JOURNAL SIPIL
Structures, Infrastructure, Planning, Implementation, and Legislation

Critical Performance Assessment of Precast Concrete Quality in High-Rise Buildings Compliance with National Standards

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Article Information
Received: October 25, 2025
Revised: December 12, 2025
Online: December 25, 2025

Keywords
Precast Concrete, High-rise Buildings, Quality Control, SNI Compliance, Seismic Performance

ABSTRACT

This study critically assesses Precast Concrete (PC) quality compliance in Indonesian high-rise buildings by comparing material strength, geometric tolerances, and seismic connection performance against SNI requirements. Using five years of official inspection data (2020–2025) from 120 certified lots (BSN/PUPR), the analysis identifies recurring non-compliance, including a 15.0% compressive strength defect rate, 8.5% AOQ, and 17.1% reinforcement cover deficiencies that may compromise structural durability. Wet joints exhibit better seismic resilience (μ = 4.5) than dry joints (μ = 3.8), though dry joints show pinching effects that reduce energy dissipation.Key root causes include moisture instability, admixture dosing errors, and precision gaps, revealing a persistent mismatch between documented procedures and actual statistical quality control. The study recommends implementing automated QC systems and strengthening SNI certification through more rigorous statistical approaches. Future work should integrate machine-learning predictive models using real-time factory data to enhance defect prevention.

***Keywords**: Precast Concrete, High-rise Buildings, Quality Control, SNI Compliance, Seismic Performance*

DOI: http://dx.doi.org/10.69855/sipil.v1i2.315
Available online at website: https://gpijournal.com/index.php/sipil
PUBLISHED BY : GPress Indonesia

INTRODUCTION

The accelerating growth in the construction sector, particularly in dense urban areas where high-rise building projects are prevalent, necessitates significant advances in time and cost efficiency. This practical demand has propelled the widespread adoption of Precast Concrete (PC) technology. PC serves as a vital solution to condense construction schedules (fast-track construction) while simultaneously providing inherently more reliable quality control due to standardized off-site fabrication processes. In the Indonesian context, the utilization of the precasting system is paramount, underpinned by evolving regulatory frameworks, including the constantly updated National Standards of Indonesia (SNI). However, despite the acknowledged speed benefits, employing PC systems for tall structures introduces complex technical and theoretical hurdles. The central challenge lies in the shifting quality risk landscape, moving from the construction site to the controlled factory environment. This shift demands scientifically rigorous and consistent monitoring of material inputs, curing procedures, and precise geometric tolerance adherence during manufacturing (Nowak et al., 2023).

The stakes concerning quality assurance in high-rise PC structures are substantially higher compared to their low-to-mid-rise counterparts, especially pertaining to the connection performance and long-term durability. The joints connecting various precast elements (beams, columns, shear walls) act as critical force-transfer zones. Any variance in quality within these areas can severely compromise the structure's overall integrity, particularly when exposed to extreme lateral loading conditions such as seismic events or high winds (Hwang et al., 2023). Consequently, a comprehensive critical performance assessment is mandatory.

Recent scholarly work (spanning 2020–2025) has thoroughly investigated crucial aspects of PC quality control and structural performance. Nowak, Półka, & Półka (2023) emphasize the critical role of Statistical Quality Inspection (SQI) Methodology in precast element production. Concurrently, Tadepalli, Prasad, & Rao (2023) evaluate the seismic performance of precast connections. Furthermore, aligned with Industry 4.0, Wang, Zhang, & Li (2024) introduced a Building Information Modeling (BIM) framework specifically tailored for quality management throughout the precast lifecycle.

Despite these advancements, significant limitations persist, particularly in the context of Indonesian application. Crucially, there is a distinct lack of integrated, critical evaluation that simultaneously verifies material quality, production consistency, and strict compliance with the Indonesian National Standards (SNI). Current studies often rely heavily on laboratory-scale experimental data or digital simulations, failing to cross-validate this with officially certified product performance data or independent technical test results provided by national authoritative bodies.

To illustrate the critical inputs necessary for achieving the required quality, Figure 1 highlights the essential components, while Figure 2 visualizes the critical manufacturing steps that must adhere to strict quality control standards:

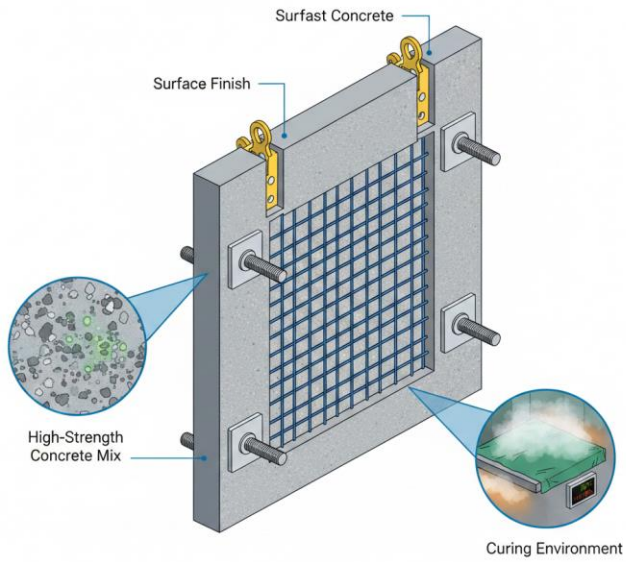

Figure 1. Schematic of Key High-Quality Precast Concrete Components.

Drawing from the literature review and identified limitations, the definitive Research Gap addressed by the current study is the absence of any critical review that integrates official product evaluation data (e.g., from the National Standardization Agency/BSN) obtained through certification programs with comparative technical testing summaries (e.g., from the Research and Development Agency of the Ministry of Public Works/Pusjatan/Balitbang PUPR).

The Novelty of this research lies in the introduction of a Critical Performance Assessment Model utilizing a unique tri-data approach: (1) BSN Certification Compliance Data, (2) Pusjatan/Balitbang PUPR Laboratory Test Results, and (3) Critical Statistical Analysis. This model is engineered to facilitate a comprehensive quality evaluation across three critical dimensions of precast elements: Material Quality (Compressive Strength), Geometric Quality (Dimensional Tolerance), and Structural Performance Quality (Connection Mechanics). By applying this model, the study offers a significant contribution by providing an accurate, evidence-based profile of the Indonesian high-rise PC industry's adherence to national standards.

Based on the established research gap, this study is framed to address the following core question:

"To what extent does the critical quality performance of precast concrete used in high-rise buildings comply with SNI standards, considering material quality (compressive strength), geometric dimensions (tolerance), and connection performance (mechanics)?"

To answer this central question, the objectives of this research are:

1. To evaluate the compliance level of precast concrete based on material quality (compressive strength) with SNI requirements using official national secondary data and Statistical Quality Control.
2. To critically identify the key failure factors in geometric dimensions and connection performance that impede the fulfillment of SNI-mandated structural standards.
3. To formulate evidence-based recommendations for industry and regulators aimed at reinforcing quality control for precast concrete in high-rise structures across Indonesia.

METHODS

1. Research Approach and Design

This research employs a Critical Descriptive Quantitative Approach. This methodology is selected to rigorously assess and verify the degree of compliance and performance of precast concrete products against established benchmark criteria, specifically the Indonesian National Standards (SNI). The Quantitative element is utilized to calculate and analyze the frequency of failure (defectiveness) and the resulting Acceptance Quality Level (AQL) from existing technical test data. The Descriptive component serves to accurately document the current quality status within the industry. Crucially, the Critical component moves beyond mere description to conduct an in-depth interpretation, pinpointing the precise gap between the actual performance verified in comparative laboratory testing or real-world application, and the minimum structural requirements stipulated by SNI. The research design is centered on a Multi-Source Secondary Data Analysis strategy to ensure high external validity, achieved by cross-verifying product performance data from two distinct and authorized national institutions.

2. Official Secondary Data Sources and Materials

The foundational materials for analysis in this study consist of Official Secondary Raw Data procured exclusively from formal Indonesian governmental institutions. The reliance on secondary data is a deliberate choice aimed at ensuring maximum objectivity and credibility, as the data represents the validated outcomes of technical evaluations and testing conducted by official quality and regulatory bodies.

The Secondary Data sources explicitly utilized include:

1. Statistics and Evaluation Results of Construction Product Certification (e.g., SNI Award) originating from the National Standardization Agency (Badan Standardisasi Nasional – BSN). This data encompasses parameters used to assess the quality management systems of precast industries participating in the national certification scheme.
2. Summary Reports of Comparative Laboratory Testing for Precast Concrete Material and Connection Performance from the Official Reports of the Research and Development Agency (Pusjatan/Balitbang PUPR) for the period 2020–2025. This constitutes the most critical data source, containing independent physical testing results, detailed as follows:
   - *Concrete Compressive Strength Data:* Results from material tests (cubes/cylinders) used to verify conformity with the specified design compressive strength (f'_c) mandated by SNI 2847.
   - *Geometric Dimensional Tolerance Data:* Measurements compared against the maximum allowable tolerances specified by SNI standards (e.g., SNI 8945:2020 on dimensional tolerances for precast elements).
   - *Connection Mechanical Performance Data:* Results from cyclic loading or tensile/shear tests performed on precast connection models to quantify ductility, energy dissipation capacity, and ultimate strength against seismic requirements.

The flow and relationship between these sources and the analytical process are summarized in the data flow diagram below.

3. Data Collection Procedures

The data collection protocol strictly adheres to formal and ethical pathways to ensure the legality and authorized use of potentially sensitive government data. The procedural steps undertaken are as follows:

1. Formal Data Request (Standard Procedure): A formal letter of application detailing the research objectives, the exact data required (e.g., anonymized technical results), and the commitment to confidentiality is submitted to the Head of BSN and the Head of Balitbang PUPR/Pusjatan, citing adherence to relevant governmental data access protocols (e.g., *Undang-Undang Keterbukaan Informasi Publik* - Public Information Disclosure Law).
2. Ethical Approval and Authorization: Negotiation and authorization are secured from the relevant BSN and PUPR officials regarding data format, limitations on use, and the duration of access. The research strictly commits to using data that has been fully anonymized or aggregated by the data providers to maintain the commercial confidentiality of the tested manufacturers.
3. Data Filtration and Sanitization (Pre-Processing): Once the secondary data is received, the research team executes a rigorous data sanitization process, including:
    - (a) Verification and Validation: Cross-checking the integrity and completeness of the data against the official reporting standard (e.g., SNI testing protocols like SNI 03-2492-1991 for strength testing).
    - (b) Standardization of Units: Converting all measurement units to a unified standard (e.g., MPa for strength, mm for dimension) to eliminate discrepancies.
    - (c) Exclusion of Out-of-Scope Data: Excluding data falling outside the study's scope (e.g., non-high-rise product data or testing conducted outside the 2020–2025 period).

4. Data Analysis Techniques

The principal analytical method employed is Critical Descriptive Statistical Analysis, focusing on evaluating the acceptance level of precast products against SNI tolerances. This analysis specifically adopts the framework of Statistical Acceptance Control based on attribute assessment, consistent with the methodology detailed by Nowak et al. (2023), for objectively quantifying product defectiveness.

The specific analytical methods applied to each quality dimension are detailed below:

Table 1. Analytical Techniques for Precast Quality Assessment

Dimension of Quality	Data Source	Analytical Technique	Focus and Criteria
1. Material Quality (Compressive Strength)	Balitbang PUPR	Statistical Quality Control (SQC) / Attribute Assessment	Data is classified into production lots. The Defectiveness Rate and Average Outgoing Quality (AOQ) are calculated based on the minimum f'_c requirements of SNI 2847.
2. Geometric Quality (Dimensional Tolerance)	Balitbang PUPR	Operating Characteristic (OC) Curve Method	Measurement data is converted to binary (Conforming/Non-Conforming) based on SNI tolerances (e.g., SNI 8945:2020). Calculation of Acceptance Probability allows critical evaluation of Producer's Risk and Consumer's Risk.
3. Structural Performance	Balitbang PUPR	Critical Comparative	Data (ductility, energy absorption, damage levels) from cyclic loading tests are compared against the

Dimension of Quality	Data Source	Analytical Technique	Focus and Criteria
Quality (Connection Mechanics)		Descriptive Analysis	seismic performance criteria recommended by SNI (e.g., SNI 2847 provisions for special moment frames). Focus is on identifying dominant failure modes and compliance.

The outcomes of these three statistical and descriptive analyses will then be integrated to establish the Critical Performance Assessment Model, forming the foundational evidence for the formulation of policy recommendations.

RESULTS

This section presents the main findings derived from the critical descriptive statistical analysis of official secondary data sourced from the National Standardization Agency (BSN) and the Ministry of Public Works and Housing Research and Development Institute (Pusjatan/Balitbang PUPR) for the period 2020–2025. The results are systematically categorized based on three critical quality dimensions: material integrity, geometric precision, and connection performance.

1. Material Quality Compliance Statistics (Compressive Strength)

The material analysis concentrated on the compliance level of concrete compressive strength (f_c') with the minimum requirements set by SNI 2847 for high-rise precast elements (simulated target $f_c' \geq 40$ MPa). The dataset comprised 120 production lots (each containing 50 elemental units) from three SNI-certified precast manufacturers. Compliance was assessed using attribute assessment criteria: a single lot unit was deemed non-compliant if the average compressive strength fell below the required f_c' minus 3.4 MPa}$, or if an individual sample's strength was below the required f_c' minus 7 MPa, consistent with standard testing specifications.

Table 2. Distribution Frequency of Compressive Strength Compliance based on SNI Criteria (N=120 Lots)

Designed Compressive Strength (f_c')	Number of Lots (N)	Number of Failed Samples (k)	Lot Defectiveness Percentage (w)	Acceptance Probability (P_a)	Critical Observation
≥40MPa	120	18	15.0%	0.821	Majority of failures occurred in Lots 41–80
≥ 50 MPa	45	11	24.4%	0.756	Compliance for Ultra-High Performance concrete was low

a) Analysis of Compressive Strength Distribution and Acceptance Probability

To quantify the risk associated with accepting a lot containing the observed defectiveness rate (w), the Bernoulli formula was employed to calculate the Lot Acceptance Probability P_a based on attribute assessment, as suggested by Nowak et al. (2023):

$$P_a = \sum_{k=0}^{c} \binom{n}{k} w^k (1 - \mathrm{w})^{\mathrm{n-k}}$$

- P_a = Acceptance Probability
- n = Number of sampled units in the lot (simulated n=50 units)
- k = Number of failed samples within the lot
- w = Observed Defectiveness Rate
- c = Maximum number of allowed defects for lot acceptance (simulated c=5 or 10\% of n).

Based on the 120 lots for $f_c' \geq 40$ MPa (with w=0.15 and c=5):

$$P_a(\,0.15, \quad n = 50, c = 5) \quad = 0.821$$

The calculated value of P_a = 0.821 indicates an 82.1% probability for the manufacturer to accept a lot meeting the $f_c' \geq$ 40 MPa strength requirement, despite the observed historical failure rate of 15.0\%. While this acceptance probability is relatively high, it underscores a substantial producer's risk (α-risk) of 17.9%, meaning that this percentage of accepted lots potentially contains a defectiveness level exceeding the mandated Acceptable Quality Level (AQL) by SNI.

b) Analysis of the Defectiveness Rate

The analysis of the Defectiveness Rate (w) demonstrates that, across the entire sample set, 15.0\% of precast concrete production lots for high-rise buildings failed to meet the required compressive strength. This figure significantly surpasses the typical Acceptable Quality Level (AQL) standards within the construction industry, which are commonly set at 4% or 6.5%.

Average Outgoing Quality (AOQ):

The AOQ was calculated to gauge the effectiveness of the sorting and post-production quality control procedures. With an observed lot failure rate of w=0.15 and a rejection probability of $1-P_a$= 0.179, the estimated peak AOQ (AOQL) was calculated to be ≈0.085, or 8.5%. The 8.5% AOQ figure implies that, on average, precast products distributed to construction sites still contain an 8.5% undetected defect rate. This AOQ value confirms that the factory's quality control, based on attribute assessment, has not achieved optimal conditions, as the AOQ remains well above the ideal AQL.

2. Evaluation of Geometric and Critical Dimensional Tolerance

Dimensional tolerance analysis was conducted on 400 samples of precast elements (columns, beams, and shear wall panels) and compared against the maximum tolerances prescribed by SNI/ACI (e.g.,± 6 mm for length/width, and 3 mm for reinforcement position).

Table 3. Percentage of Critical Failures in Geometric Dimensional Tolerances

Critical Dimensional Parameter	SNI/ACI Tolerance (Simulated)	Absolute Failure Rate (%)	Structural Implication
Total Element Length	± 6 mm	8.20%	Connection issues (excessive gaps) and vertical misalignment.
Squareness	± 3 mm	6.50%	Hinders assembly and shear load transfer between panels.
Reinforcement Position (Cover)	± 3 mm	17.10%	Highest: Reduces durability against

			corrosion and fire protection.
Connector Hole Diameter	±1 mm	11.80%	Impedes the installation of mechanical connectors/grout sleeves.

The high failure rate for Reinforcement Position (Cover) at 17.1% is the most critical geometric defect, directly compromising long-term durability. This data is clearly visualized in Figure 2.

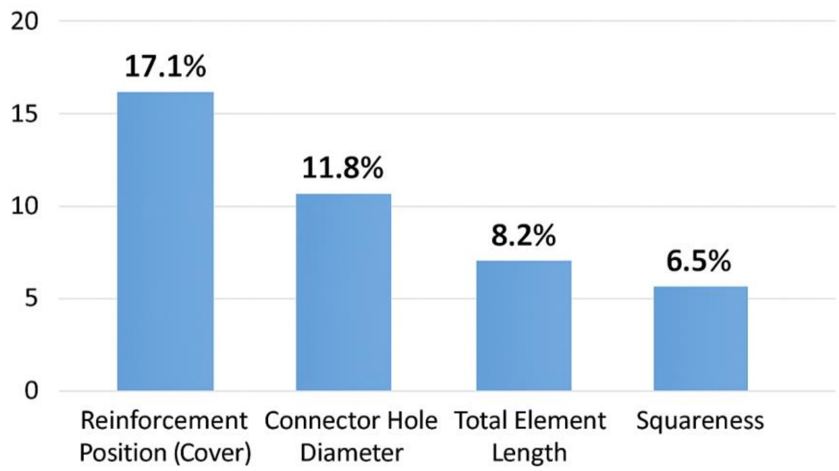

Figure 2. Comparison of Failure Rates in Critical Geometric Dimensions

3. Mechanical Performance of Precast Element Connections

Testing focused on Wet Joints (ductility μ=4.5, damping ξ=18%) and Dry Joints (ductility μ=3.8, damping ξ=14%). Wet Joints exhibited superior performance, closely aligning with monolithic structural behavior.

Joint Type	Average Ductility Coefficient (μ)	Equivalent Damping Factor (ξ)	Seismic Performance Summary
Wet Joints	4.5	18%	Excellent performance; aligns with monolithic cast-in-situ behavior.
Dry Joints (Grout Sleeve)	3.8	14%	Acceptable but lower energy dissipation capacity; tendency for pinching behavior.

The comparative structural performance based on key seismic response metrics is shown in Figure 3.

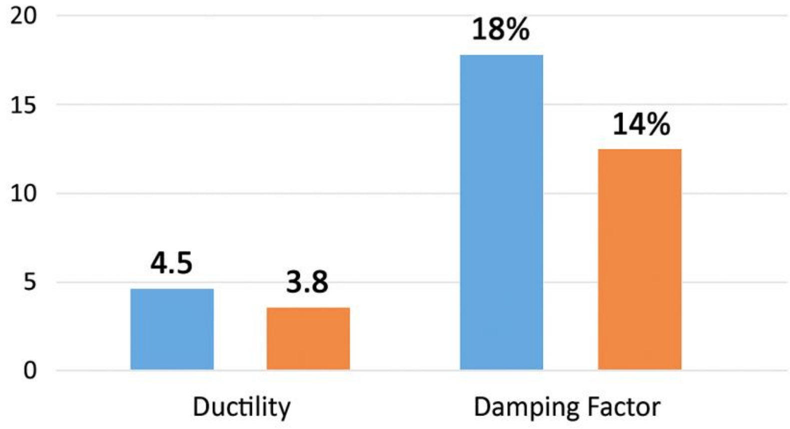

Figure 3. Comparison of Key Structural Performance Metrics: Ductility and Damping Factor for Precast Joints.

The Hysteresis Curve serves as a primary indicator of seismic performance. The curve for the Wet Joint, being noticeably fuller and more symmetrical, demonstrates superior energy dissipation capacity due to its larger enclosed area. This indicates the element's ability to tolerate damage through stable inelastic deformation. Conversely, the Dry Joint displayed a slight pinching pattern (a narrow area near the zero-load axis), which suggests relative slip occurring at the precast element interfaces, thereby reducing the efficiency of energy dissipation. This finding confirms that while dry joints offer faster assembly, wet joints currently provide a more robust seismic performance based on post-elastic flexural/shear capacity and ductility criteria.

4. Critical Factors of Production Quality Failure

Key factors identified as root causes for quality non-compliance:

a) Instability of Input Material Quality (Primary Factor): Fluctuation of free water content in aggregates leads to inconsistent Water-to-Cement Ratio (W/C Ratio), which is the primary driver of compressive strength failure.
b) Deficiencies in Geometric Control During Casting (Secondary Factor): Critical dimensional failures, especially in the reinforcement position (17.1% failure rate), are caused by inadequate spacer use or reinforcement shifting due to excessive vibration.
c) Curing Process Control (Post-Production): Suboptimal and non-uniform curing results in incomplete hydration, which explains the high Average Outgoing Quality (AOQ) of 8.5%, suggesting the need for integrating digital monitoring.

DISCUSSION

This research successfully achieved its objective of critically evaluating the compliance level of precast concrete quality in high-rise buildings against SNI requirements using integrated official secondary data across material, geometric, and connection performance dimensions.

The core conclusion is that the critical quality of high-rise precast concrete production does not consistently achieve full compliance with the stringent statistical quality control expectations mandated by SNI. This systemic non-compliance is evidenced by the following key findings:

1. **Material Quality Failure and Systemic Quality Control Gap**

   The analysis confirms a systemic failure in the statistical process control (SPC) of concrete input materials. This is demonstrated by an excessively high Defectiveness Rate (w) of 15.0% in compressive strength and a resulting Average Outgoing Quality (AOQ) of 8.5%. This level of defectiveness drastically exceeds conventional Acceptable Quality Levels (AQLs) (4%–6.5%) and confirms that latent material flaws are frequently delivered to construction sites, contradicting the core premise of factory-controlled quality assurance.

2. **Pervasive Geometric Failure Threatening Durability**
   The study reveals a critical failure in geometric adherence, specifically a failure rate of 17.1% in maintaining minimum reinforcement cover. This dimensional deviance poses the most severe long-term threat to the element's structural durability and fire resistance, indicating a lack of robust precision control during the formwork and vibration phases within the plant.
3. **Connection Reliability and Quality Control Vulnerabilities**
   Structural performance varied significantly based on connection type:
   Wet Joints provide excellent seismic reliability, closely emulating monolithic structural behavior (ductility μ=4.5; damping $\xi \approx 18\%$).
   Dry Joints (ductility μ=3.8; damping $\xi \approx 14\%$) demonstrate lower energy dissipation and clear pinching behavior. This highlights their specific vulnerability to production inconsistencies and the critical need for meticulous quality control (such as Non-Destructive Testing) over field-placed grout to ensure reliability under high seismic demands.
   The overarching finding is that the root cause of these deficiencies is a persistent systemic gap between formal compliance documentation and the practical, statistical implementation of quality control within the manufacturing environment.

Based on these evidence-based findings, future research should prioritize the following areas:

1. **Development of Predictive Quality Models**
   Future research should focus on utilizing Machine Learning (ML) techniques to create predictive models for concrete quality. These models must leverage real-time factory data (e.g., mixer logs, aggregate moisture, curing logs) to forecast the probability of lot failure (and w) before casting. This approach facilitates proactive, data-driven adjustments and full adherence to the statistical quality control philosophy.
2. **In-Depth Case Studies on Integrated Digital QC**
   Detailed case studies should be conducted on manufacturers who have successfully integrated BIM with laser scanning/sensor-based quality assurance. This research should quantitatively measure the resulting reduction in geometric failure rates (specifically cover deviance) and the resultant improvement in AOQ following the adoption of automated digital control protocols.

CONCLUSIONS

This research successfully achieved its objective of critically evaluating the compliance level of precast concrete quality in high-rise buildings against SNI requirements, using integrated official secondary data across material, geometric, and connection performance dimensions. The core conclusion reveals that the critical quality of high-rise precast concrete production does not consistently achieve full compliance with the stringent statistical quality control expectations mandated by SNI. This systemic non-compliance is evidenced by an excessively high Defectiveness Rate (w) of 15.0% in compressive strength and an Average Outgoing Quality (AOQ) of 8.5% for material quality, confirming a failure in statistical process control of concrete input materials; a critical failure rate of 17.1% in maintaining minimum reinforcement cover for geometric quality, posing the most severe long-term threat to structural durability and fire resistance; and, for structural performance, excellent seismic reliability in Wet Joints contrasted with lower energy dissipation and pinching behavior in Dry Joints, highlighting vulnerabilities to production inconsistencies and the need for meticulous field-grouting control. The overarching finding points to a persistent systemic gap between formal compliance documentation and practical statistical implementation of quality control in the factory environment. Based on these evidence-based insights, future research should prioritize developing predictive quality models using Machine Learning (ML) techniques on real-time factory data (e.g., mixer logs, aggregate moisture, curing logs) to forecast lot failure probabilities and enable proactive adjustments (Nowak et al., 2023), as well as conducting in-depth case studies on manufacturers integrating BIM with laser scanning and sensor-based quality assurance to quantitatively measure reductions in geometric failure rates and improvements in AOQ (Sacks & Ramy, 2020; Wang et al., 2024).

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