



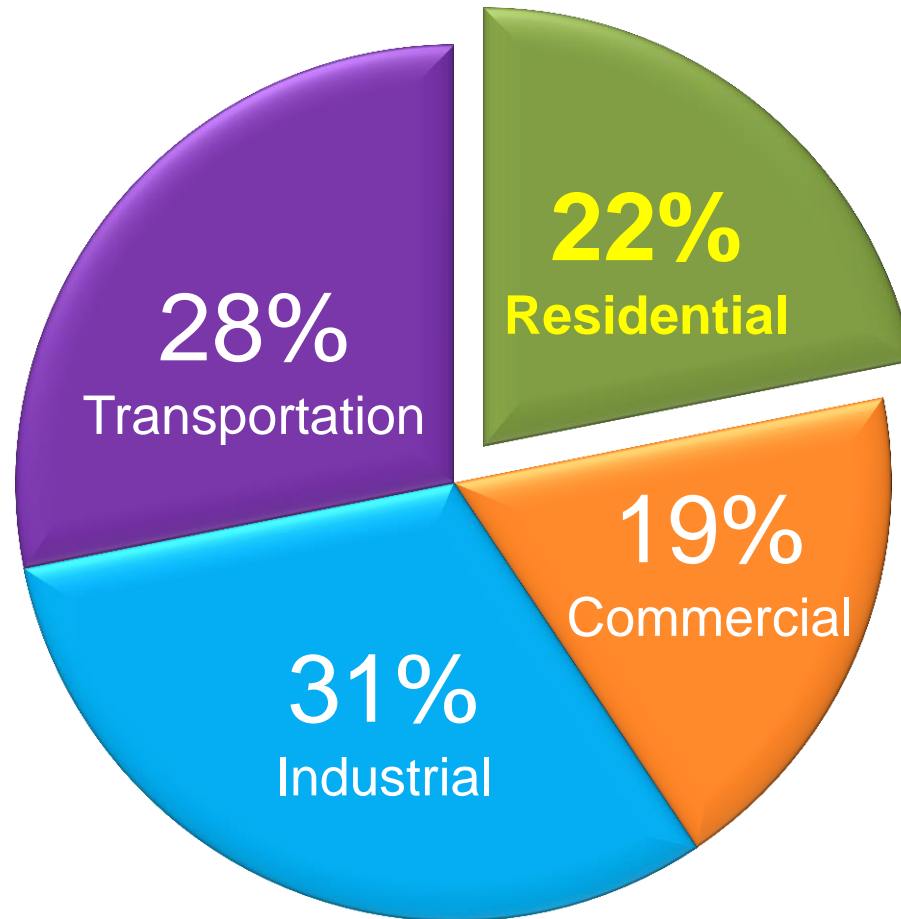
## Building America Top Innovations

**SAM RASHKIN &  
ERIC WERLING**  
Building Technology Office

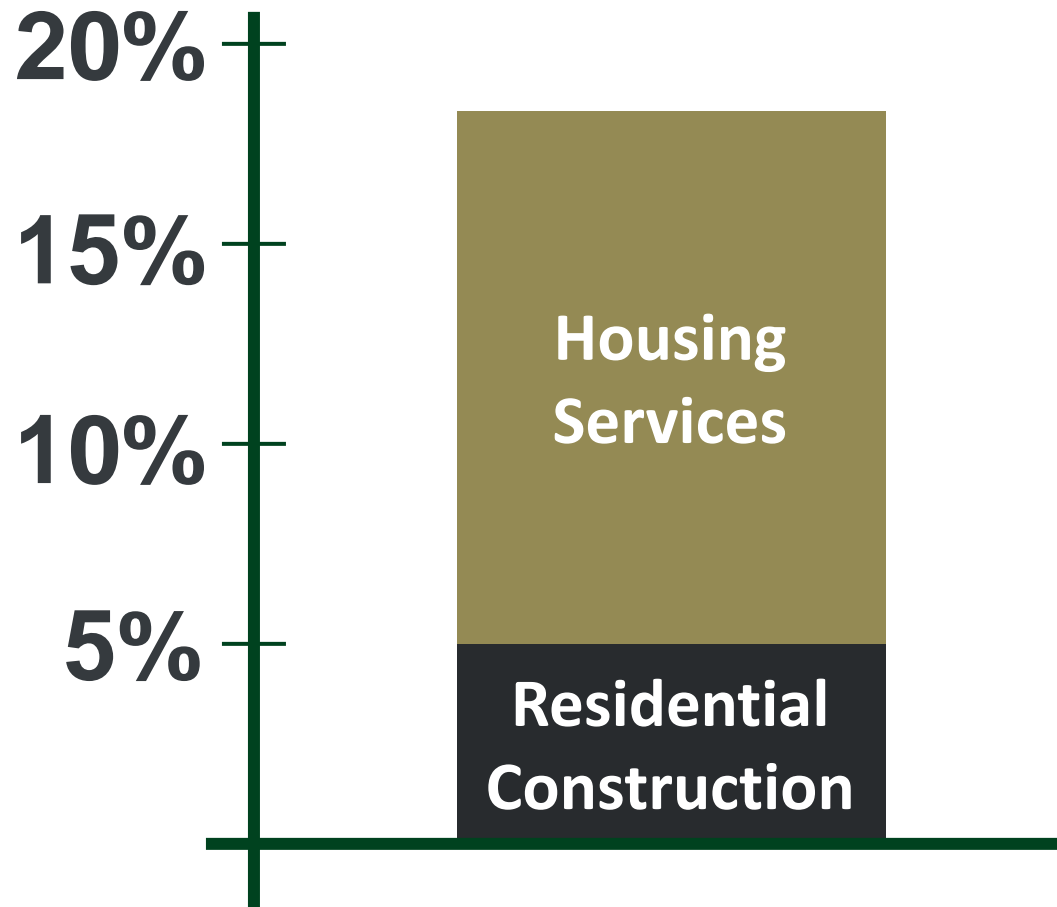
# **Business Case**

## **Why Building America**

# Building America Business Case Residential Energy Use Significant



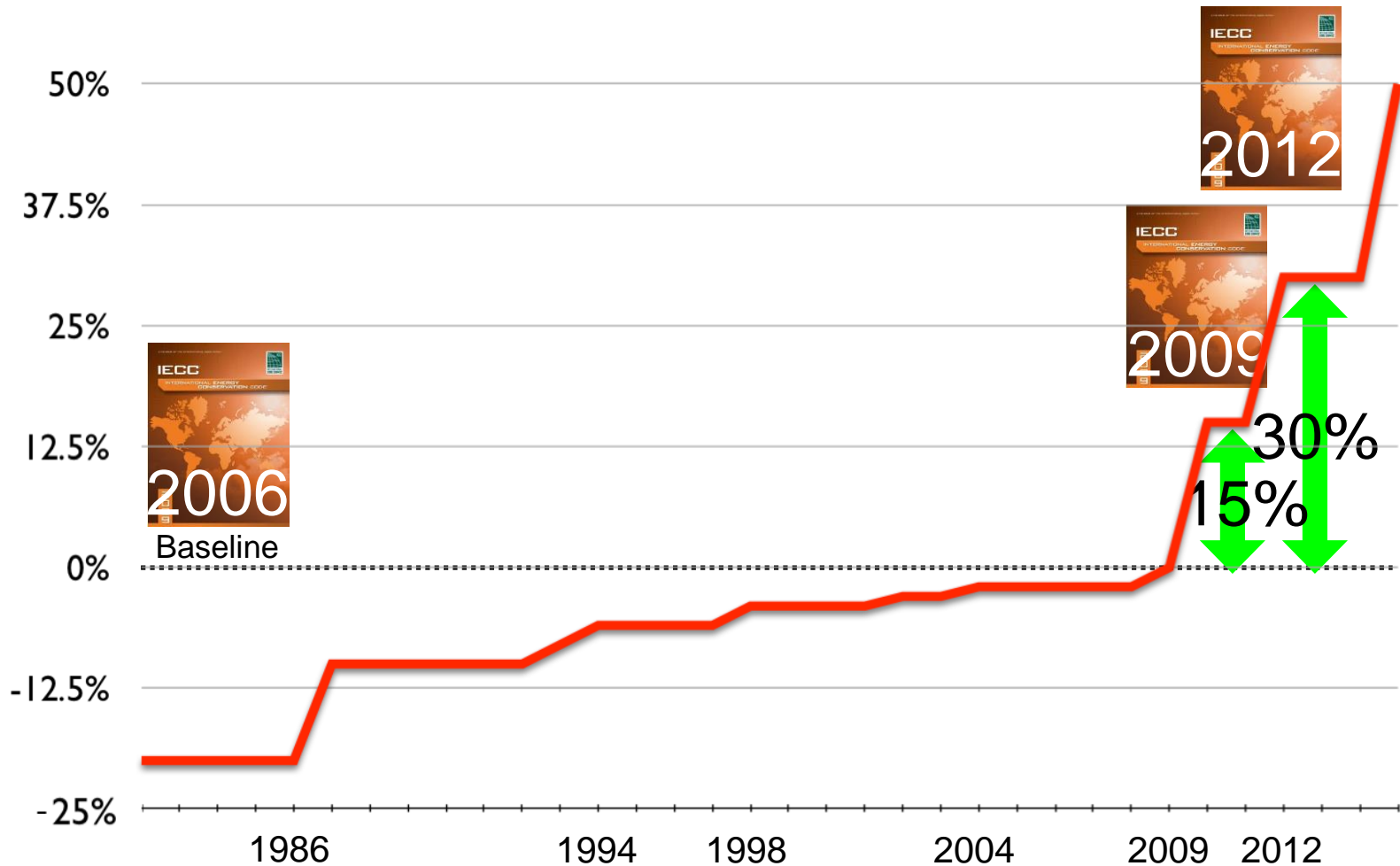
## U.S. Energy Consumption



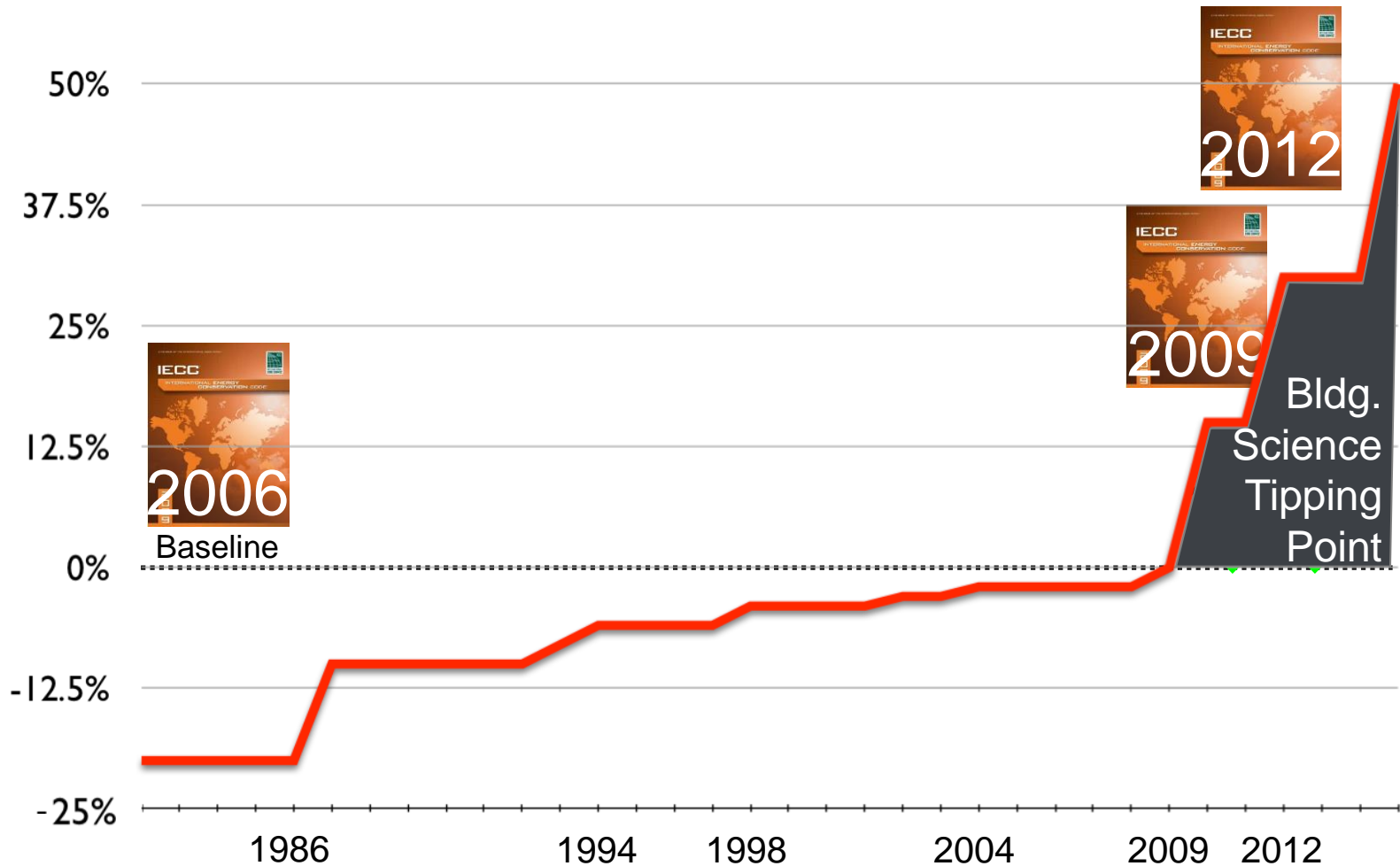
## Housing Sector Percent of GNP

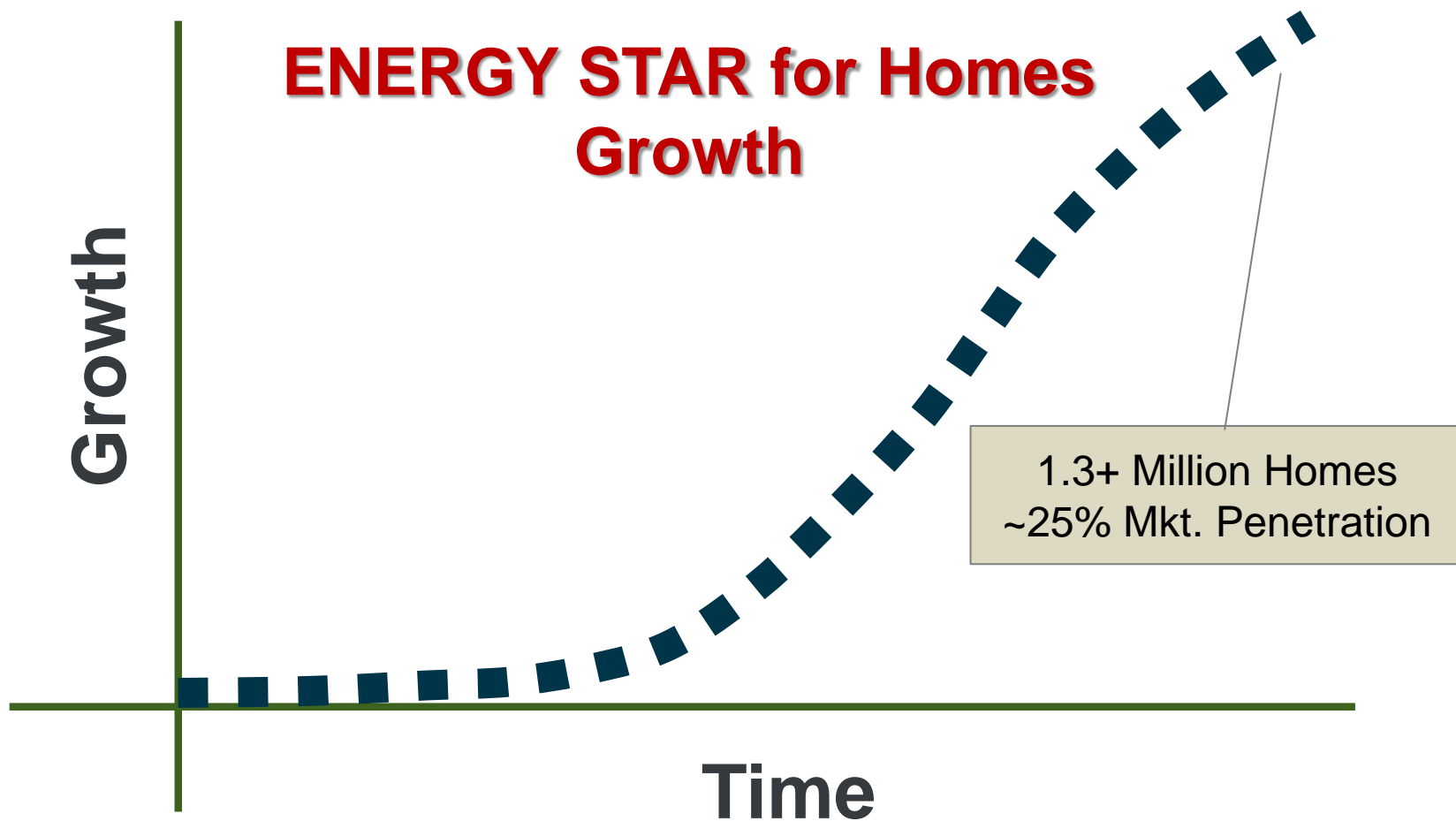
Source: NAHB data through Q1 2012

# Building America Business Case Building Science Imperative



# Building America Business Case Building Science Imperative

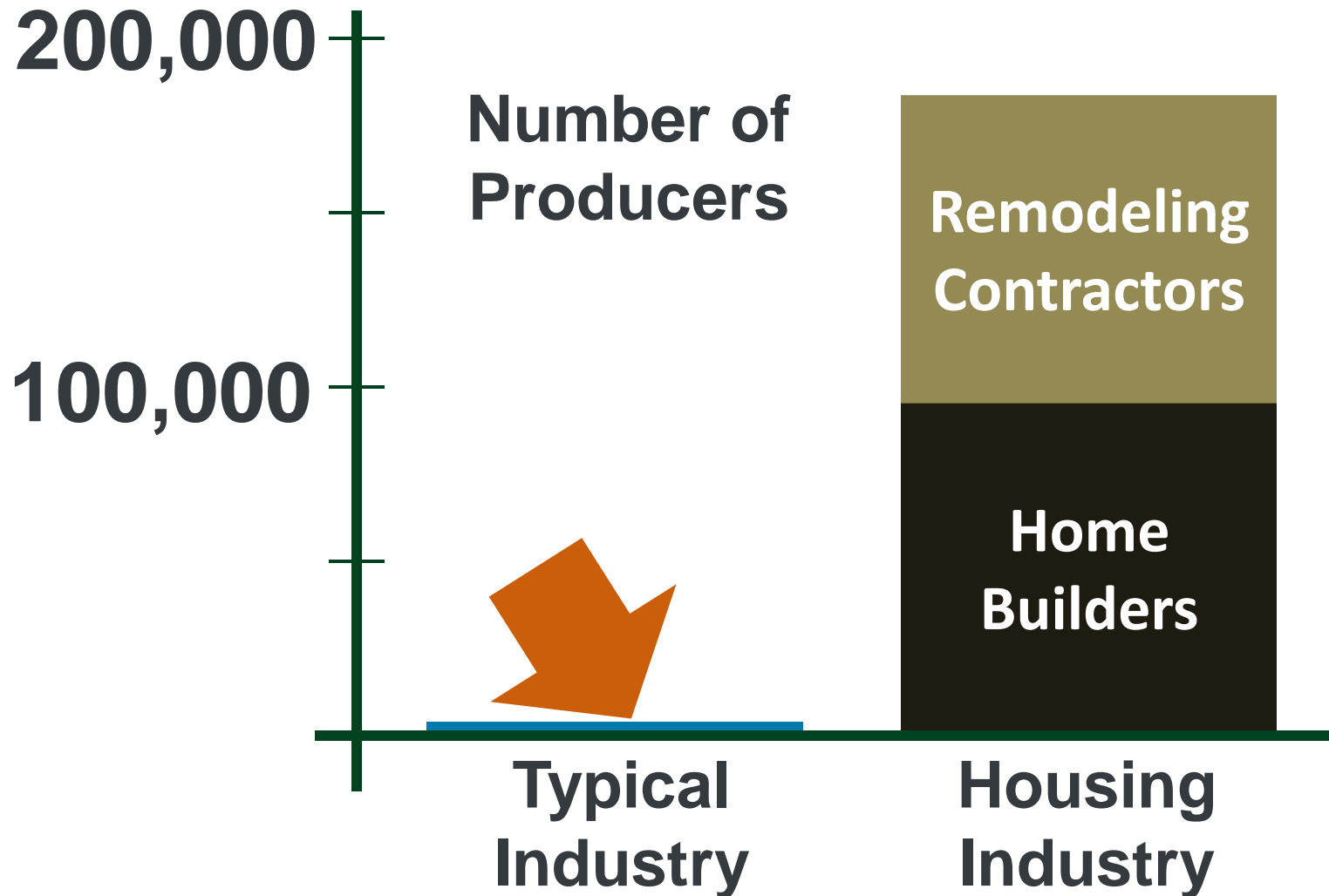




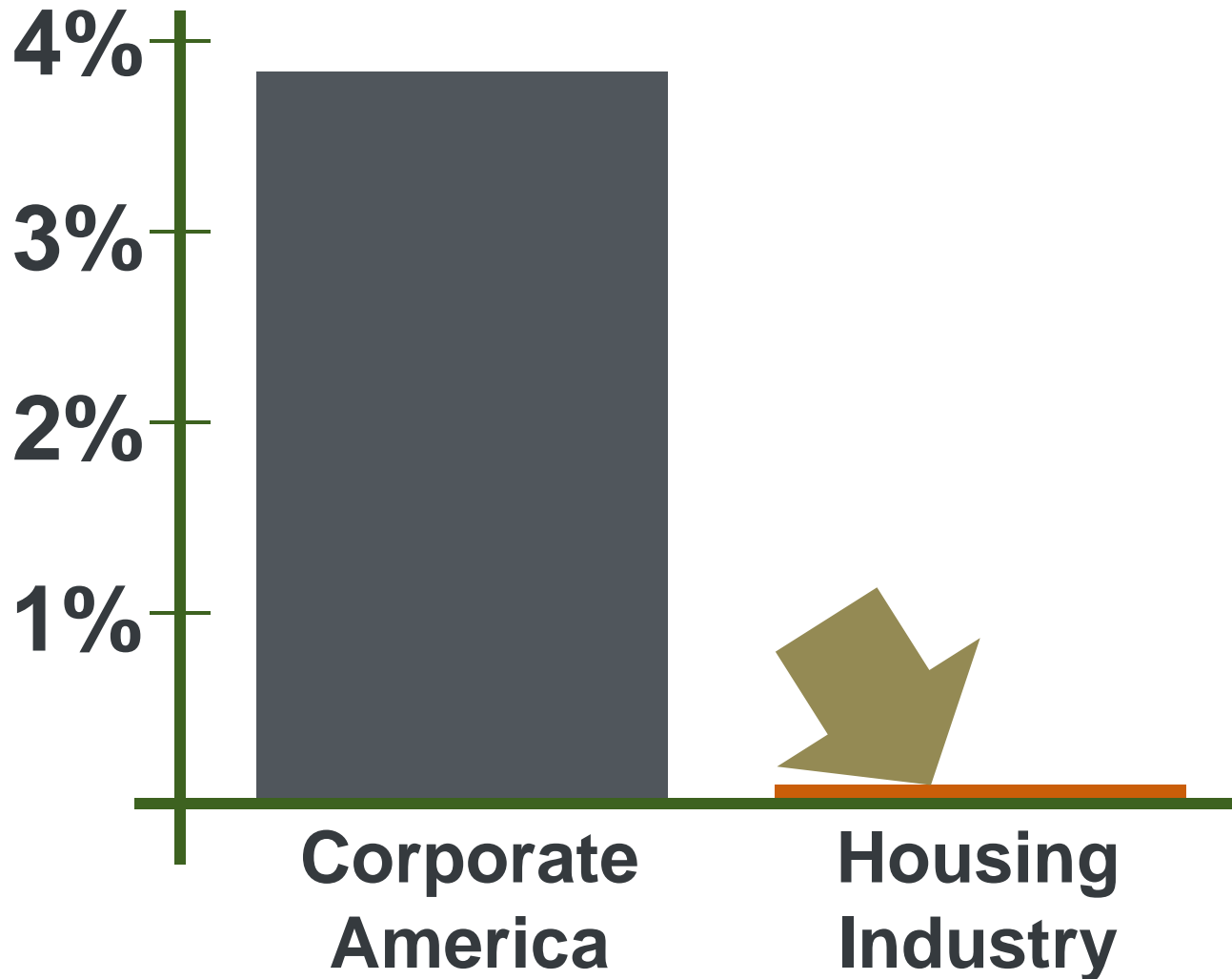
- Jobs
- Clean Air
- Energy Independence
- Stronger Communities
- Healthier Households



# Building America Business Case Disaggregated Housing Industry

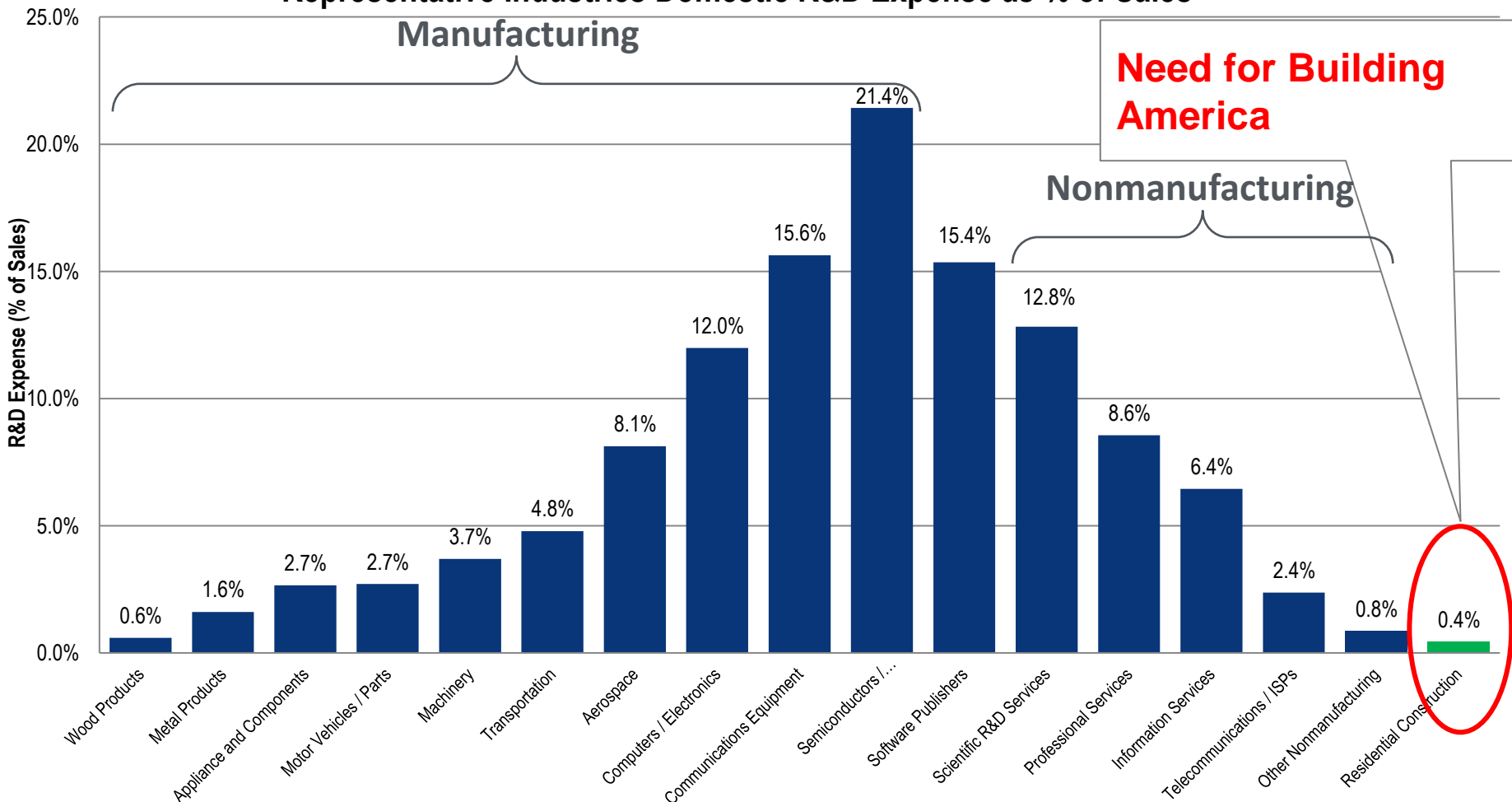


## R&D Investment as a % of Revenue



# Building America Business Case Industry Underinvests in R&D

## Representative Industries Domestic R&D Expense as % of Sales



Source: National Science Foundation/Division of Science Resources Statistics, Business R&D and Innovation Survey: 2008

Building America Fills Market Need for a  
High-Performance Home  
**HUB of Innovation**



# **Business Goals**

## **Building America Strategy**

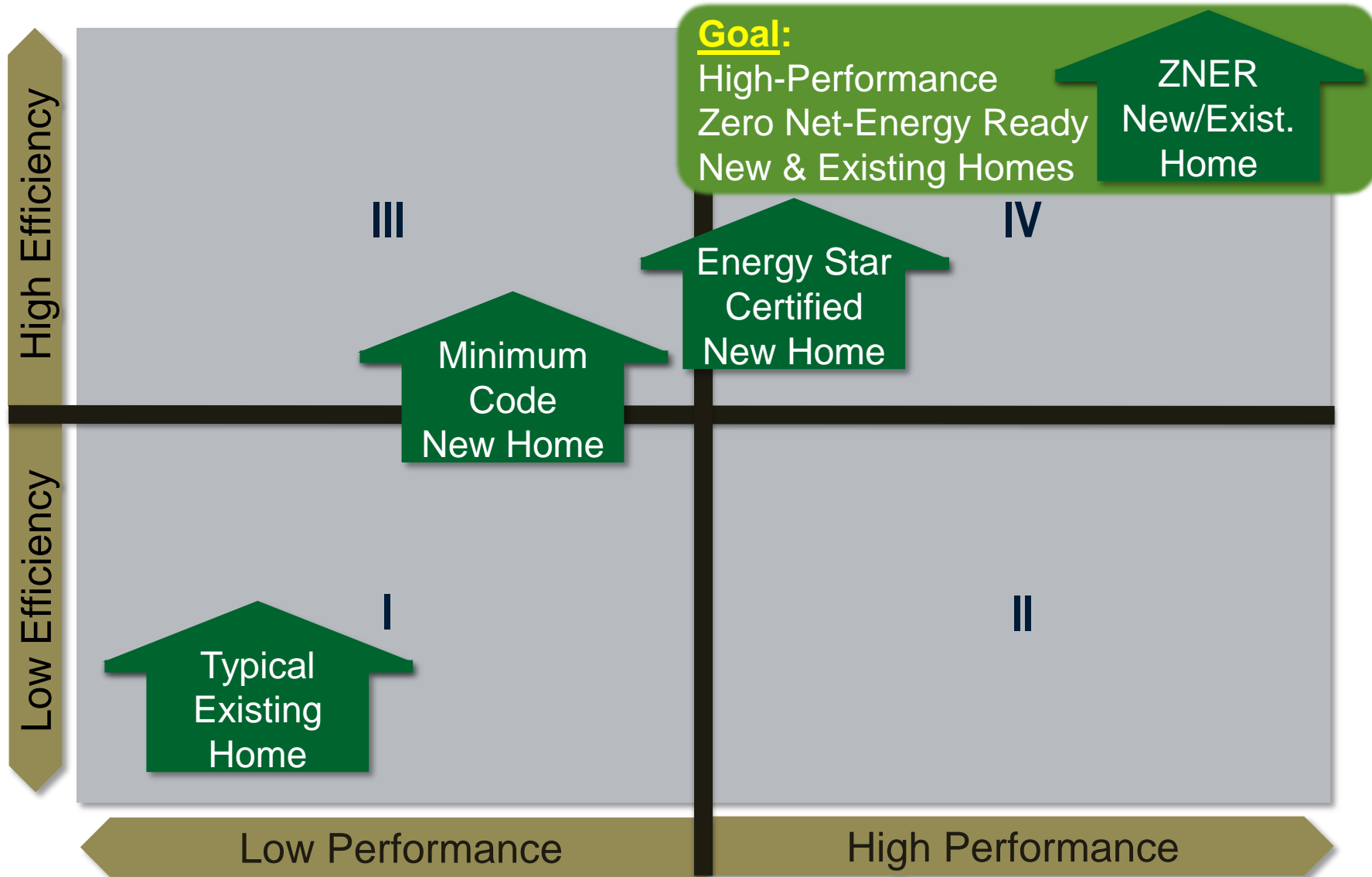
## 1. Efficiency

- Enclosure
- Low-Load HVAC
- Components

## 2. Performance

- Comfort
- Health
- Durability
- Renewable Readiness/Integration
- Water Conservation
- Disaster Resistance

# Building America Goal

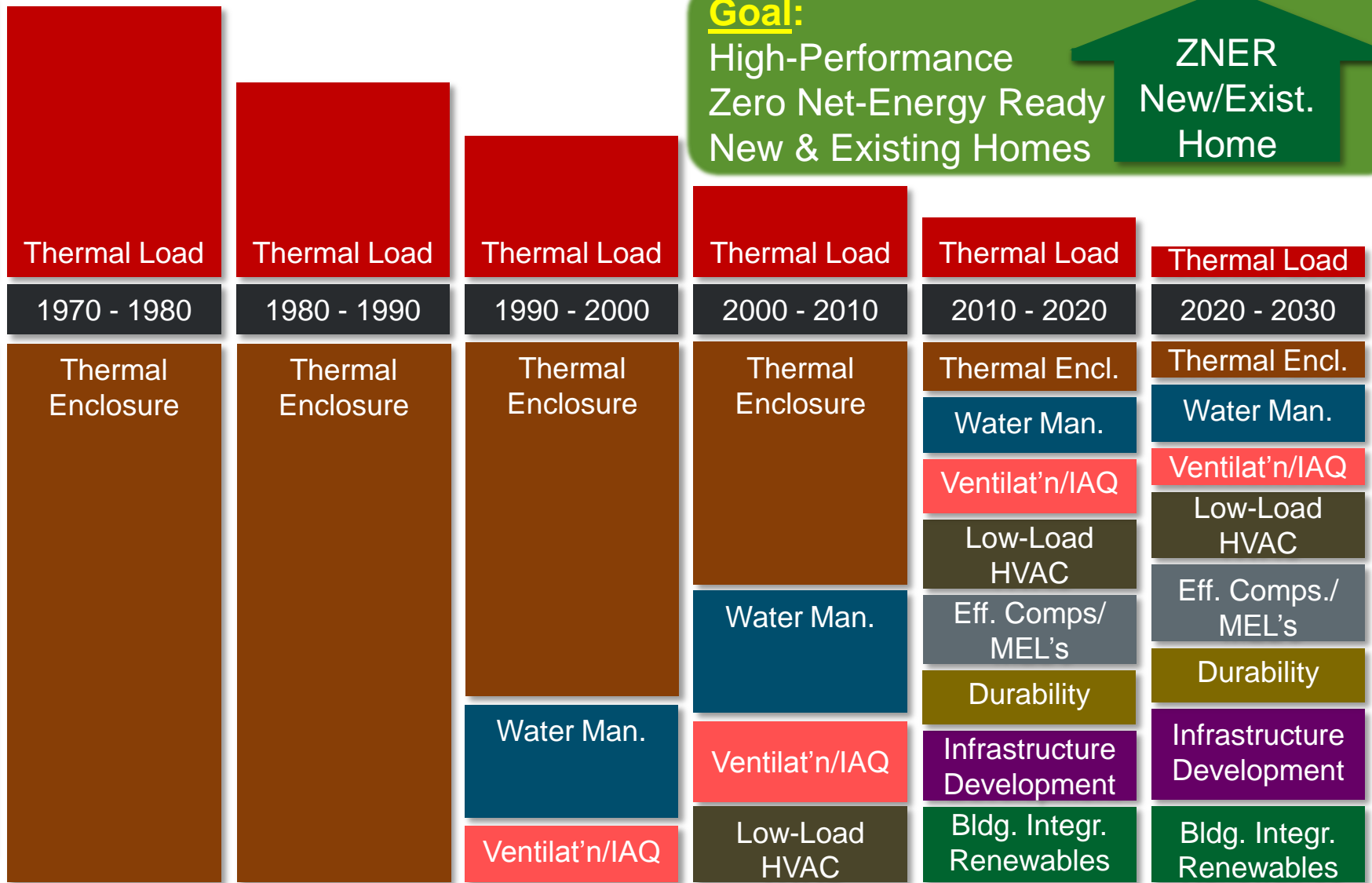


# Building America Path

Thermal Load

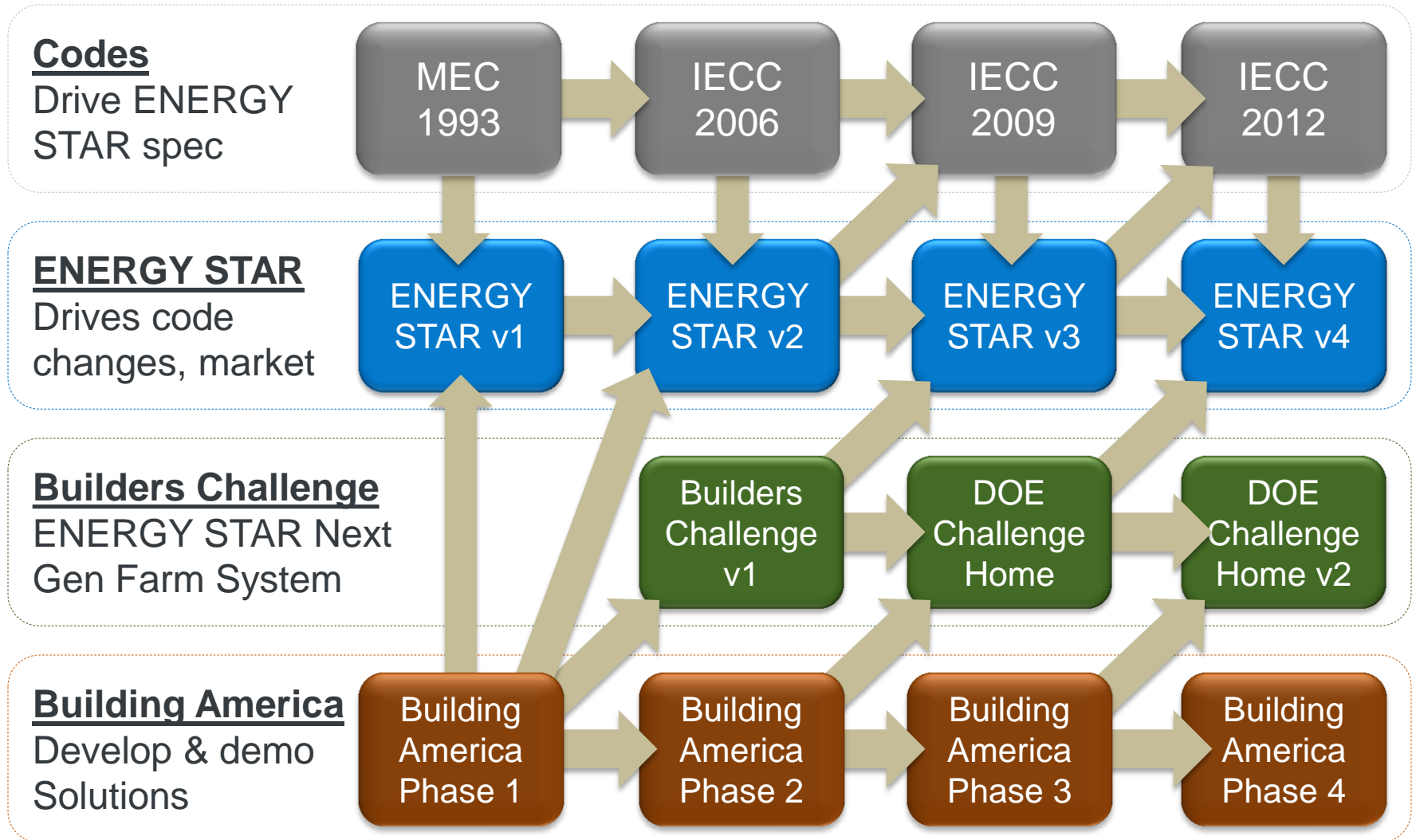
Resulting Research Priorities

**Goal:**  
High-Performance  
Zero Net-Energy Ready  
New & Existing Homes



# Building America Process



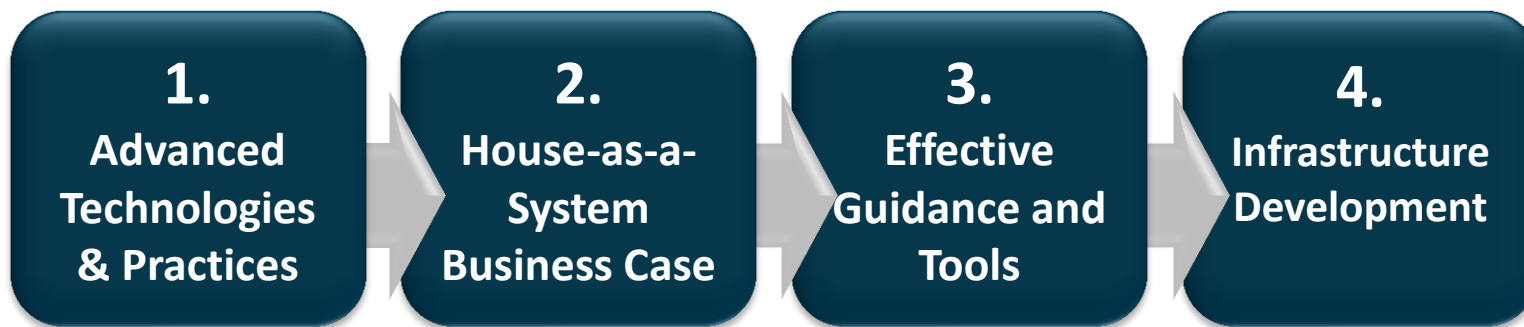
# Progress Top Innovations

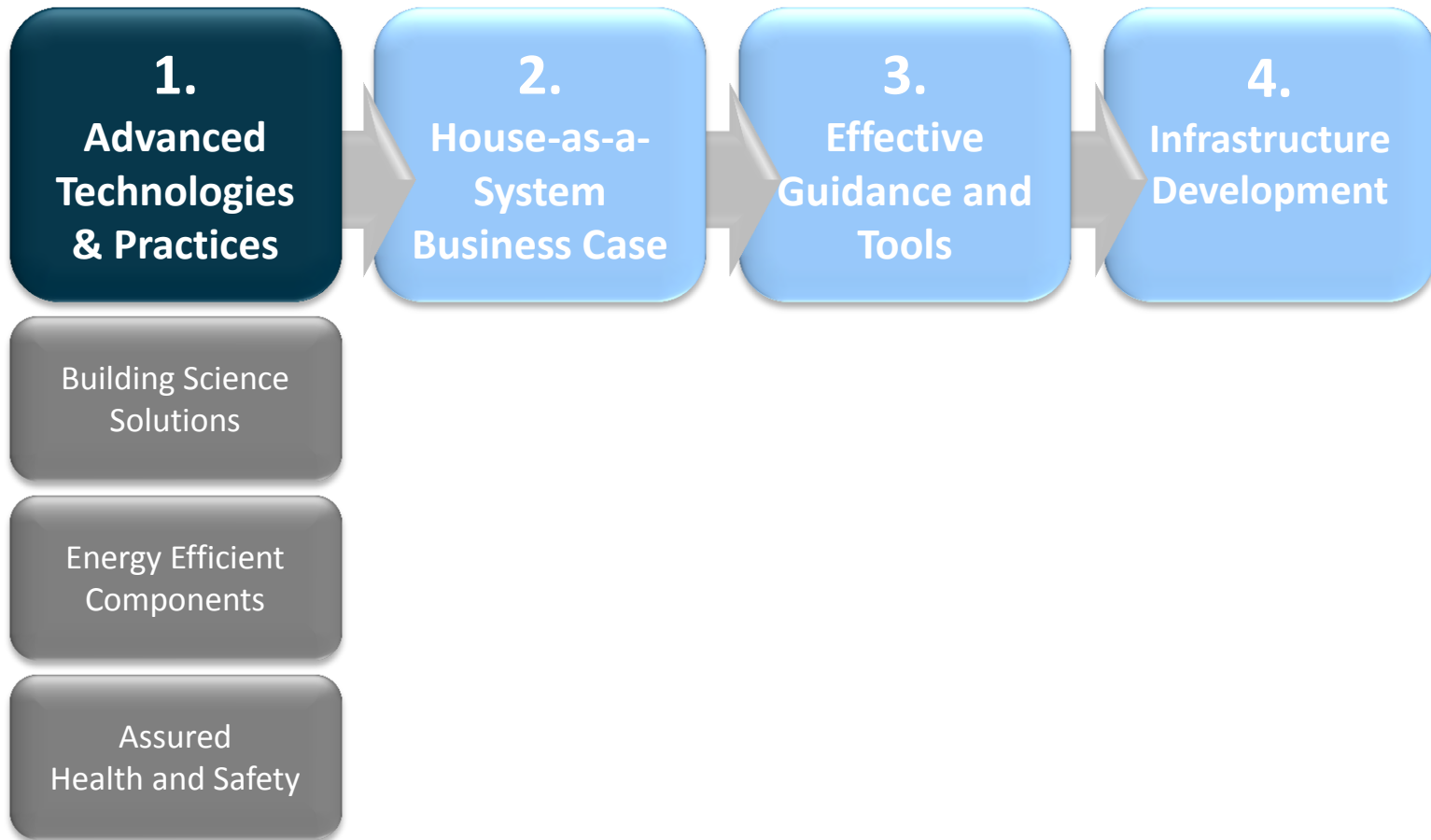
- Determine Criteria

- Determine Criteria

- Building America played a primary role
- Significant real or potential impact:
  - solving critical problem
  - capturing significant opportunity

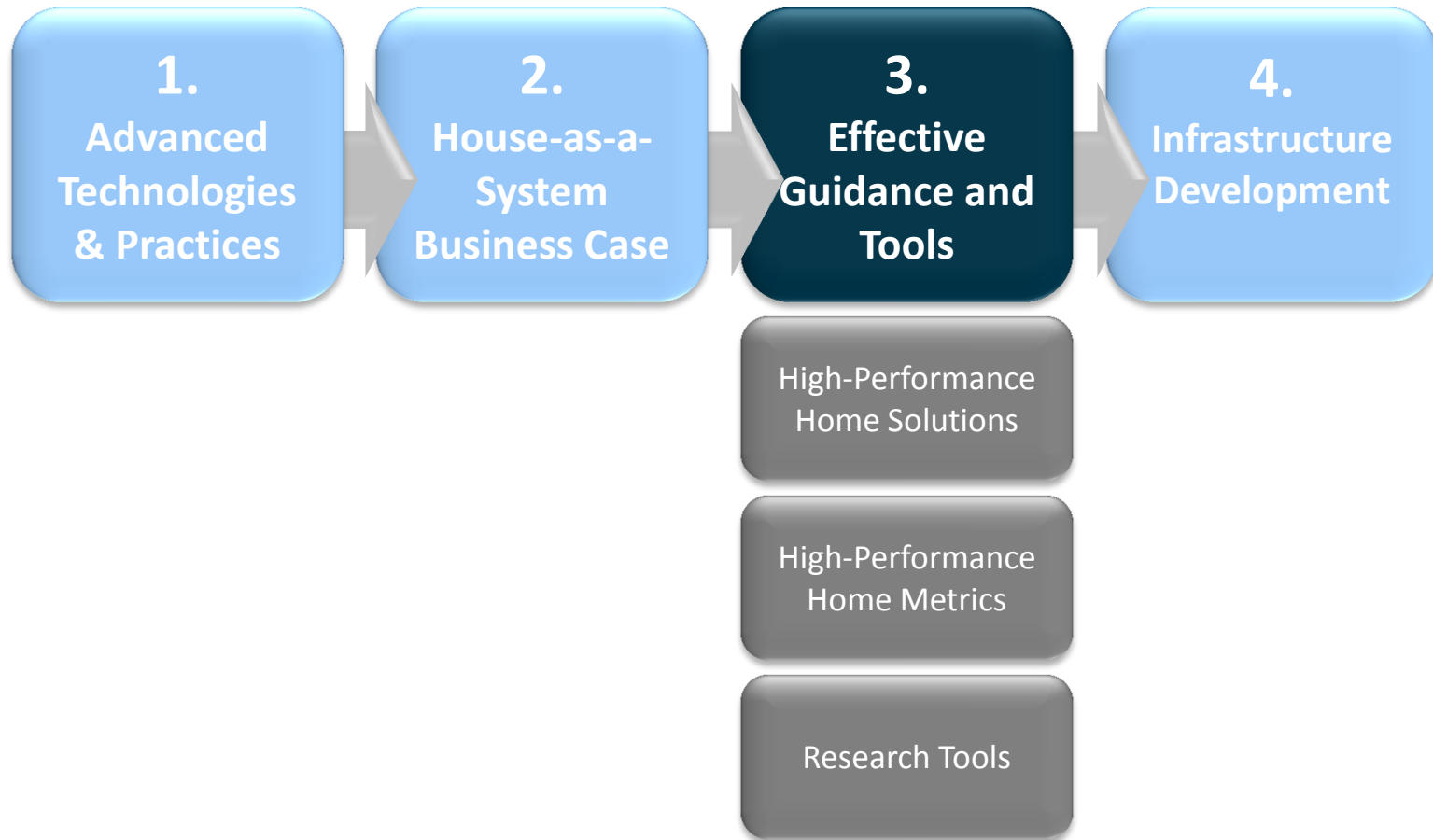
- Determine Criteria
- Solicit Nominations
- Research Past Documents
- Compile Complete List of BA Innovations
- Identify Story (Innovations Categories)

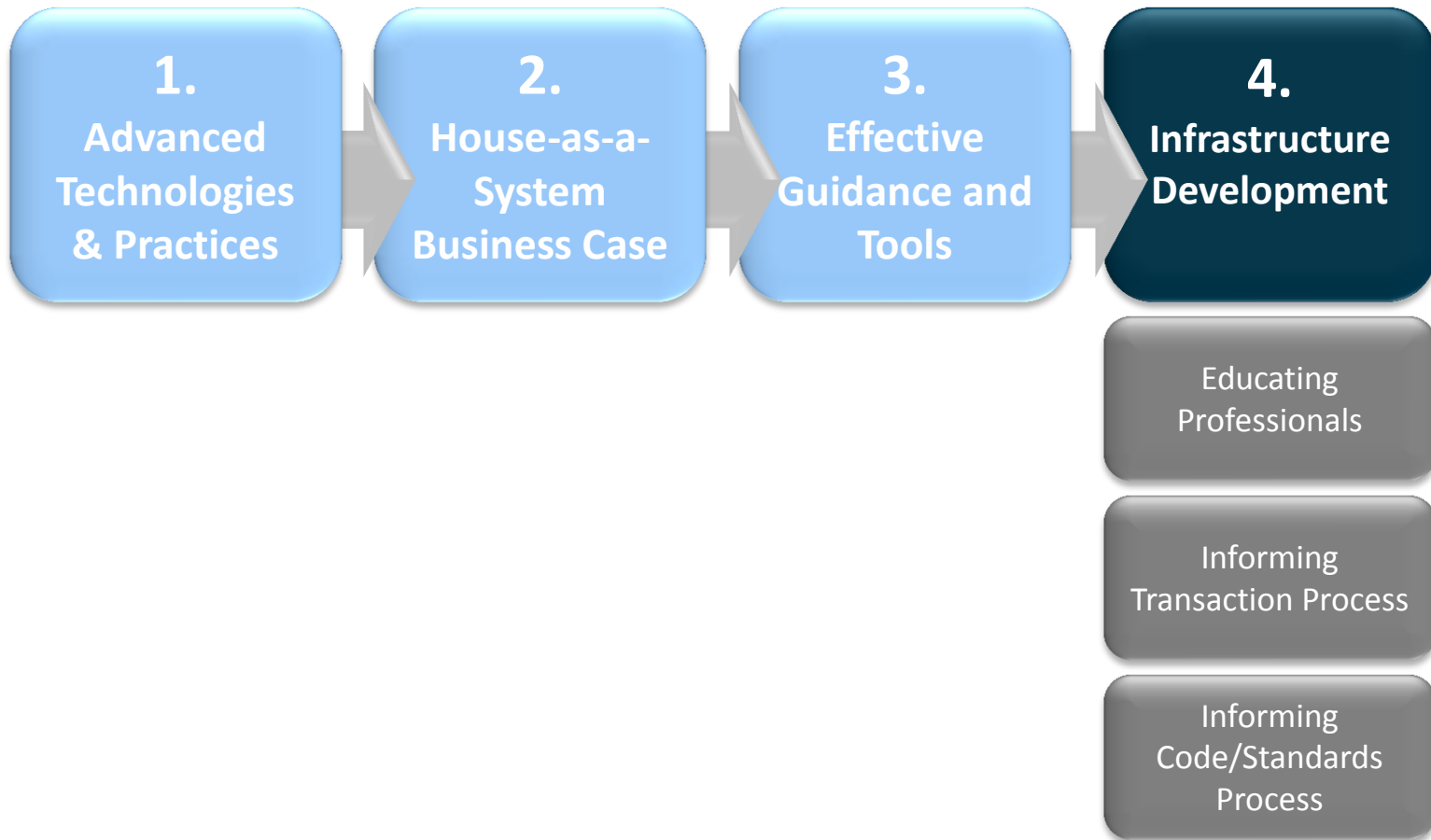










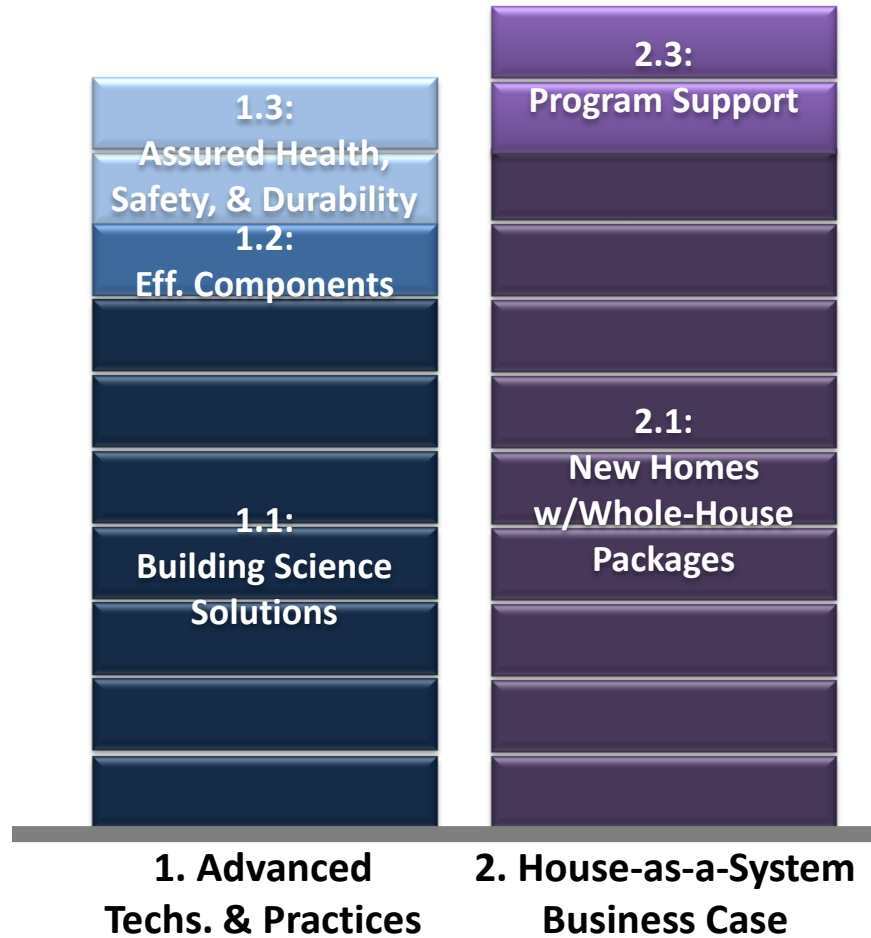




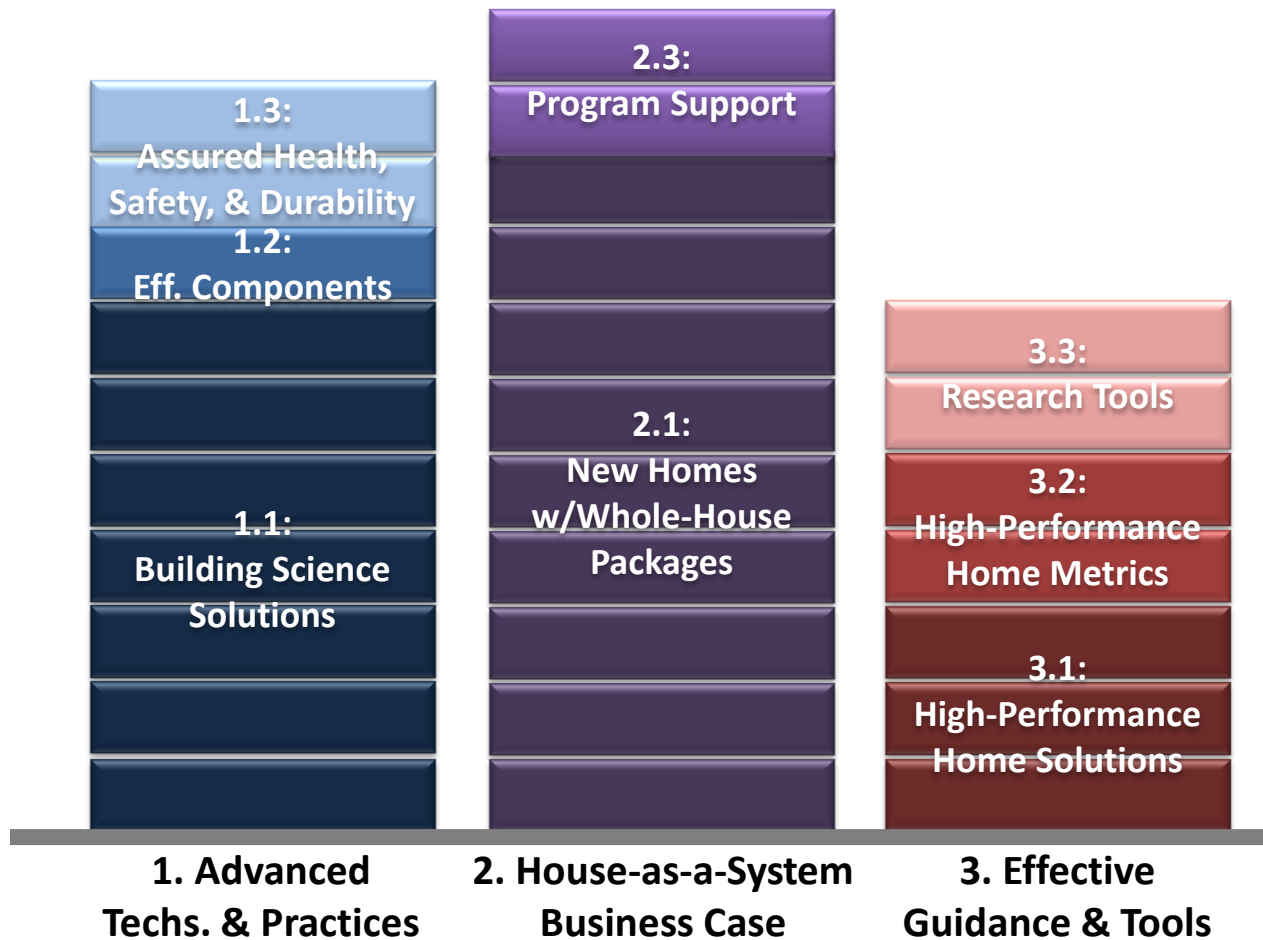
- Determine Criteria
- Solicit Nominations
- Research Past Documents
- Compile Complete List of BA Innovations
- Identify Story (Innovations Categories)
- **Sort Nominations**
- **Select Top Innovations per Criteria**



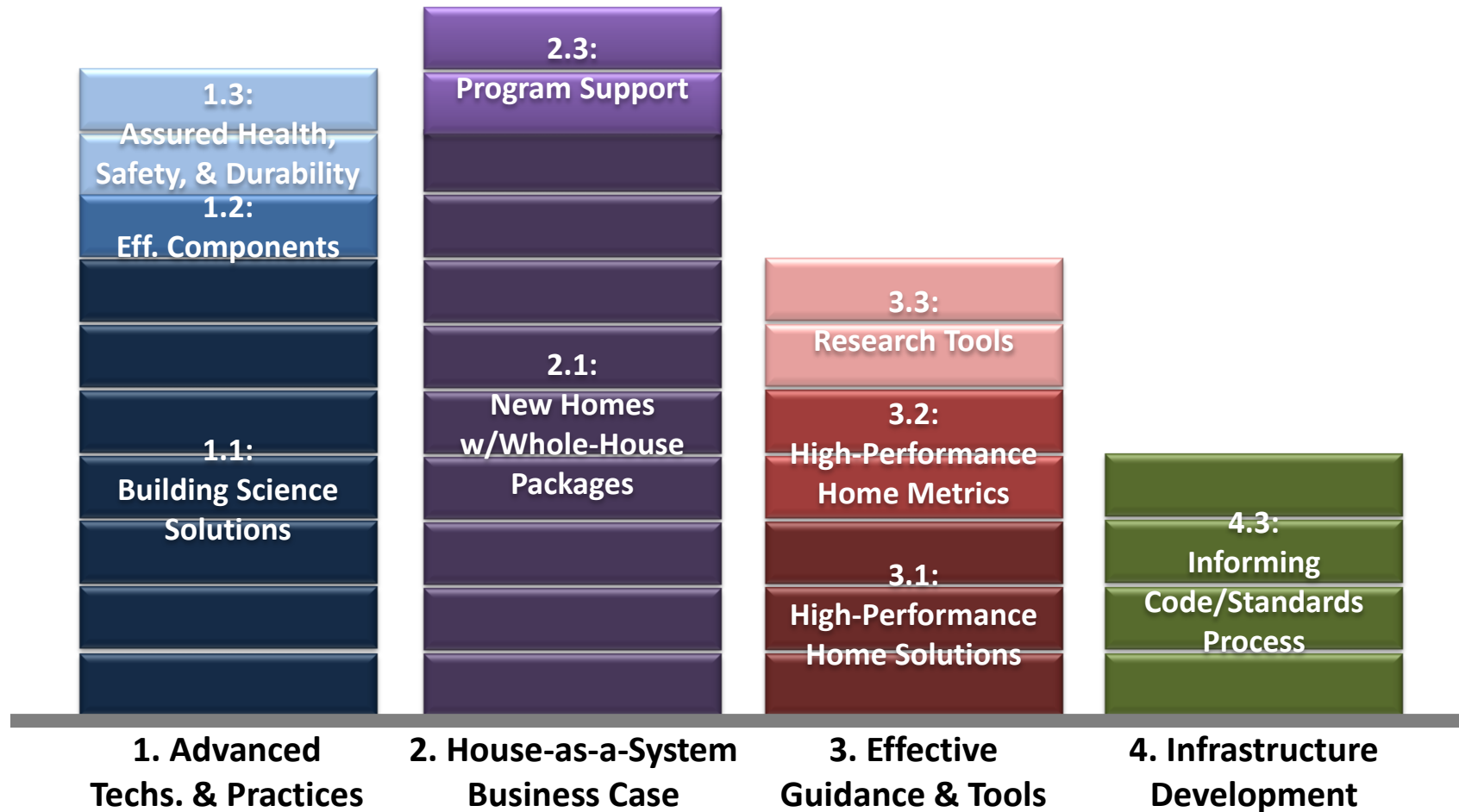
# Top Innovations



# Top Innovations

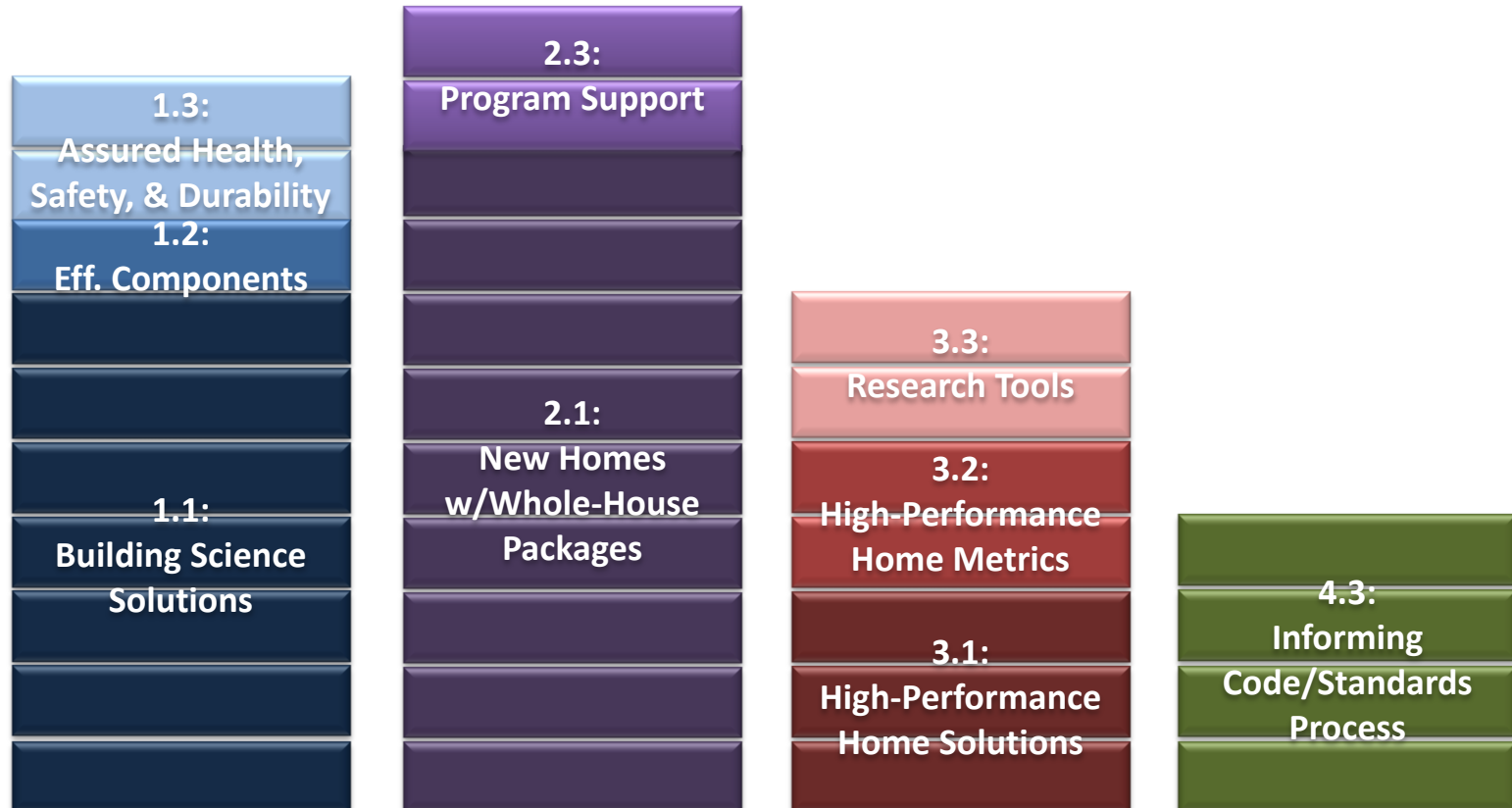


# Top Innovations





# Top Innovations



**1. Advanced Techs. & Practices**

**2. House-as-a-System Business Case**

**3. Effective Guidance & Tools**

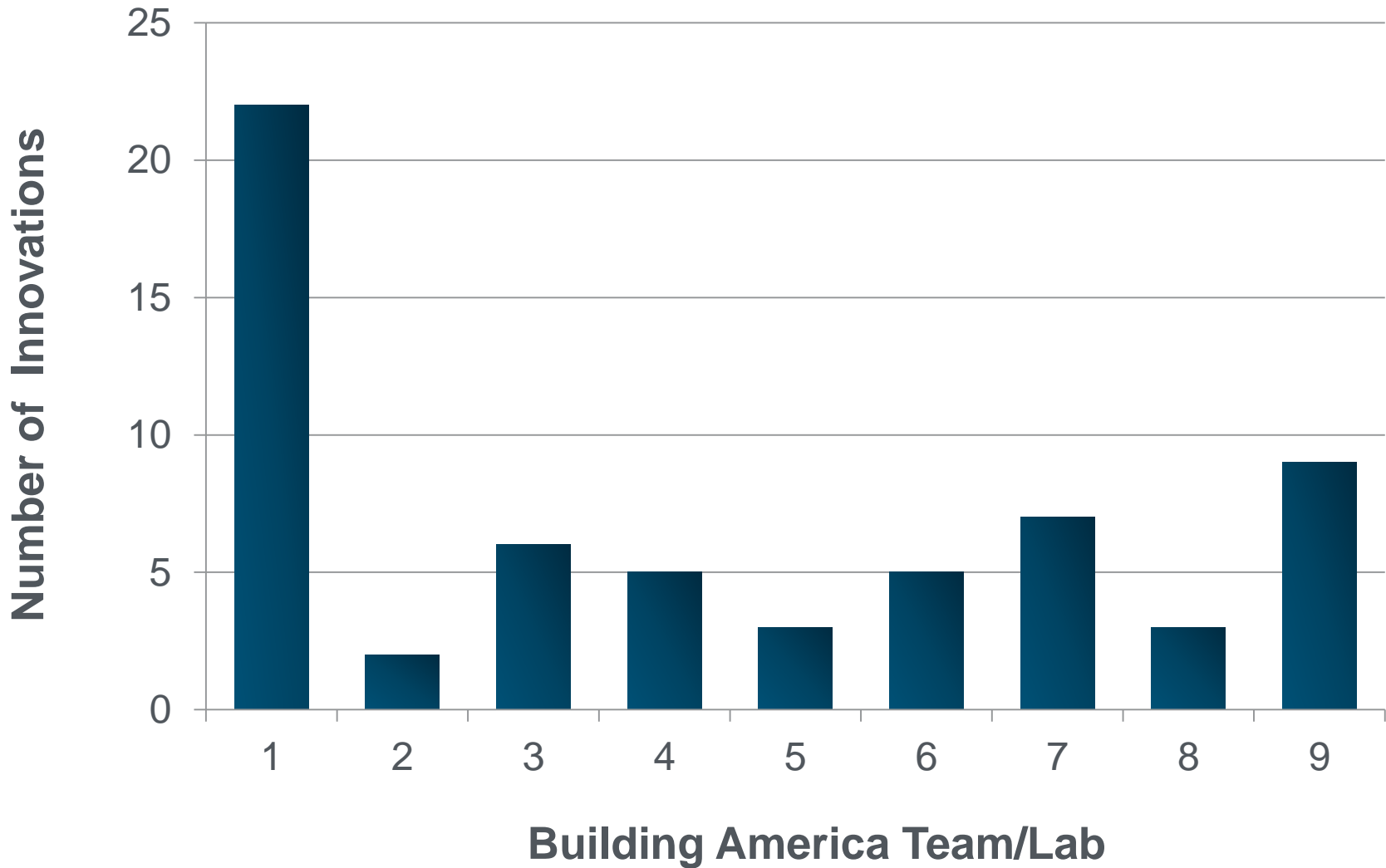
**4. Infrastructure Development**

**Gaps:**

2.2:  
Existing Homes w/  
Whole-House Pkgs.

4.1:  
Educating  
Professionals

4.2:  
Recognize Value in  
Transaction Proc.



- Determine Criteria
- Solicit Nominations
- Research Past Documents
- Compile Complete List of BA Innovations
- Identify Story (Innovations Categories)
- Sort Nominations
- Select Top Innovations per Criteria
- **Tell the Story – Top Innovation Profiles**

## Research by Building America diagnosed the causes and prescribed a cure that dramatically reduced moisture problems in manufactured housing in Florida.



Duct leakage was a key factor in moisture damage in manufactured homes in humid climates.

Building America researchers visited 24 manufactured home factories between 1996 and 2003 and tested duct leakage in 190 units: 132 with mastic-sealed ducts and 58 with taped ducts. The target duct leakage goal was a 6% total duct leakage—68% of the homes with mastic-sealed ducts achieved this target while only 34% of the homes with taped ducts achieved this.



**RECOGNIZING TOP INNOVATIONS IN BUILDING SCIENCE** – The U.S. Department of Energy's Building America program was started in 1995 to provide research and development to the residential new construction and remodeling industry. As a national center for world-class research, Building America funds integrated research in market-ready technology solutions through collaborative partnerships between building and remodeling industry leaders, nationally recognized building scientists, and the national laboratories. Building America Top Innovation Awards recognize those projects that have had a profound or transforming impact on the new and retrofit housing industries on the road to high-performance homes.

Research by Building America diagnosed the causes and prescribed a cure that dramatically reduced moisture problems in manufactured housing in Florida.

In the late 1990s, Building America researchers at the Florida Solar Energy Center (FSEC) worked with manufactured home builders to diagnose moisture problems in homes in Florida. Moisture issues were so severe that in some homes researchers could push their fingers through the saturated drywall. Using a whole-house diagnostic approach, researchers determined that the primary cause of moisture problems was duct leakage.

Between 1996 and 2003 researchers visited 24 manufactured home factories and tested duct leakage in 190 homes. Researchers measured total duct leakage and/or duct leakage outside in 101 houses representing 190 floors (some homes were double wide which equals two floors). Most homes had mastic-sealed ducts but one-third of the duct systems were sealed with tape. Results of the studies showed that the duct leakage goal of ≤ 6% total duct leakage was achieved by a much higher percent of homes with mastic-sealed ducts than with tape-sealed ducts. The researchers observed that mastic provided a much more durable seal than did tape.

The researchers identified several issues with duct installation at the factories: leaky supply and return plenums, misalignment of ducts and openings, sloppy free-hand cutting of holes in duct board and sheet metal, insufficient connection area at joints, mastic applied to sawdust-covered surfaces, insufficient or missing mastic, loose tie straps on flex duct connections, incomplete tabbing of fittings, and improperly applied tape.

"Based on research with Building America, Palm Harbor Homes implemented duct system testing and increased return air pathways from bedrooms to 50 inches<sup>2</sup> per 100 cfm of supply air company wide. Since this implementation started, Palm Harbor has manufactured 35,000 homes and has had no incidents of moisture-related issues in homes installed in hot-humid climates. Additionally, air flow issues have been all but eliminated."

**Bert Kessler**, Vice President of Engineering, Palm Harbor Homes

### BUILDING AMERICA TOP INNOVATIONS 'HALL OF FAME' PROFILE

The researchers made several recommendations regarding the ducts: set a duct tightness target of ≤ 6% total duct leakage or ≤ 3% duct leakage to the outside, seal all joints with mastic, accurately cut holes and fully bend all tabs at collar and boot connections, tighten strap ties with a strap-tightening tool, and provide return air pathways from bedrooms to main living areas. Researchers also provided the manufacturers with recommendations regarding HVAC system efficiency, improved windows, adding insulation, and air sealing especially at the marriage line of double-wide units.

When the recommendations were implemented in two homes in a demonstration of four homes, the two homes that were mastic sealed had less than half the air leakage of those sealed with tape.

In addition to providing these research findings and recommendations, Building America followed through with the manufacturers.

#### Duct Tightness Results in Demonstration

Home	CFM25 Total
Control Home	118
Control Home	126
Energy Home	51
Healthy Home	79



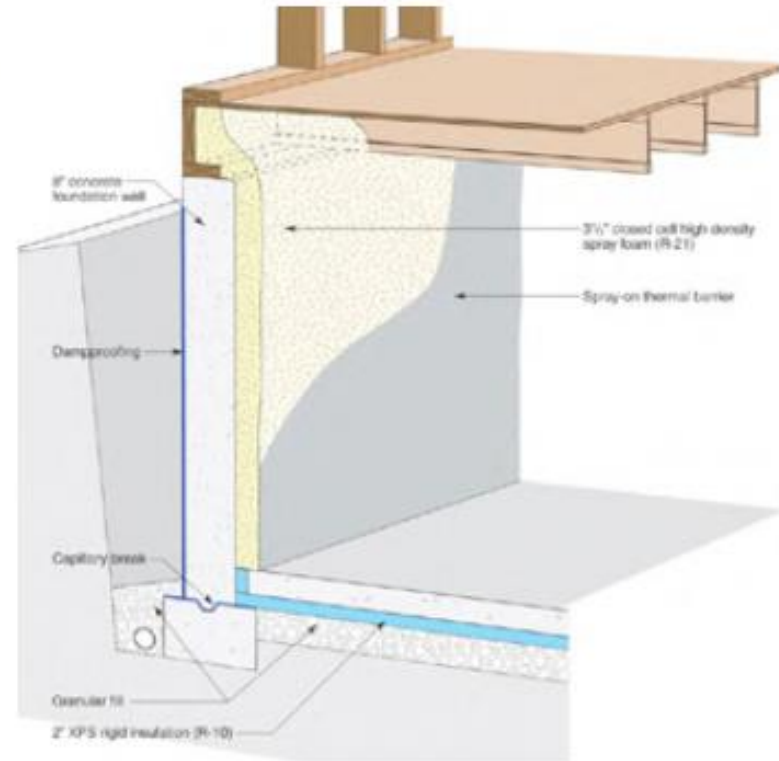
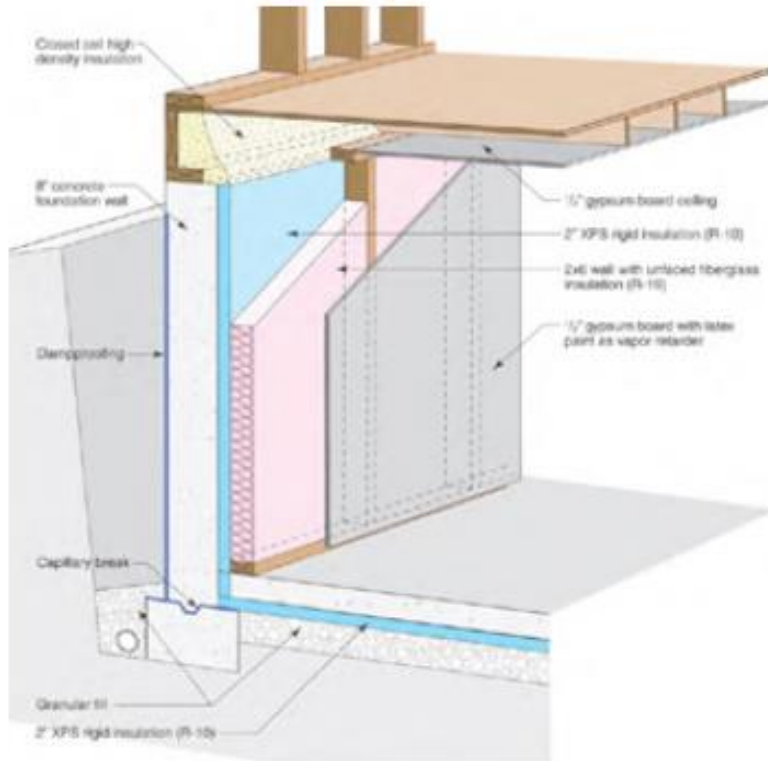
FSEC shared the lessons learned in

Building America researchers visited 24 manufactured home factories between 1996 and 2003 and tested duct leakage in 190 units: 132 with mastic-sealed ducts and 58 with taped ducts. The target duct leakage goal was ≤ 6% total duct leakage—68% of the homes with mastic-sealed ducts achieved this target while only 34% of the homes with taped ducts achieved this.

Building America research has provided essential guidance for one of the most challenging assemblies in cold-climate high-performance homes.

- Basements 10% to 30% of total heat loss.
- Significant moisture problem risks due to extensive cold surfaces at walls and slab.

# Building America Top Innovations Adv. Techs. & Practices: Building Science Solutions Basement Insulation Systems



Research has demonstrated unvented, conditioned attics can substantially improve energy performance while allowing builders to continue locating HVAC systems in attic space.

- Unconditioned attic duct heat loss/gain increases heating/cooling energy use 10%.
- Further losses attributed to duct leakage commonly exceeding 20% of air flow.
- Code acceptance since 2006
- 10,000's of homes





# Unvented Conditioned Crawlspace

In most climates, this innovation saves energy while improving comfort, health, and durability.

This research has encouraged adoption by builders and codes.

- 15 – 18% less heating/cooling energy use
- 20+% less humidity
- 2009 and 2012 IRC changes allowing conditioned crawlspaces influenced.
- 1,000's of homes

Building America Top Innovations  
Adv. Techs. & Practices: Building Science Solutions  
**Unvented Conditioned Crawlspace**

U.S. DEPARTMENT OF  
**ENERGY**

Energy Efficiency &  
Renewable Energy



Research has provided proven high-R wall options that cost-effectively control both thermal and moisture flow. This innovation is critical to high-performance homes.

- Measured R-value is almost always lower than the rated whole-wall R-value.
- Potential for condensation occurs 15 – 95% of the time with several high-R wall types.
- Thus, high-R wall research is critical to efficiency and durability goals.

## Evaluation of Three Common High-R-Value Wall Assemblies

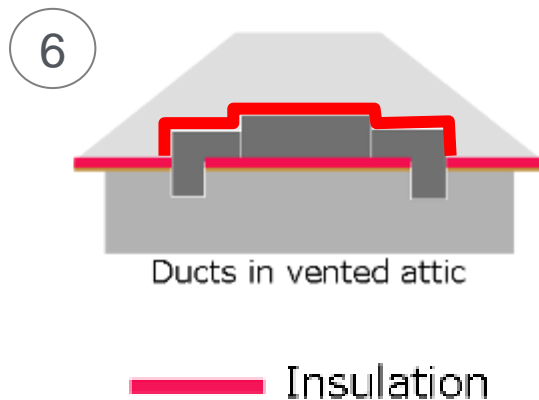
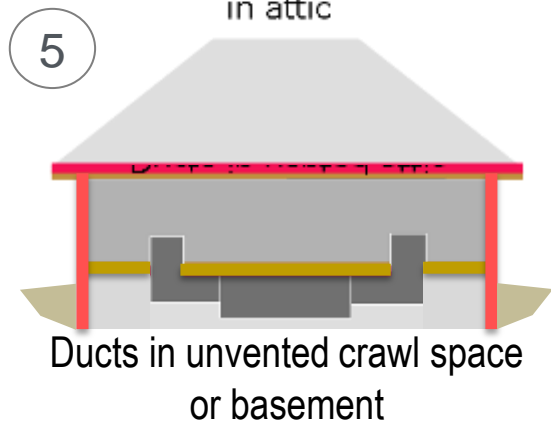
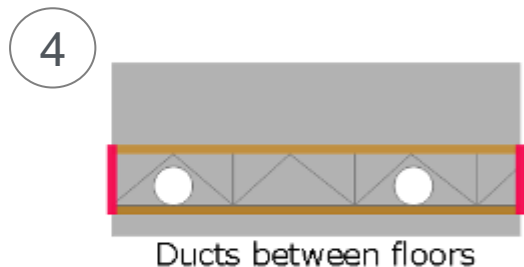
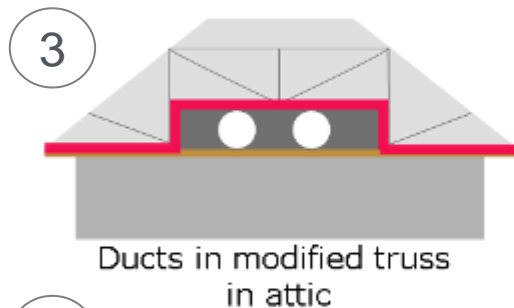
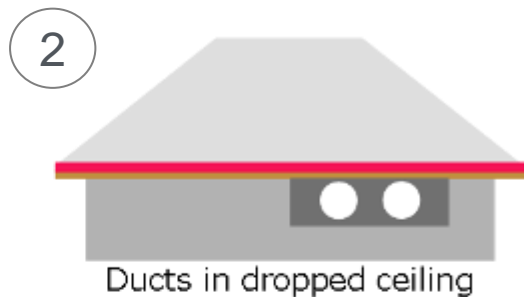
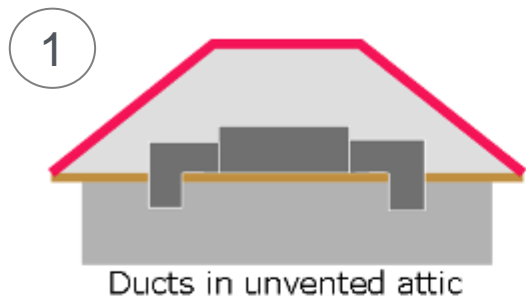
*(Aldrich et al. 2010)*

Wall Type	Cost*	Advantages	Challenges
Double framed walls with blown or sprayed insulation	\$1,500 - \$2,500	Similar methods to traditional stick construction	Complex designs can double time and cost
2x4 or 2x6 insulated, framed walls with exterior rigid foam insulation	\$3,000 - \$3,500	Reduced condensation potential, good drying potential	Increased cost for XPS, furring, for finishing doors and windows
Structural insulated panels 8-1/4" SIP 10-1/4" SIP	\$1,500 \$2,250	Speed of assembly, inherent air-tightness	Requires special training
Incremental cost when comparing 800 ft <sup>2</sup> of this wall to 800 ft <sup>2</sup> of a baseline 2x6 wall			

Building America has provided proven solutions for locating ducts in conditioned space that are being adopted by builders across the country.

- ~8 – 15% savings on air conditioning bills
- 1,000's of homes

# Building America Top Innovations Adv. Techs. & Practices: Building Science Solutions Ducts in Conditioned Space - New





**Figure 20. Ductwork well-sealed to sheetrock with ccSPF**



**Figure 21. Rigid insulation inserted under ductwork to serve as a substrate and provide insulating value**



**Figure 22. Varying thickness of ccSPF and interference from cross bracing**



**Figure 23. Varying application thicknesses shown on rectangular (left) and round (right) ducts**

Water heating continues to grow in importance as improved thermal enclosures dramatically reduce heating and cooling loads. Building America has provided important insight regarding one of the most significant options.

- Potential for 33% savings
- Actual savings vary significantly based on individual draw and volume.
- Effic. approaches rated EF > 10 gallons/draw.
- Greatest savings occur at 50 gal./day use.

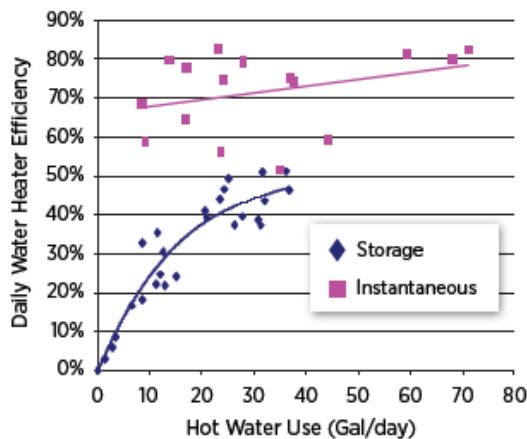


# Building America Top Innovations

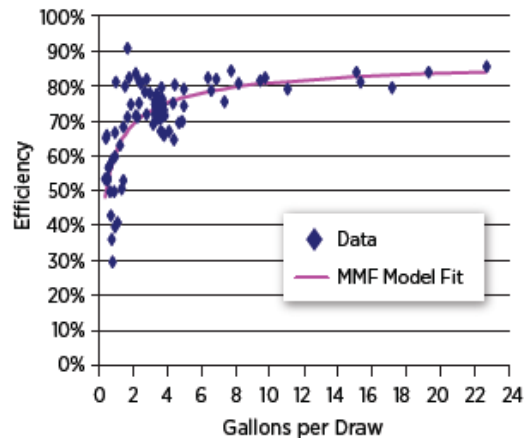
## Adv. Techs. & Practices: Building Science Solutions

# Tankless Gas Water Heater Perf.

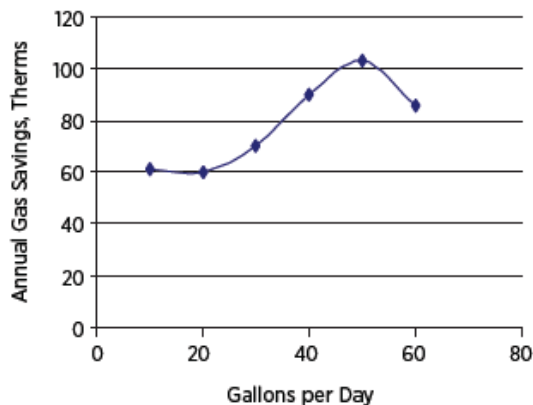
Measured Performance of Storage and Tankless Gas Water Heaters as a Function of Daily Hot Water Use



Performance of a Tankless Gas Water Heater as a Function of Draw Volume



Approximate Annual Energy Savings as a Function of Daily Hot Water Use



### REFERENCES

CARB. 2009. *Tankless Water Heater*, Prepared by Steven Winter Associates, Inc. for the U.S. Department of Energy Building America. [http://apps1.eere.energy.gov/buildings/publications/pdfs/building\\_america/tankless\\_water\\_heaters.pdf](http://apps1.eere.energy.gov/buildings/publications/pdfs/building_america/tankless_water_heaters.pdf)

NREL. 2006. *Building America System Research Results: Innovations for High performance Homes*, NREL/TP-550-39024, Prepared by the National Renewable Energy Laboratory for the U.S. Department of Energy Building America.

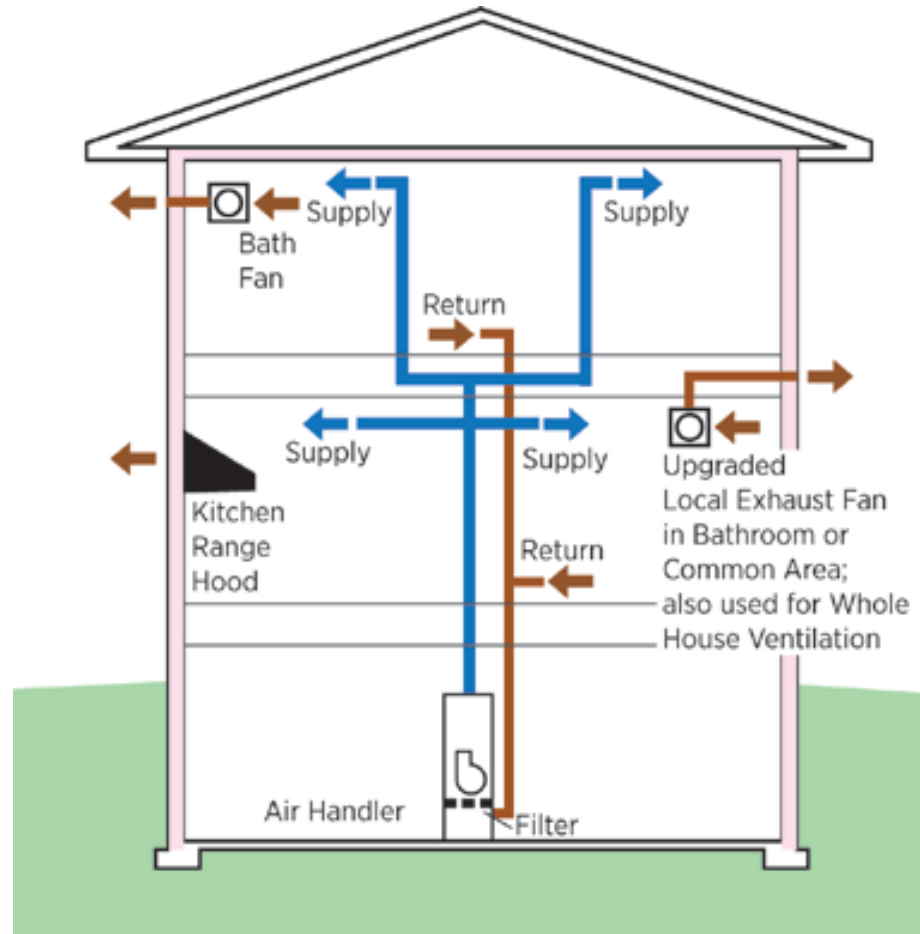
High-performance homes require attention to good indoor air quality. Building America has effectively influenced our nation's home builders to embrace whole-house ventilation with low-cost options that adapt well to their production processes.

- Simple whole-house ventilation systems cost less than \$350 to install
- 1,000's of homes using these systems

# Building America Top Innovations

## Adv. Techs. & Practices: Building Science Solutions

# Simple, Low-Cost Ventilation



# Building America Top Innovations House-as-a-System Business Case: New Home Packages Cost Performance Trade-Offs

## Added Costs & Cost Reductions of Energy-Efficiency Measures – Hot-Dry Climate Example

Unvented Roof	+ \$750
NOT Installing Roof Vents	- \$500
High-Performance Windows	+ \$300
Controlled Ventilation System	+ \$150
Downsize Air Conditioner 2 Tons	- \$1,000
Sealed Combustion Furnace	+ \$400
<b>TOTAL PREMIUM</b>	<b>+ \$100</b>

## Added Costs & Cost Reductions of Energy-Efficiency Measures – Severe Cold Climate Example

Advanced Framing	- \$250
High-Performance Windows	+ \$250
Controlled Ventilation System	+ \$150
Power Vented Gas Water Heater	+ \$300
Simplified Duct Distribution	- \$250
Downsize Air Conditioner 1 Ton	- \$350
<b>TOTAL ADDED COST</b>	<b>- \$150</b>

# Building America Top Innovations House-as-a-System Business Case: New Home Packages Affordable High-Perf. with HFH

U.S. DEPARTMENT OF  
**ENERGY**

Energy Efficiency &  
Renewable Energy





**Urbane's** first home, built for \$36 per ft<sup>2</sup> in 2008, incorporated both energy efficiency and strategies to reduce building costs. Homebuyers began seeking out the builder for energy-efficient, high-quality homes.

Urbane Homes, Louisville, KY

Building America Top Innovations  
House-as-a-System Business Case: New Home Packages  
**Hot-Humid Moisture Control**



Green Coast Communities, New Orleans, LA



**Pulte Homes** worked with Building America's IBACOS team to develop a suite of energy efficiency measures, including solar water heating, that cut energy use more than 50% on more than 1,000 homes in Tucson, Arizona.

Pulte Homes at Civano in Tucson, AZ





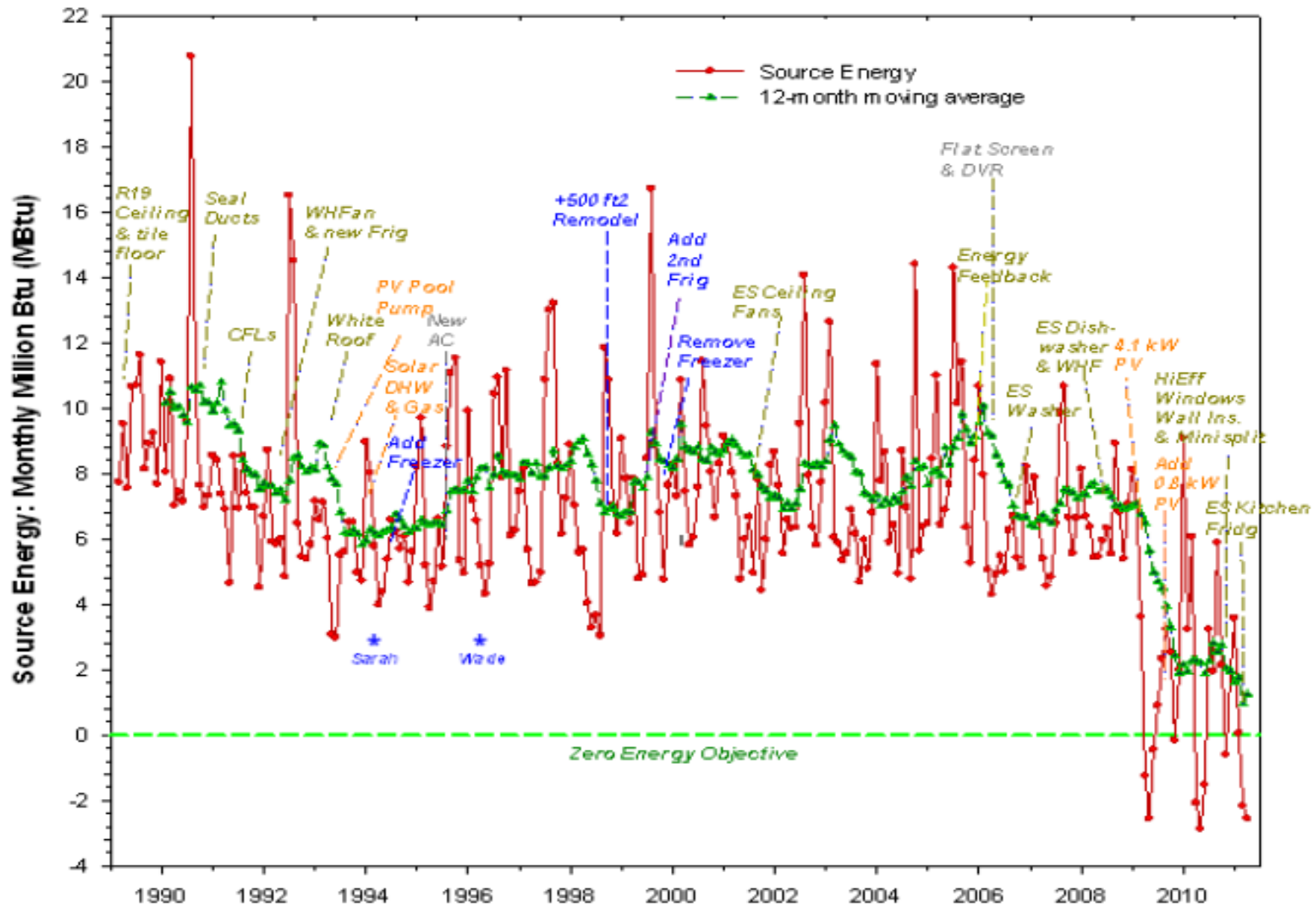
**FSEC: Parker Residence**  
Increasing evidence that Phased Deep Retrofit (PDR) approaches can lead to cost-effective DER, even ZNE. This case study and research report describes details of a cost-effective PDR that achieved Net positive in 2012.

Parker Residence, Cocoa Beach, FL

# Source Energy & Retrofit History for Parker Family

## Electricity and Natural Gas

### Cocoa Beach, 1989 - 2011





# U.S. Department of Energy Energy Efficiency and Renewable Energy

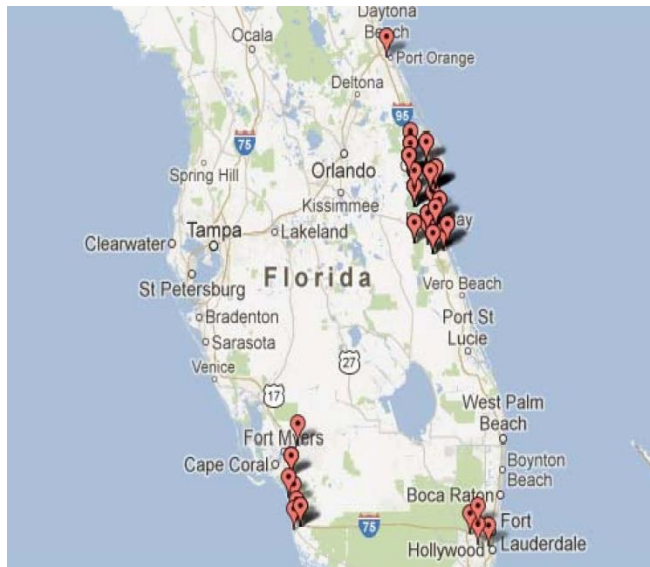
Bringing you a prosperous future where energy is clean, abundant, reliable, and affordable

## Building Technologies Program

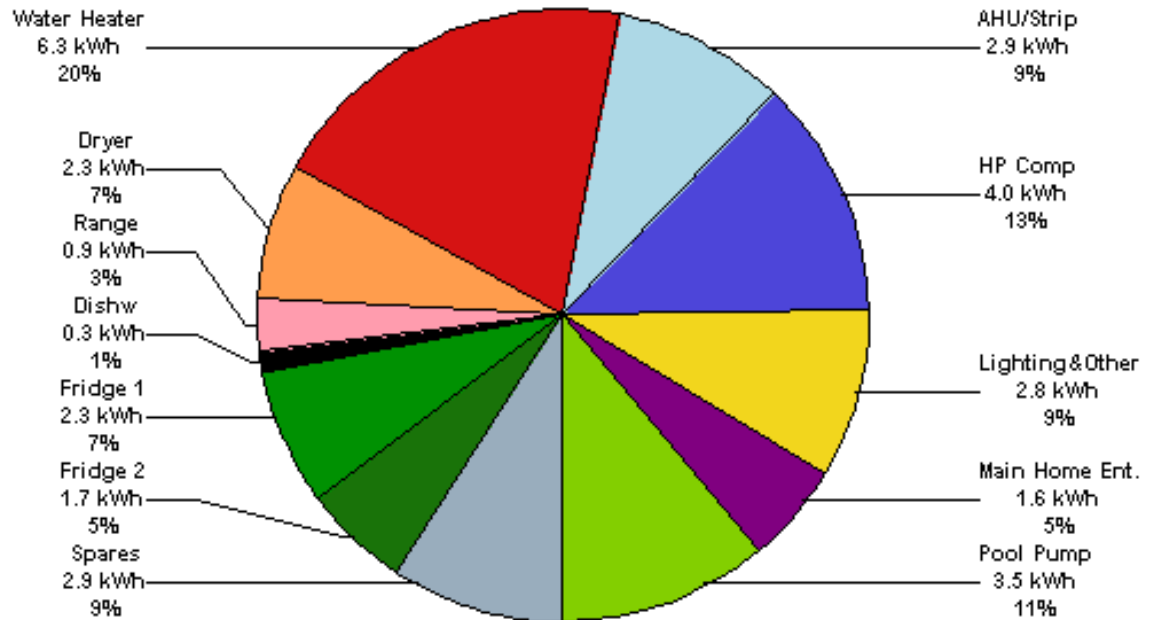


**Building AMERICA**  
U.S. Department of Energy  
Research Leading to Zero Energy Homes

# *Phased Deep Retrofit Need: Averages don't tell all (FL Example)*



**Electricity by End-Use, Jan 27, 2013-Feb 25, 2013  
Houses 1-60, 35.8 kWh/day Total**





# U.S. Department of Energy Energy Efficiency and Renewable Energy

Bringing you a prosperous future where energy is clean, abundant, reliable, and affordable

## Building Technologies Program



**Building AMERICA**  
U.S. Department of Energy  
Research Leading to Zero Energy Homes

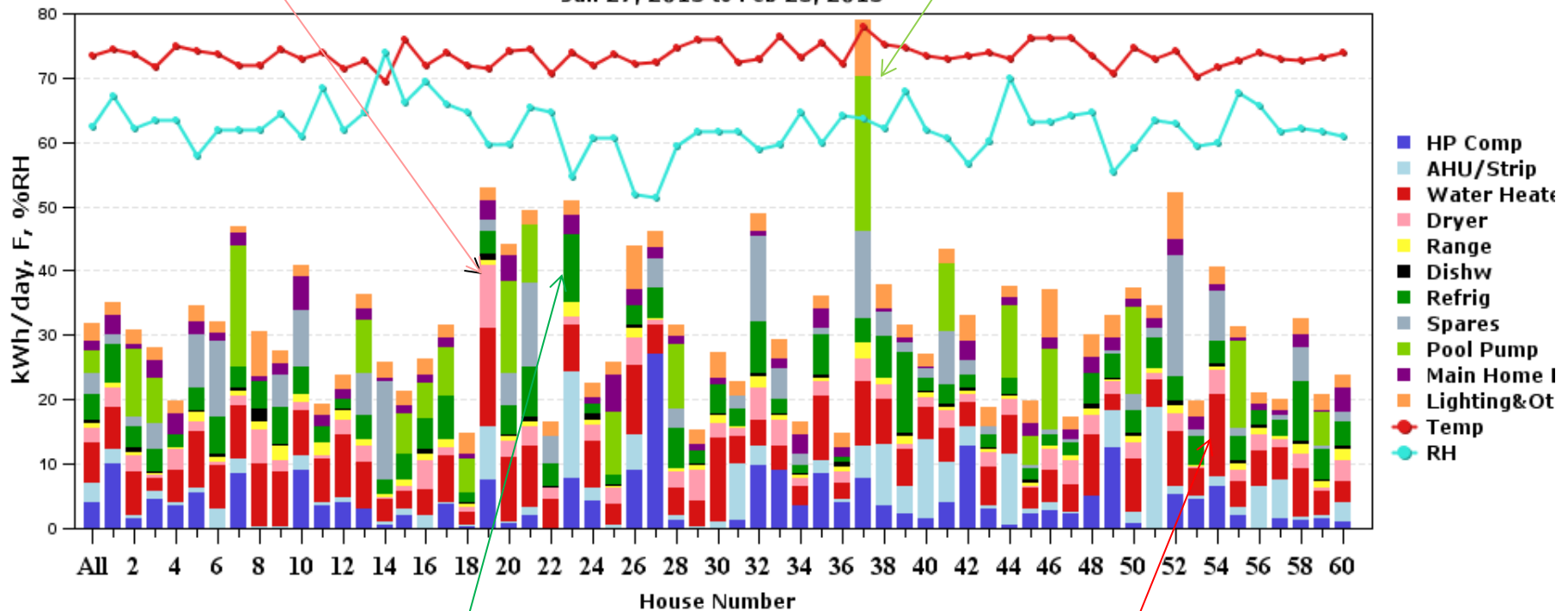
# Phased Deep Retrofits in Florida

10 kWh/d: clothes drying

24 kWh/d for pool pumping

### Phased Deep Retrofits Electricity by End Use

Jan 27, 2013 to Feb 25, 2013



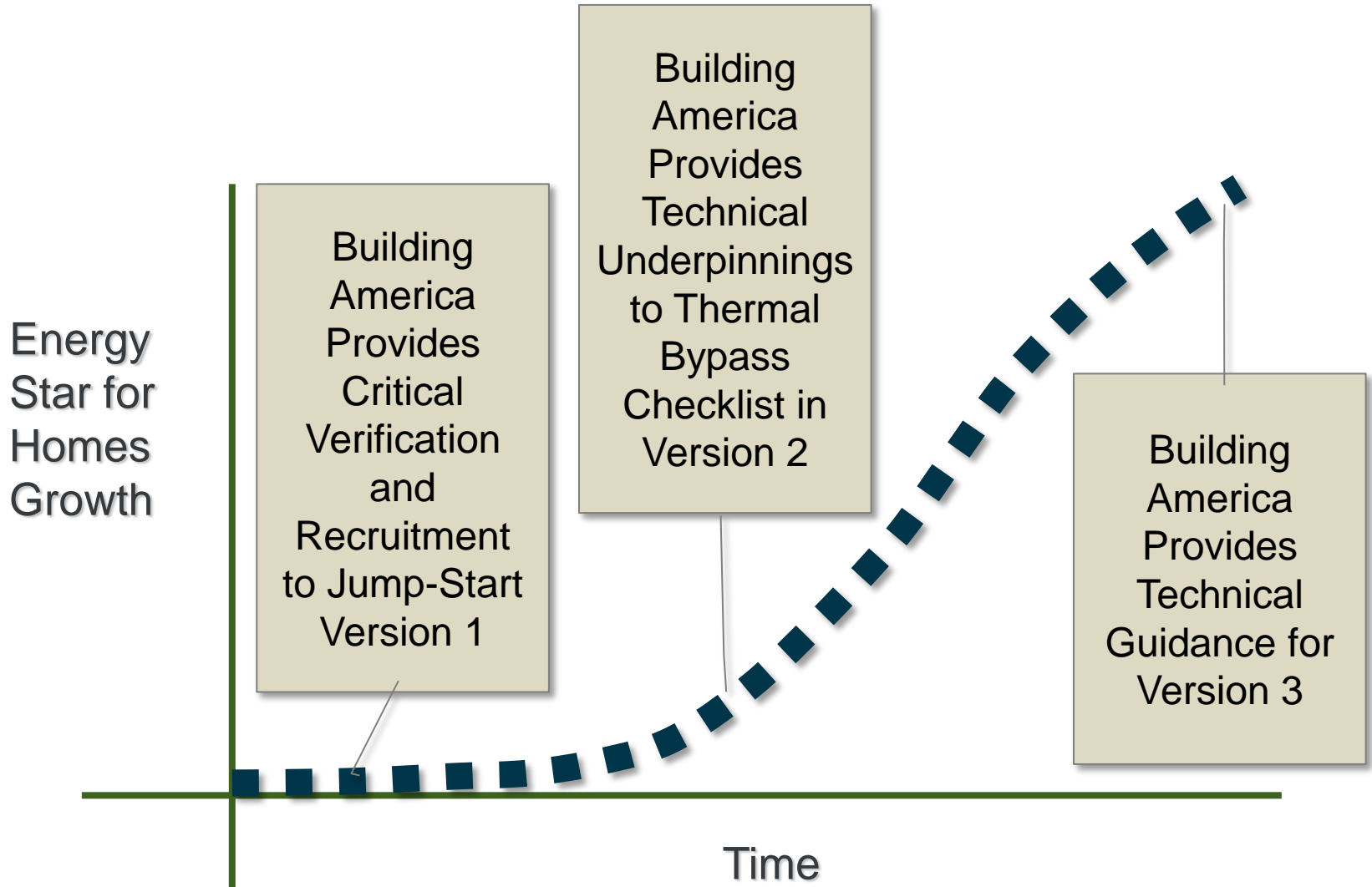
10 kWh/d: refrigerators

13 kWh/day: water heat

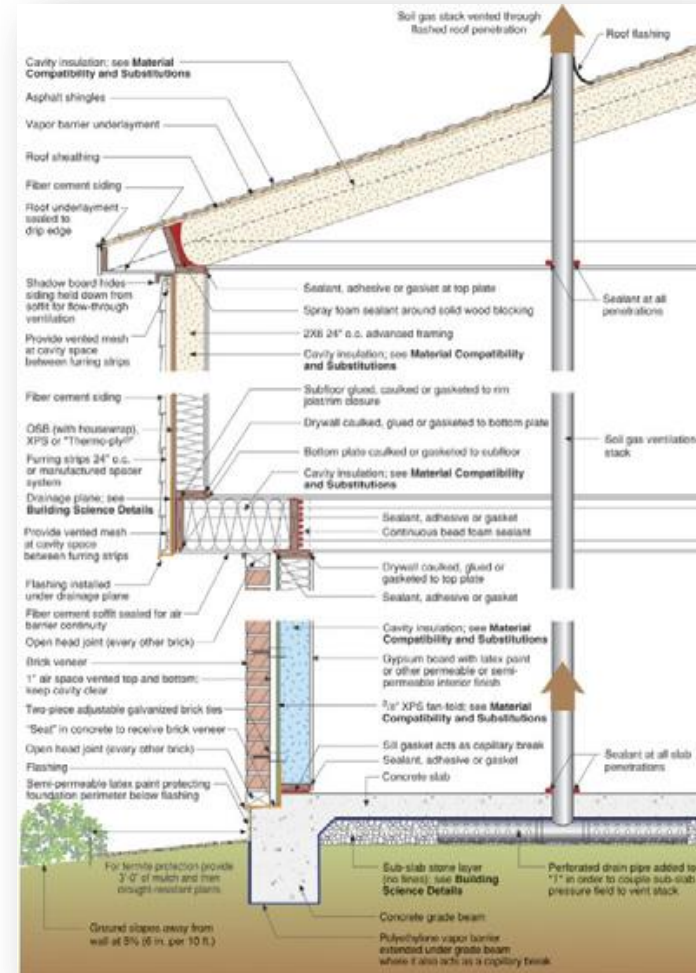
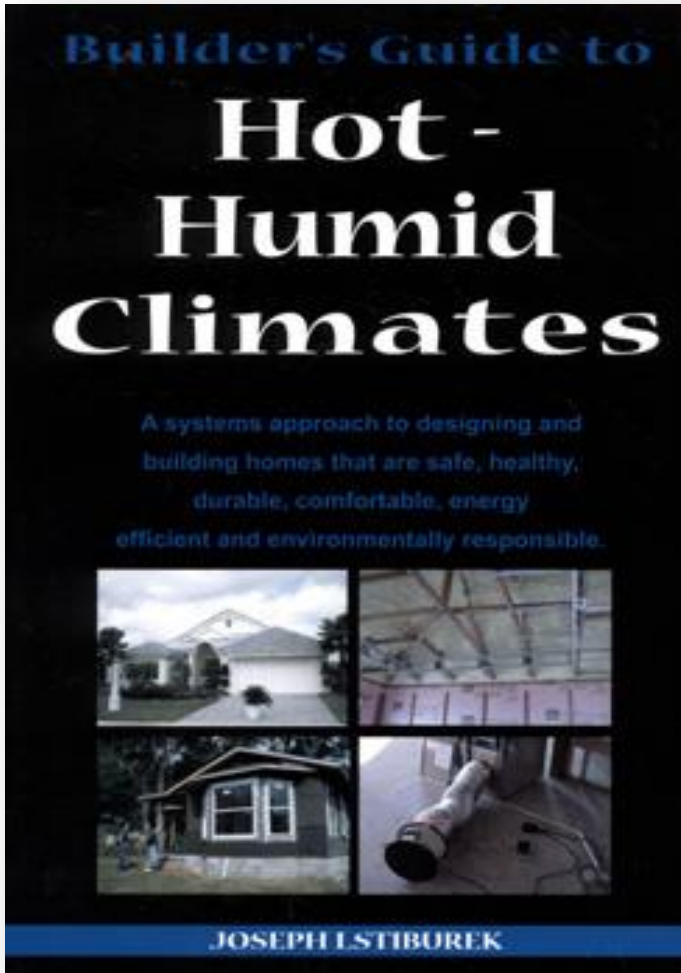
ENERGY STAR for Homes with critical support from Building America has helped transformed the U.S. housing industry to high performance along with a national HERS infrastructure.

- ~25% of all homes constructed in 2011
- Over 1.3 million certified homes
- ~\$23 billion energy cost savings
- ~210 million tons of avoided GHG emissions

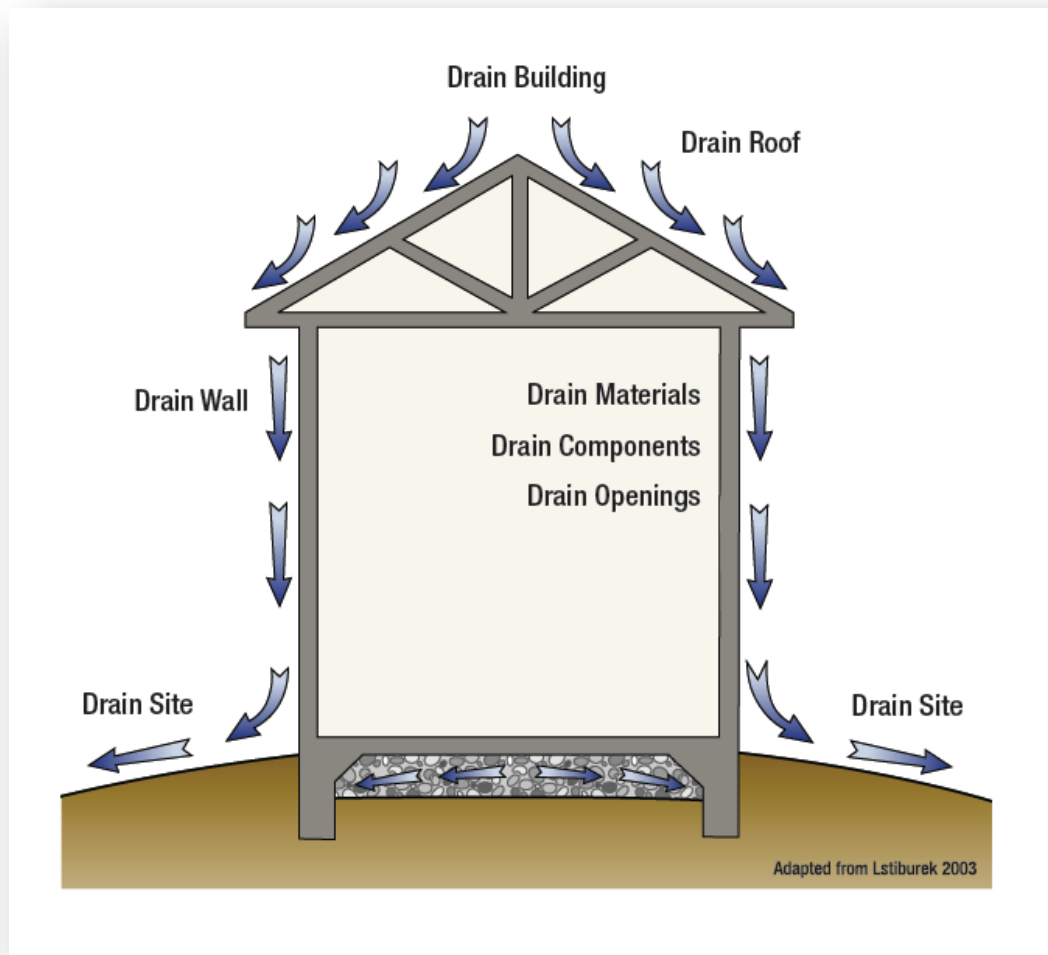
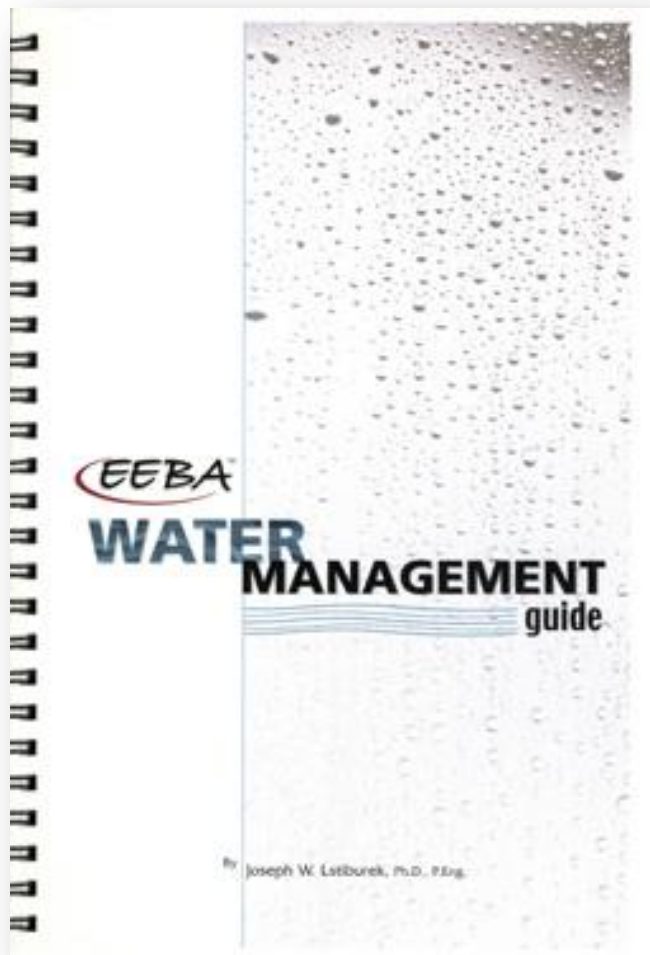
Building America Top Innovations  
House-as-a-System Business Case: Program Support  
**ENERGY STAR** for Homes Support



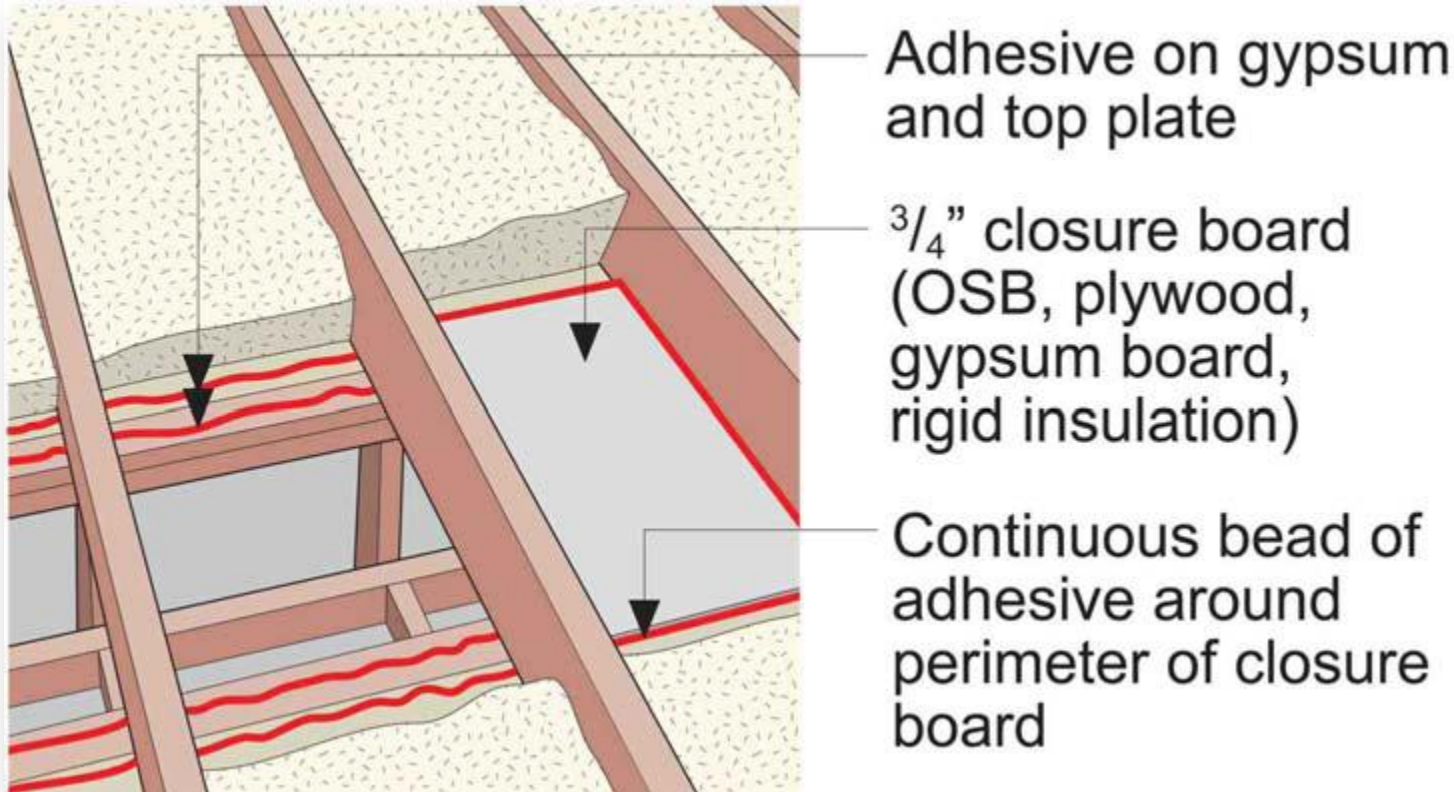
# Building America Top Innovations Effective Guidance and Tools: High-Performance Homes EEBA Builder Guides



# Building America Top Innovations Effective Guidance and Tools: High-Performance Homes EEBA Water Management Guide

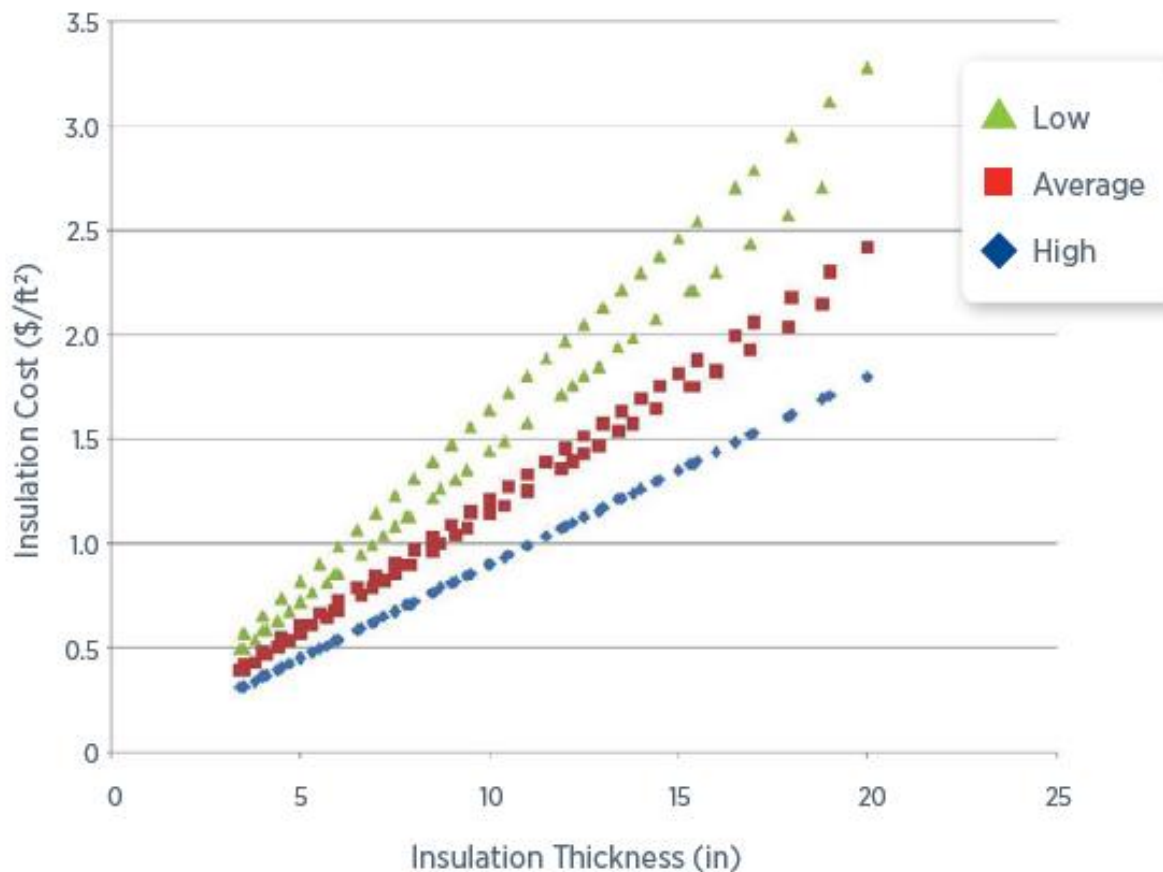






### Insulation Thickness & Cost

The database provides the ability to visualize data for quality assurance.



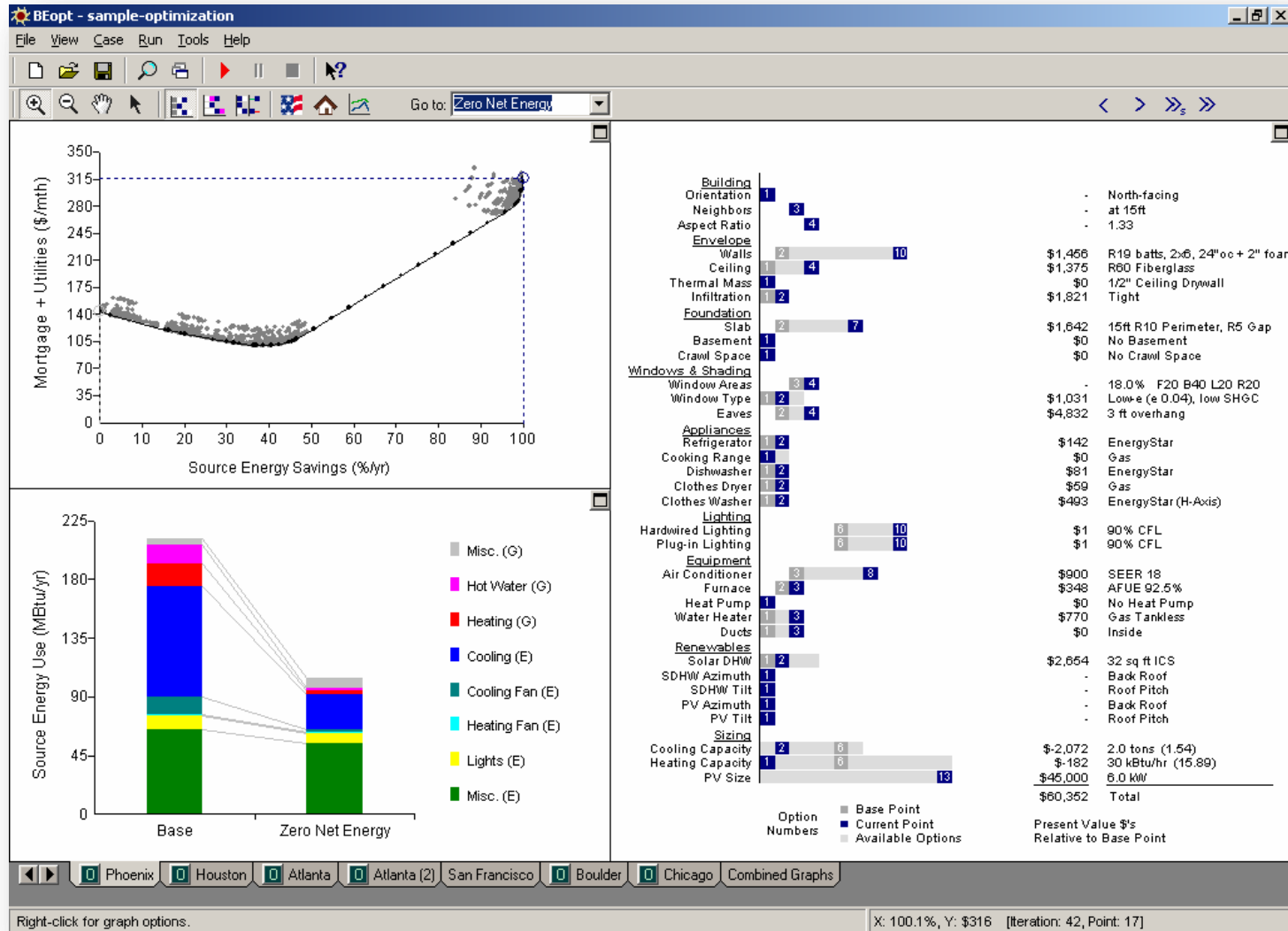
## Default R-Values for Common Insulation Types

The table shows default R-values for common insulation types used in analysis for retrofit homes. NREL derived the values from several sources (Henderson and Egebrecht 2010).

Insulation Material	Nominal R-Value/in.
High-density fiberglass batt	3.8/in.
Low-density fiberglass batt	3.1/in.
Loose-fill fiberglass	3.2/ in.
Cellulose	3.7/in.
EPS	4.0/in.
XPS	5.0/in.
Open-cell polyurethane foam	3.6/in.
Closed-cell polyurethane foam	6.5/in.
Rigid polyisocyanurate	7.2/in.

\* the Building  
America Benchmark

# Building America Top Innovations Effective Guidance and Tools: Research Tools BeOPT Software

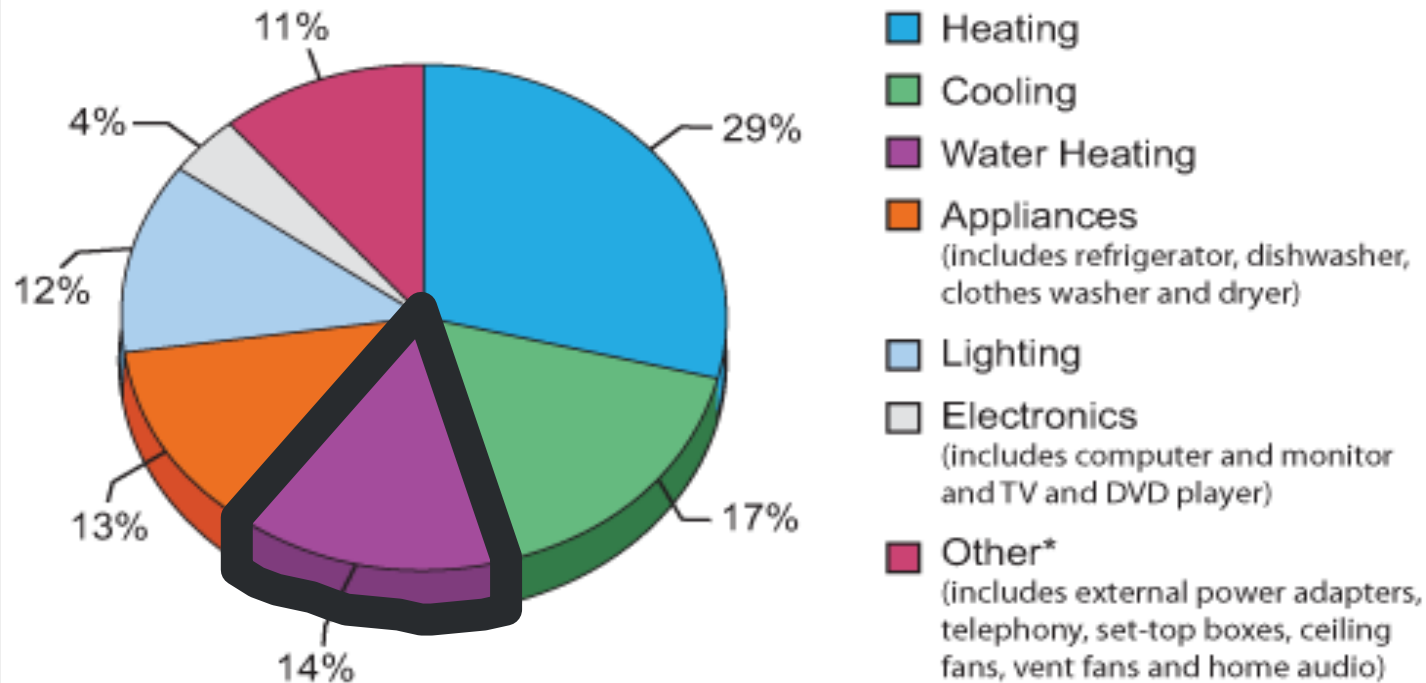


# Building America Top Innovations

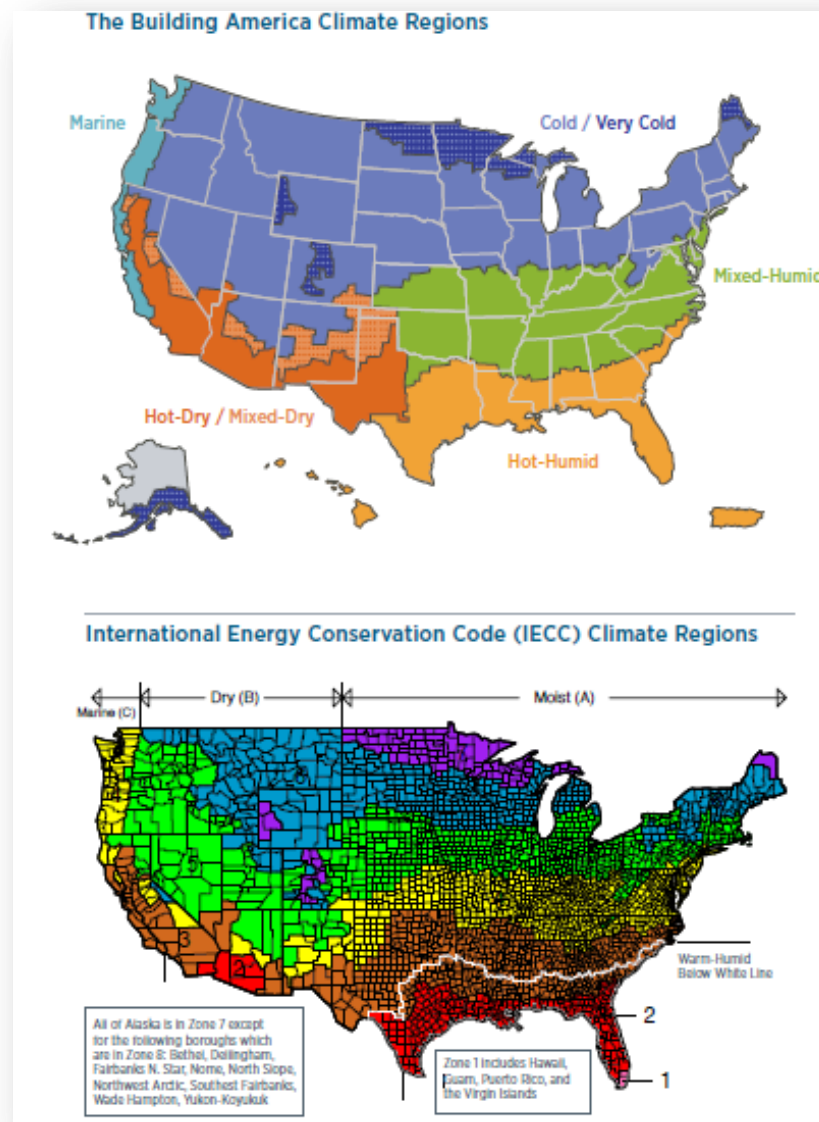
## Effective Guidance and Tools: Research Tools

# Model Simulating Real DHW Use

Annual Energy Bill for a typical Single Family Home is approximately \$2,200.



# Building America Top Innovations Infrastructure Development: Informing Code and Standards Building Science Climate Maps



## Vapor Retarder Definitions

The 2009 IRC R601.3 gives the following definitions and examples for vapor retarder classes:

Class	Definition	Examples
I	≤ 0.1 perm	Sheet polyethylene, sheet metal, non-perforated aluminum foil, foil-faced insulation sheathing
II	> 0.1 to < 1.0 perm	Kraft-faced fiberglass batts or low-perm paint, unfaced expanded polystyrene, fiber-faced polyisocyanurate
III	> 1.0 perms	Latex or enamel paint

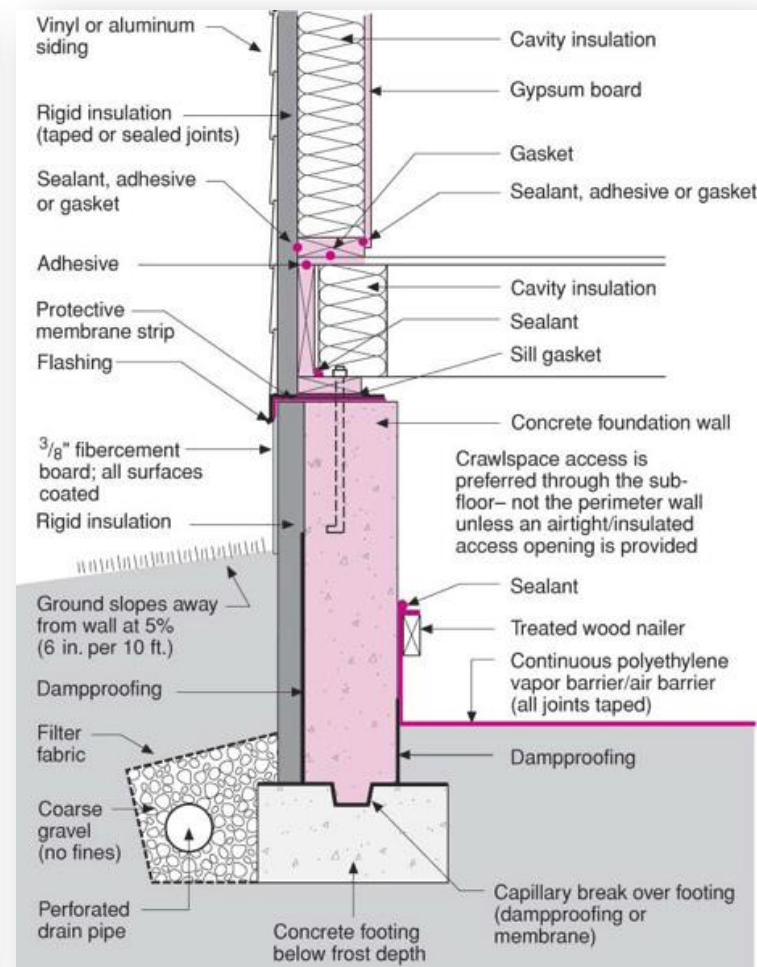
## Class III Vapor Retarders

Zone	Class III vapor retarders permitted for:
<b>Marine 4</b>	<ul style="list-style-type: none"> <li>• Vented cladding over OSB</li> <li>• Vented cladding over plywood</li> <li>• Vented cladding over fiberboard</li> <li>• Vented cladding over gypsum</li> <li>• Insulated sheathing with R-value ≥ R-2.5 over 2x4 wall</li> <li>• Insulated sheathing with R-value ≥ R-3.75 over 2x6 wall</li> </ul>
<b>5</b>	<ul style="list-style-type: none"> <li>• Vented cladding over OSB</li> <li>• Vented cladding over plywood</li> <li>• Vented cladding over fiberboard</li> <li>• Vented cladding over gypsum</li> <li>• Insulated sheathing with R-value ≥ R-5 over 2x4 wall</li> <li>• Insulated sheathing with R-value ≥ R-7.5 over 2x6 wall</li> </ul>
<b>6</b>	<ul style="list-style-type: none"> <li>• Vented cladding over fiberboard</li> <li>• Vented cladding over gypsum</li> <li>• Insulated sheathing with R-value ≥ R-7.5 over 2x4 wall</li> <li>• Insulated sheathing with R-value ≥ R-11.25 over 2x6 wall</li> </ul>
<b>7 &amp; 8</b>	<ul style="list-style-type: none"> <li>• Insulated sheathing with R-value ≥ R-10 over 2x4 wall</li> <li>• Insulated sheathing with R-value ≥ R-15 over 2x6 wall</li> </ul>

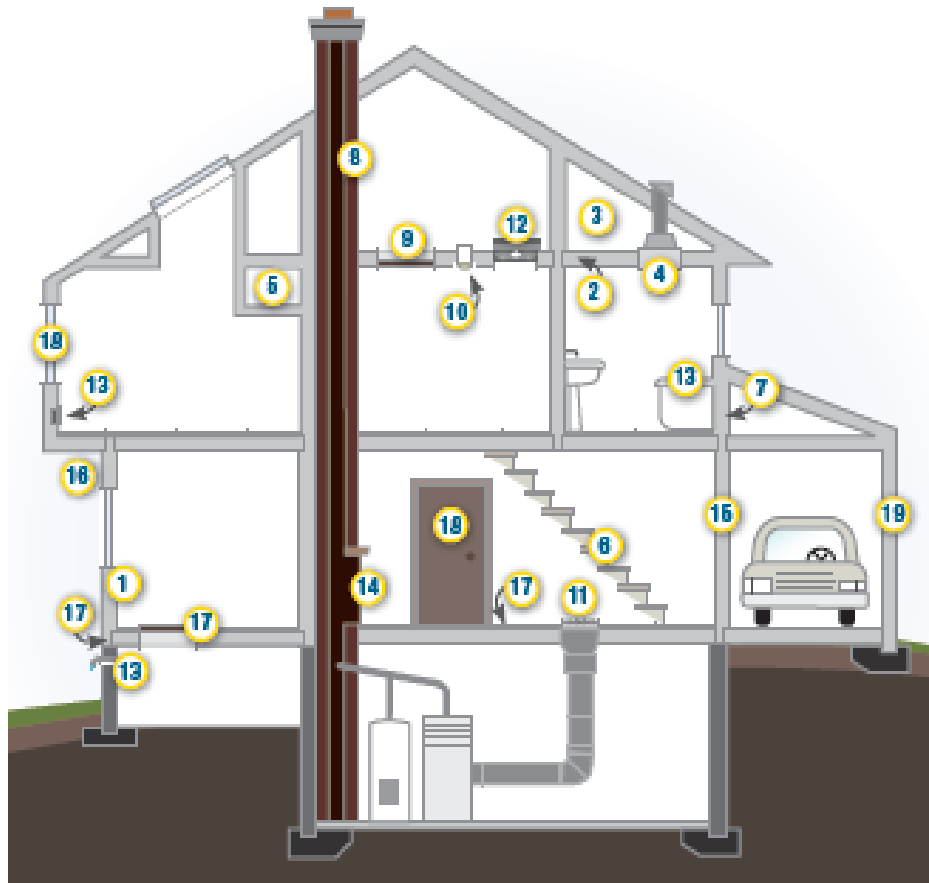
According to the 2009 IRC: "For the purposes of this section vented cladding shall include the following minimum clear air spaces. Other openings with the equivalent vent area shall be permitted."

1. Vinyl lap or horizontal aluminum siding applied over a weather-resistive barrier as specified in Table R703.4 of the *2009 International Residential Code*.
2. Brick veneer with a clear airspace as specified in Section R703.7.4.2 of the *International Residential Code*.
3. Other approved vented claddings.

# Building America Top Innovations Infrastructure Development: Informing Code and Standards Unvented Crawlspace I-Code







### Air Sealing Trouble Spots

(Baechler et al. 2010)

- |  |  |
|--|--|
| 1. Air Barrier and Thermal Barrier Alignment | 11. Ducts  |
| 2. Attic Air Sealing                         | 12. Whole-House Fan                              |
| 3. Attic Kneewalls                           | 13. Exterior Wall Penetrations                   |
| 4. Shaft for Piping or Ducts                 | 14. Fireplace Wall                               |
| 5. Dropped Ceiling/Soffit                    | 15. Garage/Living Space Walls                    |
| 6. Staircase Framing at Exterior Wall        | 16. Cantilevered Floor                           |
| 7. Porch Roof                                | 17. Rim Joists, Sill Plate, Foundation, Floor    |
| 8. Flue or Chimney Shaft                     | 18. Windows & Doors                              |
| 9. Attic Access                              | 19. Common Walls Between Attached Dwelling Units |
| 10. Recessed Lighting                        |  |

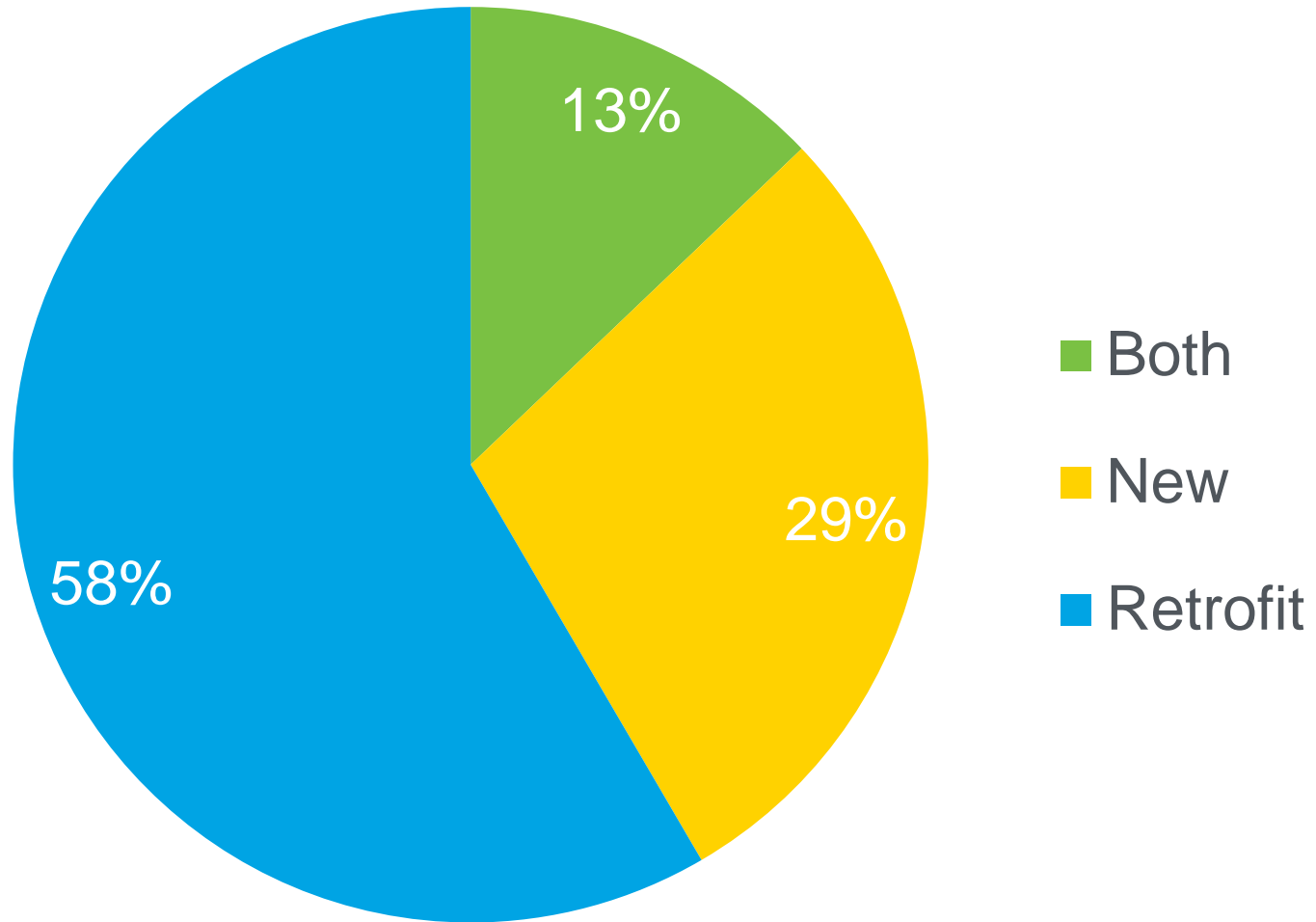
- Determine Criteria
- Solicit Nominations
- Research Past Documents
- Compile Complete List of BA Innovations
- Identify Story (Innovations Categories)
- Sort Nominations
- Select Top Innovations per Criteria
- Tell the Story – Top Innovation Profiles
- **Annual Event Announcing Top Innovations**

- Building America Hub of Innovation
- Document Legacy Innovations
- Major Event Announcing Latest Innovations
- Tool for Identifying Program Gaps
- Tool for Managing Program Assets
- Tool for Promoting Program Results

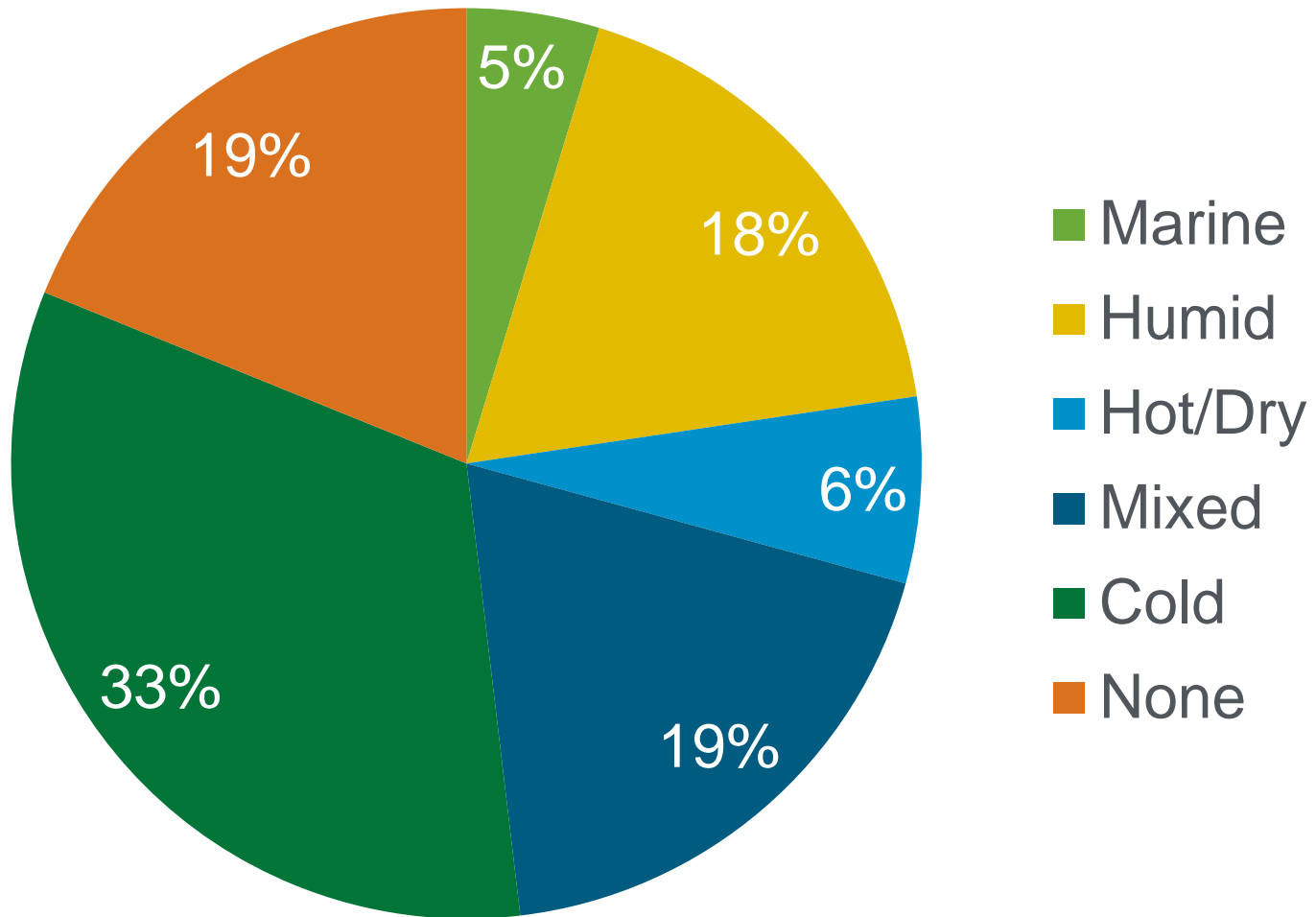
# Building America Innovations Project Portfolio



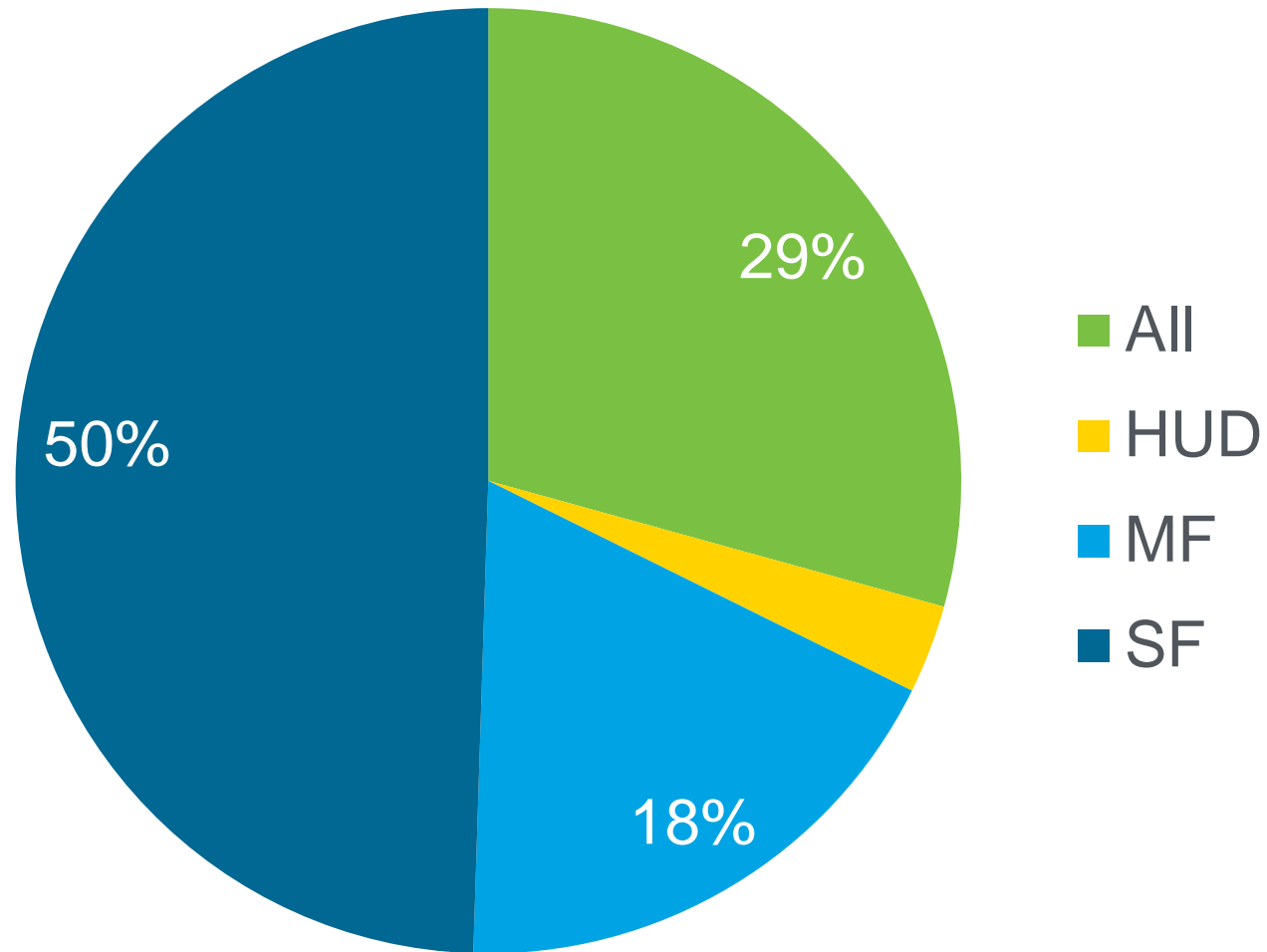
# 2012 Projects by Sector



# 2012 Projects by Climate

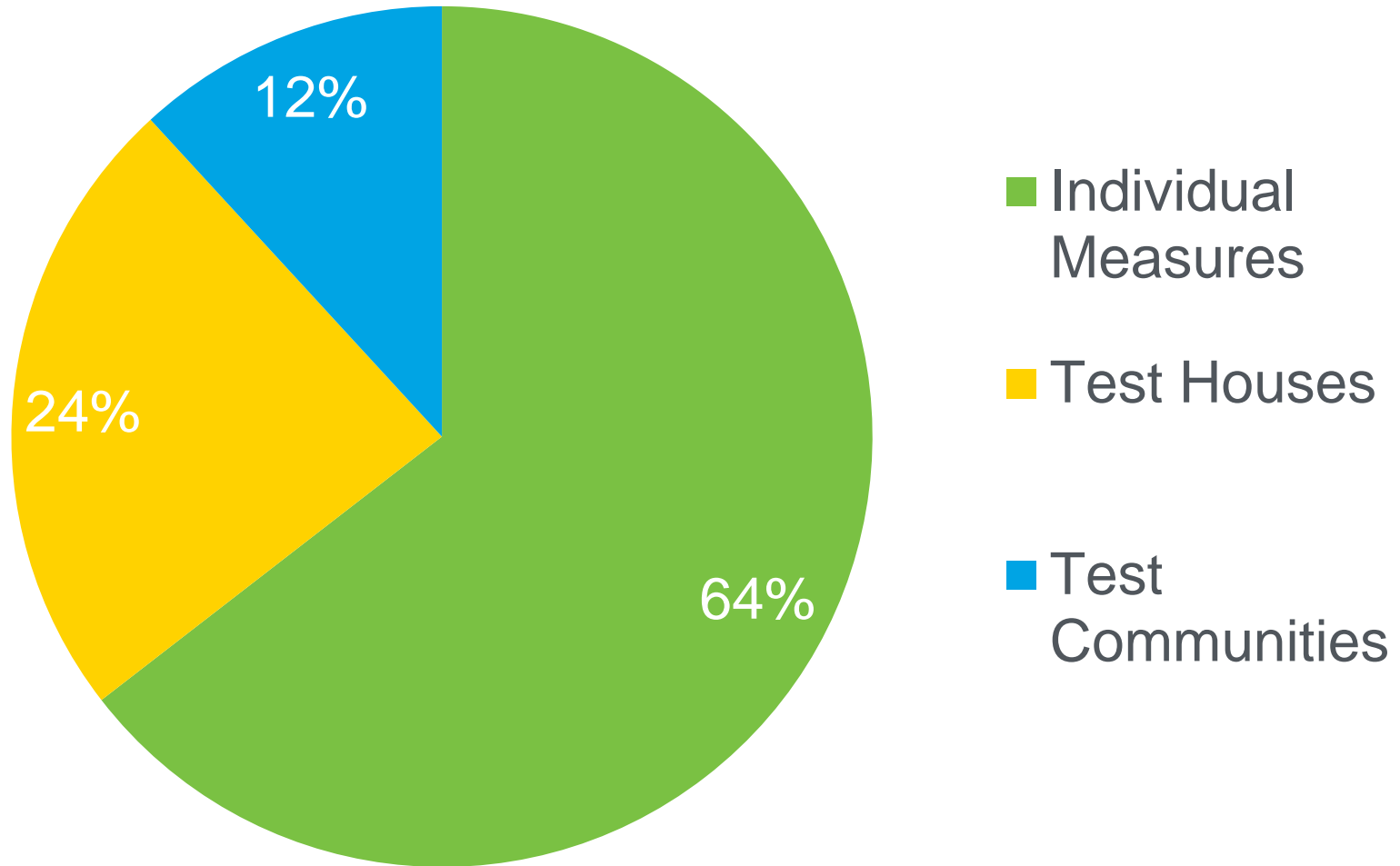


# 2012 Projects by Building Type

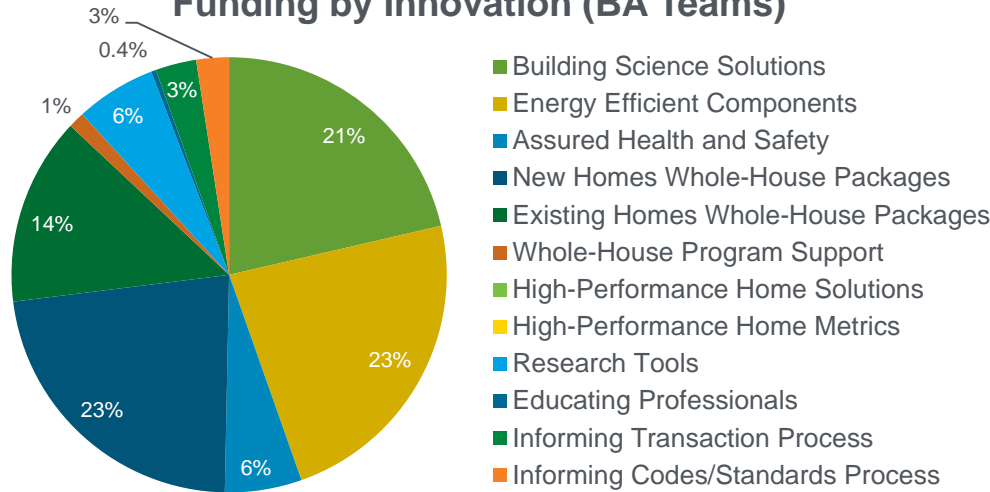




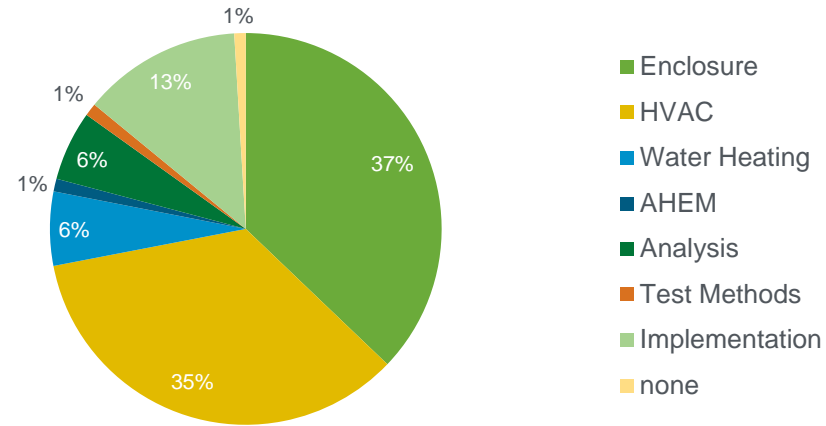
# 2012 Projects by Scale



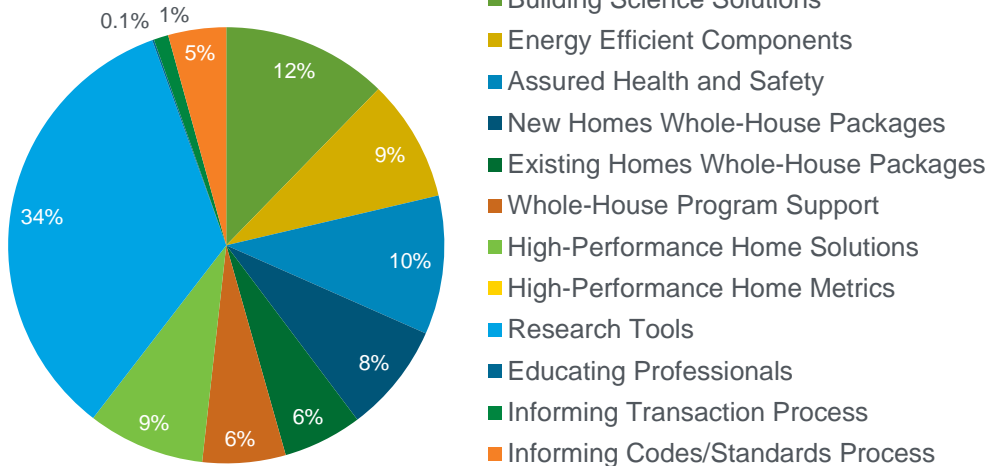
### Funding by Innovation (BA Teams)



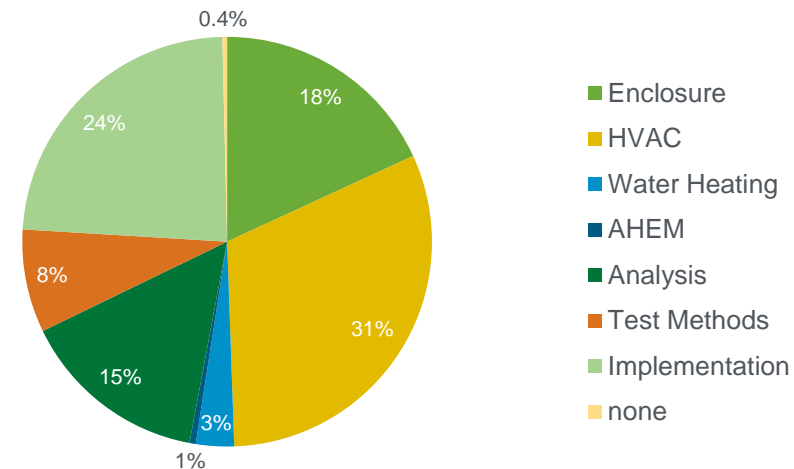
### Funding by STC (BA Teams)



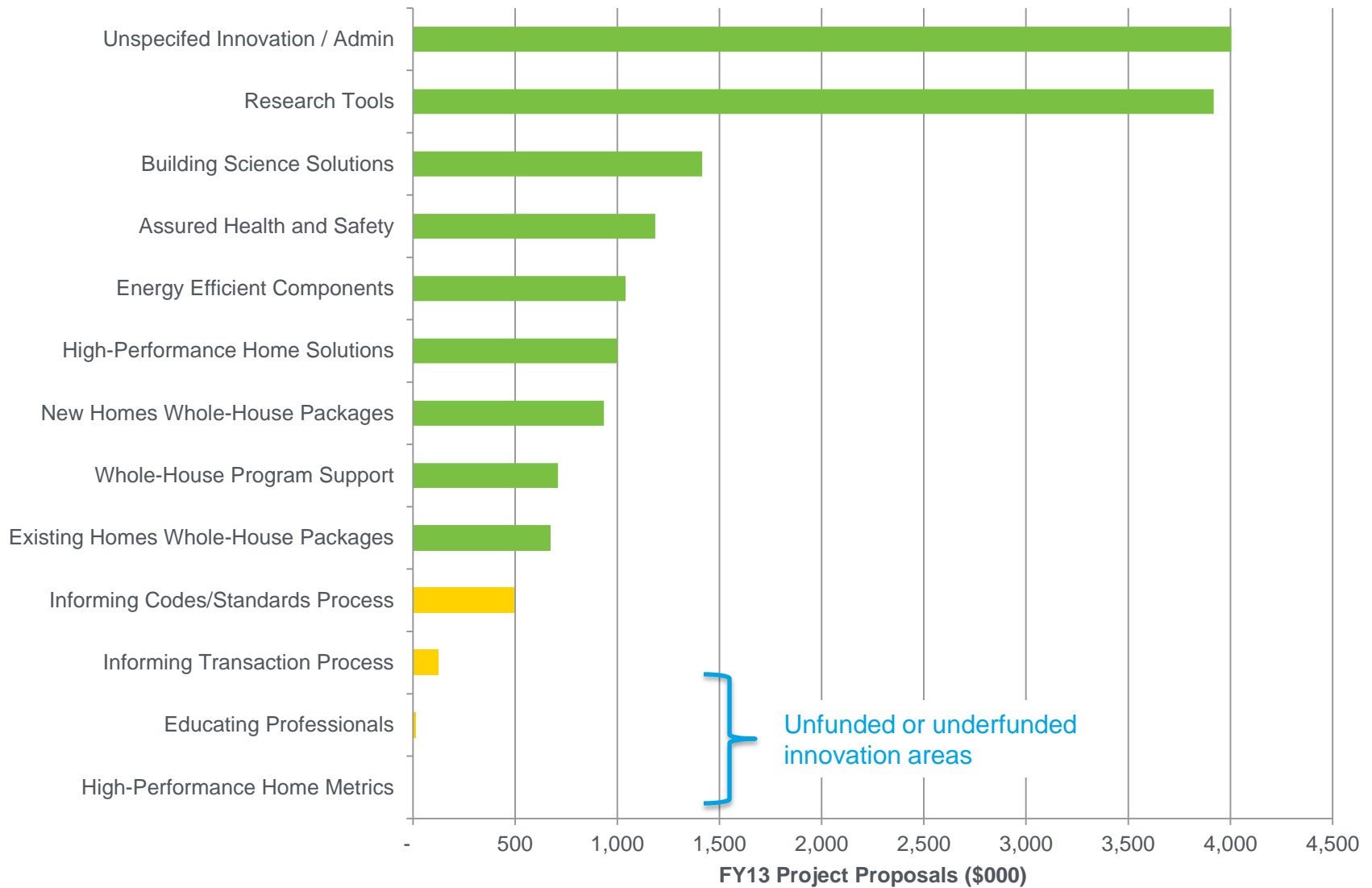
### Funding by Innovation (Lab & BA Teams)



### Funding by STC (Labs & BA Teams)



# Targeted Innovation Gaps - 2013



# **Building America Advanced Retrofit Technology & Demonstration Projects**

- Side-by-Side Lab House Retrofit Performance Studies
- Cladding Attachment for Thick Exterior Insulating Sheathing (2)
- High-R Roof Retrofit Techniques
- Moisture Performance Field Testing of Retrofits
- Cold Climate Foundation Wall Insulation, including “Excavation-less”

- Pressure Regain Supply Outlets for Retrofits
- Advanced Combined Heating/Hot Water Systems (2 projects)
- Buried & Encapsulated Attic Duct Retrofits
- Hydronic Primary Loop Temperature Controller
- Side-by-Side Lab House Retrofit Performance Studies (21 SEER vs. 13 SEER)
- Cold Climate Roof Retrofit Applications

- Central HW System Control for MF
- Hydronic Heating Control Retrofits for MF (2)
- Optimized Air Distribution Retrofit Strategies for MF
- Mini-Split Applications for Retrofits for MF

- Ventilation System Effectiveness Study
- Space Conditioning Impacts of Retrofits Study
- Improved Combustion Safety Testing Procedures
- Low-Cost Radon Reduction in Retrofits/WAP



- Phased Deep Retrofit Process Development: 60 FL Homes (FSEC)
- Energy Use Analysis of DER Homes (BSC, LBNL, NREL)
- Measure Guidelines from Advanced Technology Projects (planned)
- Building America Solution Center content from BA Innovations (planned)

# Current BA Retrofit Projects:

## Community-Scale Advanced Retrofit Demos

- Marine Climate DER Process: CA (DEG)
- Public Housing Approach: NC (ARIES)
- Las Vegas, NV Retrofit Program (BARA)
- Lend Lease Community Scale Retrofit Process: 800 units in SC (IBACOS)
- Multifamily DER: 2 MA Apartment Demonstration Projects (SWA)
- Greenbelt, MD HPwES Advanced Retrofit Demonstration Project (NAHBRC)
- Community Scale Attic Retrofit Approach: 100 CA homes (DEG)

- Home Performance w/Energy Star: 13 Projects (BSC, FSEC, IBACOS, NAHBRC, PARR)
- Better Buildings Neighborhood Partnership grantees: 3 projects (FSEC)
- Better Buildings Challenge: 6 projects (IBACOS)
- Home Energy Score Pilots: 5 projects (DEG, FSEC, IBACOS)
- Weatherization Assistance Program: 3 projects (DEG, UMN)

# Thank You

Questions?

**For More Information:**  
just Google “Building America”