ingredients	New		23		19
Keurig Dr. Pepper	Allentown	PA	Beverage	New	811	220	Dennis Group	9/20
Keurig Dr. Pepper	Moore	SC	Coffee	New	708		Gray	8/21

Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>K</b>								
Kingfish Zeeland	Jonesport	ME	Fish aquaculture	New		110		11/19
Kroger	Dallas	TX	Fulfillment center/DC	New	350			22
Kroger	Florence	KY	Fulfillment center/DC	New	674	17		1/19
Kroger	Forest Park	GA	DC/fulfillment center	New		121		10/19
Kroger	Groveland	FL	Warehouse/fulfillment	New				6/19
Kroger	Monroe	OH	DC/fulfillment center	New	335	55		8/19
<b>L</b>								
Lionchase Holdings	Texarkana	TX	Cold storage DC	New	200	20		12/19
Little Leaf Farms	Burnsville	NC	Fresh lettuce grow/production	New		86		12/19
Log Still Distilling	New Haven	KY	Bourbon, rye whiskey	New		12		8/19
Lotus Bakeries	Mebane	NC	Baked goods	New	130		Dennis Group	7/19
<b>M</b>								
Magnolia Botanicals	Ridgeville	CS	Hemp, CBD	New		3.2		12/19
Malt Products Corp.	Dayton	OH	Malted barley extract (dryer)	New		15		6/19
Maple Leaf Foods	London	ON	Fresh poultry	New	640		Hixson/Gray CM	6/21
Maple Leaf Foods	London	ON	Poultry	New			Hixson Architecture & Engineering	21
Maple Leaf Foods	Shelbyville	IN	Plant-based Products	New	230	310	Hixson Architecture & Engineering	23
Mark Anthony Brewing	Memphis	TN	Specialty beverages	New		12		3/19
Martin Preferred Foods	Dallas	TX	Meat/poultry/seafood	New			Food Plant Engineering LLC	20
McCain Foods	Burley	ID	DC	New		200		8/19
McCain Foods	Caldwell	ID	Potato processing	New	100			2/19
MegaFit Meals	Benton	KY	Meals	New	16	3		11/19
Michael Foods	Norwalk	IA	Eggs	New	150		Gleeson Constructors & Eng. LLC	10/19
MolsonCoors	Montréal	ON	Beer	New			Alberici, Pomerleau	12/20
Monin Americas	Sparks	NV	Flavorings, extracts	New	115	27	Gray	5/20
Montana Specialties Mills LLC	Great Falls	MT	Non-GMO, organic oilseeds	New		20		19
Mycotechnology Inc.	Aurora	CO	Plant-based protein	New	60		CRB	19
<b>N</b>								
National Property Holdings/Domino's	Katy	TX	Dough, fresh ingredients	New	60		ARCO National Construction	11/20
NC Food Innovation Lab	Kannapolis	NC	Plant-based foods	New	14	7	CRB	19
Nestlé Purina	Hartwell	GA	Pet food	New			Alberici	12/20
NewCold	Burley	ID	Cold storage for McCain Foods	New	180	90		19
Newly Weds Foods	Chicago	IL	Bakery	New	40	10	Epstein	12/20
Niagara Bottling	Jeffersonville	IN	Water	New	469	56		19
Niagara Bottling	Kansas City	MO	Water bottling	New	420	68		9/19
Niagara Bottling	Temple	TX	Bottled water	New	450	90		4/19
NomNomNow	Nashville	TN	Fresh pet food	New		2		1/19
Nongshim	Corona	CA	Noodles	New		200		21
Nordic Aquafarms	Eureka	CA	Fish	New		400		5/19

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Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>O</b>								
OFD Foods	Henrietta	NY	Freeze-drying contract service	New	50	25		19
Old Trapper Smoked Products	Forest Grove	OR	Jerky	New	80			6/19
<b>P</b>								
Peer Foods	Edinburgh	IN	Cold storage	New	62	14	Tippmann Group	5/20
Performance Food Group	Gilroy	CA	Cold storage	New	190		ARCO National Construction	5/19
Performance Food Group/Vistar	Mt. Olive	NJ	Cold storage	New	215		ARCO National Construction	8/19
Performance Pet	Mitchell	SD	Pet food	New	150			12/19
Petsource by Scoular	Seward	NE	Pet foods	New	105	57	Gray	9/20
PHM Brands	Michigan City	IN	Hemp products/CBD	New		6		6/19
Plumrose USA	Moberly	MO	Pork	New	125	39	The Austin Company	3/21
Poultry Products Northeast	Londonderry	NH	Cold storage	New	110	20	CMC Design-Build Inc.	2/20
Prairie View A&M U Meat Processing Lab	Prairie View	TX	Meat processing	New	8	8	CRB	20
Preferred Freezer Services	Portsmouth	VA	Refrigerated warehouse	New	200	60		5/19
Prestage Foods of Iowa	Eagle Grove	IA	Pork	New	625		Epstein	3/19
Proliant	St Johns	MI	Dairy	New	71		E.A. Bonelli + Associates	21
<b>Q</b>								
Quality Sausage QOZ	Dallas	TX	Toppings	New	111		Gleeson Constructors & Eng. LLC	4/21
QuikTrip	Belton	MO	Bakery	New		12	Haskell	19
QuikTrip	Midlothian	TX	Bakery	New		2	Haskell	5/19
<b>R</b>								
Rabbit Hole Spirits	Campbellsburg	KY	Bourbon, other spirits	New		50		19
Ramar Foods	Kapolei	HI	Filipino foods	New				12/19
Readington Farms	Easton	PA	Dairy	New	350	250		4/19
Ready Seafood	Saco	ME	Seafood	New	50	15	CMC Design-Build Inc.	10/19
Resonate Foods	Lyon	KY	Food-grade hemp	New		2		11/19
RiceWrap Foods	Butner	NC	Rice sheets for sushi	New		10		5/19
Rosina Food Products	West Seneca	NY	Meat products	New		58		10/19
Royal Canin/subsidiary Mars Petcare	North Sioux City	SD	Pet food	New		100		4/19
<b>S</b>								
Saratoga Food Specialties	Bolingbrook	IL	Dry mix (wastewater)	New	2	3	Epstein	3/19
Scannell Properties/Northeast Coca-Cola	S. Windsor	CT	Beverage distribution	New	200		ARCO National Construction	6/19
Sedes Soy Crush	Caruthersville	MO	Soy proteins/oils	New				19
Simmons Foods	Siloam Springs	AR	Chicken	New		300		8/19
Simmons Prepared Foods	Decatur	AR	Chicken processing	New		300		19
Smithfield Foods	Principio	MD	DC	New	420			7/19
Smithfield Foods	Tar Heel	NC	Distribution center	New	500	100		2/19
Smith's Food & Drug Stores	Henderson	NV	Dry-goods DC	New		14		19
Southeastern Mills	Rome	GA	DC	New	140	6		12/19



Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
<b>S</b>								
Southern Visions	Bay Minette	AL	Tea and sugar	New	125	24		2/19
SpartanNash	Fargo	ND	Produce DC	New		10		12/19
SSI Foods	Amarillo	TX	Protein	New	75	42		10/19
Strauss Brands	Franklin	WI	Specialty meats	New				8/19
Stuffed Puffs	Bethlehem	PA	Stuffed Puffs marshmallows	New	150			12/19
Sunrise Soya	Delta	BC	Tofu	New	85			12/19
<b>T</b>								
Table Talk Pies	Worcester	MA	Cold storage	New	34		Tippmann Innovation	5/19
Tasty Brands	Owensboro	KY	Prepared foods	New	25		Food Plant Engineering LLC	20
Taylor Farms	Ciudad Morelos	MX	Fresh cut produce	New	290	65	Dennis Group	1/19
The Bel Group	Sorel-Tracy	QC	Mini Babybel cheese	New		66		20
The Muffin Mam	Watts Mills	SC	Baked goods	New	100	19		7/19
Torani	San Leandro	CA	Flavors, syrups	New		12	Haskell	3/20
Trisco Foods	Colorado Springs	CO	Specialty foods	New	40			2/19
Tuffy's Pet Foods	Delano	MN	Pet treats	New	173		CRB	20
Two Rivers Fishery	Ballard Cty	KY	Fish (12-company partnership)	New				5/19
Tyson Foods	Eagle Mountain City	UT	Case-ready beef/pork	New		300		10/19

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Company	City	State	Primary Product	Type	Sq. ft. (x1000)	Cost (\$ Mil.)	A&E/C	Completion Date
Tyson Foods	Humboldt	TN	Fresh poultry	New	393		Gray	11/19
Tyson Foods	Joslin	IL	Beef	New	86		Gleeson Constructors & Eng. LLC	4/21
Tyson Foods	Tonganocie	KS	Poultry production	New		320		6/19
<b>U</b>								
United Dairy Farmers	Cincinnati	OH	Donuts	New			Hixson Architecture & Engineering	19
<b>V</b>								
Victor Hoppenstein's Brewlab	Charleston	SC	Beer	New		1		9/19
VPX (aka Bang Energy)	Pembroke Pines	FL	Energy drinks warehouse/DC (Ph. 1)	New		35		2/19
VPX (aka Bang Energy)	Pembroke Pines	FL	Energy drinks warehouse/DC (Ph. 2)	New		40		1/20
VPX (aka Bang Energy)	Phoenix	AZ	Energy drinks and DC	New	397	200		10/19
<b>W</b>								
WholeStone Farms	Fremont	NE	Pork	New	10	13	Epstein	5/22
WholeStone Farms	Fremont	NE	Pork	New/Ren.	36	7	Epstein	2/20
WholeStone Farms	Fremont	NE	Pork (wastewater)	New	14	22	Epstein	5/22
WholeStone Farms	Fremont	NE	Pork	New	10	10	Epstein	11/19
Wildbrine Plant-based Creamery	Santa Rosa	CA	Plant-based products	New	20	4		5/19
<b>Z</b>								
Zucremex	San Diego	CA	Liquid sugar processing	New		16	Haskell	8/20



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