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Los Alamos National Laboratory and Lawrence Livermore National  
Laboratory

Plutonium Sustainment Monthly Program Report

September 2012

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## Executive Summary

In September of 2012 the Plutonium Sustainment program at LANL completed or addressed the following high-level activities:

- 1) Completed assembly, inspection, packing, and approvals for Pollux. Completed shipment to DAF in early October in accordance with the Gemini Core Team's schedule.
- 2) Delivered the draft Program Implementation Plan and revised repeatedly.
- 3) Met with Kansas City Plant staff to "kick-off" the non-nuclear pit-component production mission.

All MRT L2 Milestones 4195-4198 or the relevant PBIs associated with Plutonium Sustainment have been met and evidence packages submitted.

The year-end budget/performance indices were 0.96 (S.P.I.) and 1.00 (C.P.I.). Table 1 identifies all Baseline Change Requests (BCRs) that were initiated, in process, or completed during the month.

The earned value metrics overall for LANL are within acceptable thresholds, so no high-level recovery plan is required. Note that the planned (budget) and earned value for September includes planned carryover holdbacks (no allocation) with no associated FY12 costs. This has a minor (positive) impact on S.P.I. and a significant (positive) impact on the C.P.I. (see Earned Value Metrics below). For Pu Sustainment overall, the C.P.I. in September neglecting the \$10.75M holdback is 0.90. Likewise, the C.P.I. for FY12 is 1.004. With the facility infrastructure element removed, the C.P.I. in September becomes 0.92. Likewise, the C.P.I. for FY12 is 0.992.

Again neglecting the holdback, the S.P.I. numbers for Pu Sustainment overall are 0.94 (Sept) and 0.96 (FY12) and with the facility infrastructure element removed 0.95 (Sept) and 0.95 (FY12)

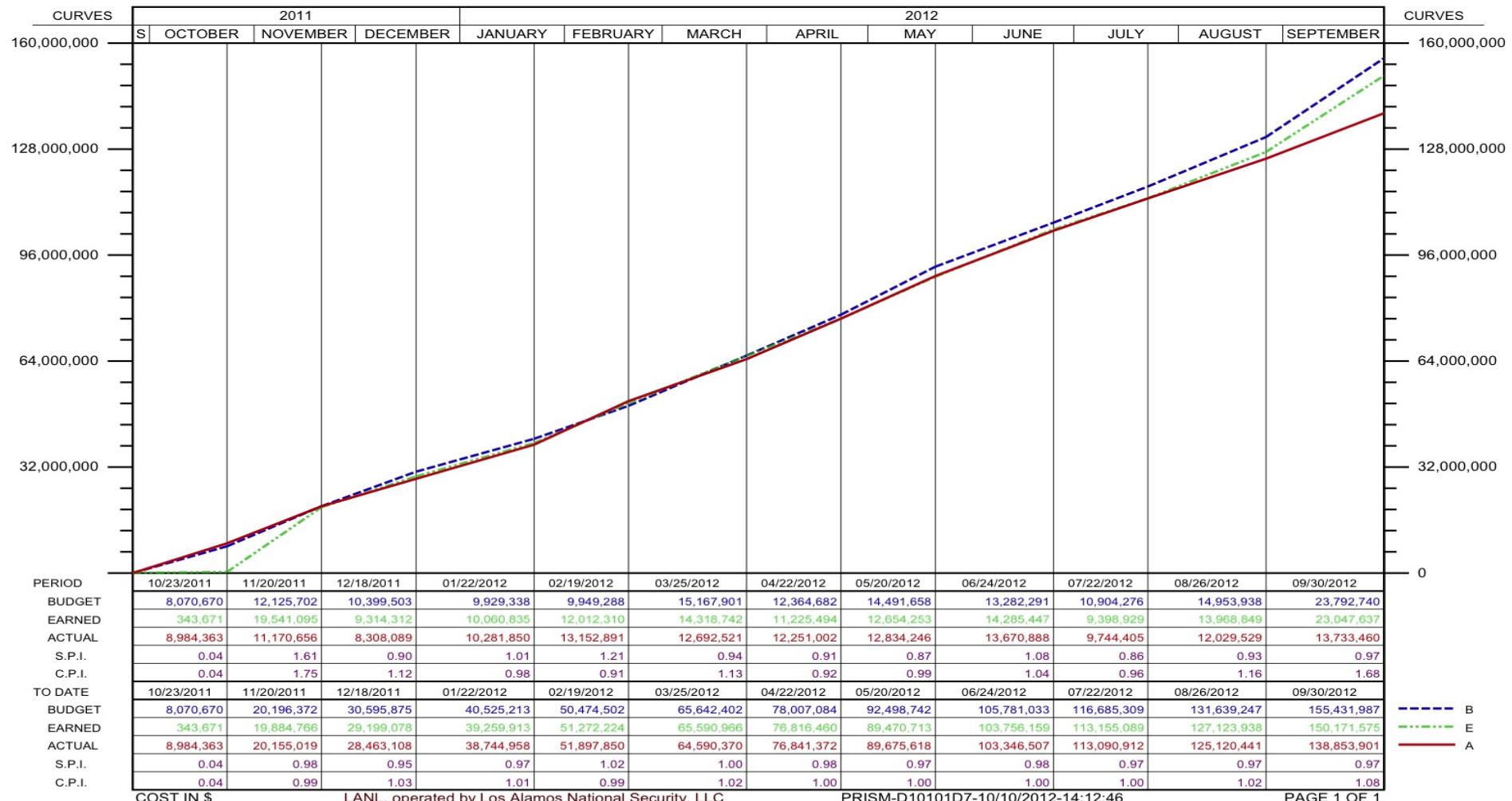
Each of the 5 major LANL WBS elements is discussed in detail below with a section at the end that is provided by LLNL.

**Table 1: September Baseline Change Requests**

WBS	BCR #	BCR Description	Date Assigned	Date Approved	Impact	Cost Impact	Change Level
Power Supply	PSM-12-056	Additional Asphalt & Rooftop Chillers	9/17/12	9/19/12	Cost/Scope	\$83k	3
Power Supply	PSM-12-057	Punch list Items and CD-4 Approval	9/17/12	9/21/12	Cost/Scope	\$96k	3
Power Supply	PSM-12-058	Conduct MSA	9/17/12	Working	Cost/Scope	\$94k	
Power Supply	PSM-12-059	Purchase of Argon Tank and A/C Units	9/17/12	9/21/12	Cost/Scope	\$87k	3

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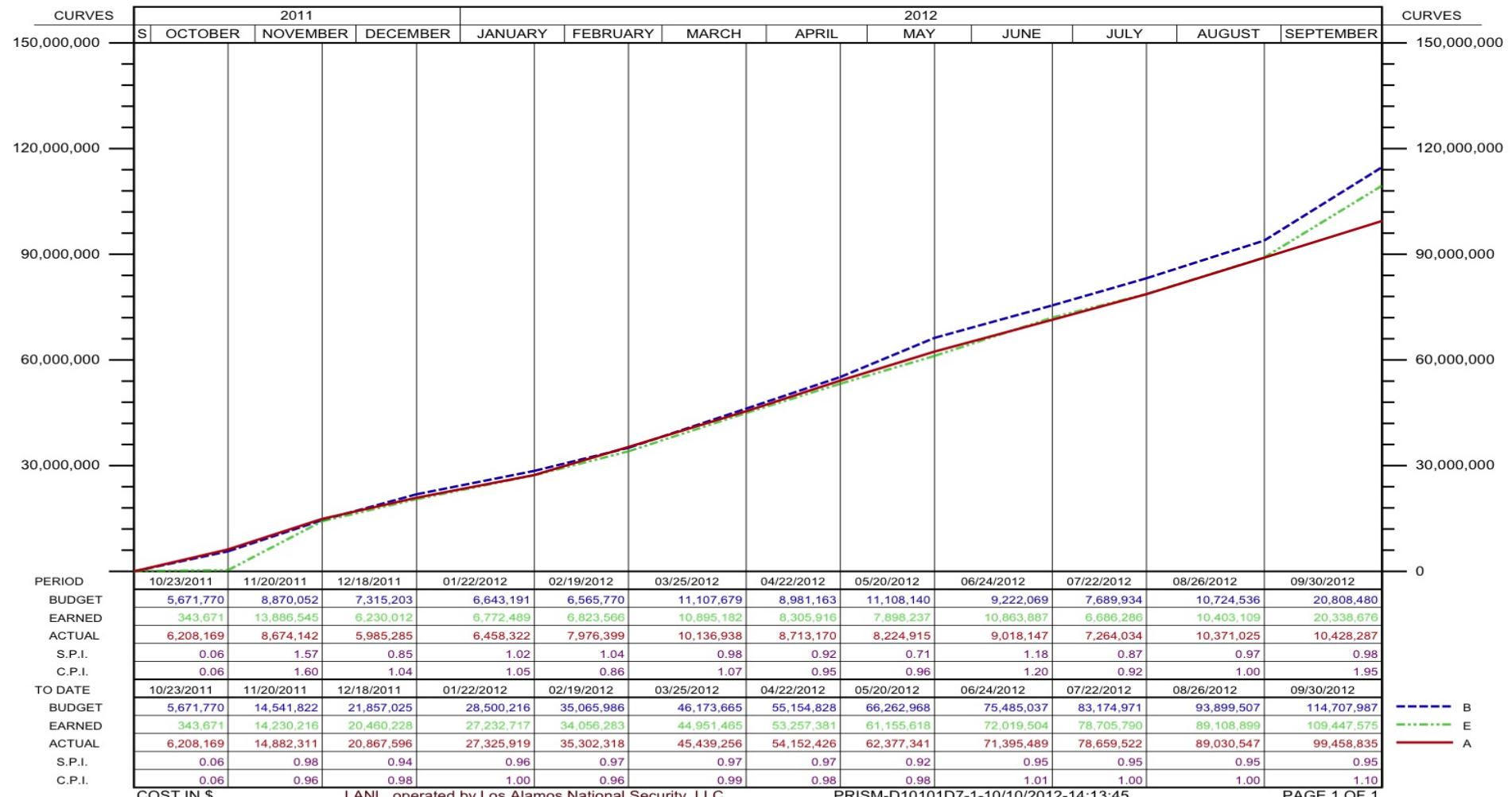
## Earned Value Metrics

PERFORMANCE S-CURVE  
Pu Sustainment

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# PERFORMANCE S-CURVE

## Pu Sustainment W/O Facility Infrastructure



## 1.0 LANL - Pit Development

MRT 4196	BLUE	Perform Activities to Sustain Base Pit Material Processing and Fabrication Capability		
L3 Milestone	Baseline Date	Status/Comments	Completion Date	RGYB
Non-nuclear components necessary for an EDU build are available for use.	July 13, 2012		June 13, 2012	BLUE
Suitable nuclear material is available as ER	September 21, 2012		May 14, 2012	BLUE
Laser Welding documentation approved <ul style="list-style-type: none"> <li>• Technical Specifications &amp; Requirements</li> <li>• Functional &amp; Operations Requirements</li> <li>• Cold System Test Plan</li> </ul>	September 21, 2012	TS&R Approved by PMB/WB F&OR Approved by PMB/WB Cold System Test Plan Approved by PMB/WB	June 27, 2012 June 27, 2012 August 23, 2012	BLUE
Electron Beam Welder Corrective Maintenance Complete	June 29, 2012	Corrective Maintenance completed. Weld performed	June 28, 2012	BLUE
Preparation Unit Installed	August 14, 2012	Post installation operation demonstrated on part	June 26, 2012	BLUE
Production Strategy and TRL/MRL assessment	September 30, 2012		September 4, 2012	BLUE

### 1.1 Technical Progress

- Completed casting of the forth and fifth W87 hemi shells.
- Completed waste banding on the five W87 castings.
- Machined the fourth W87 inner and outer contour on T-Base 2.
- Completed the W87 MC4597 Pit Production Strategy and Product Development Plan (LA-CP-12-01100 - September 4, 2012).
- Completed all critical-path procedures for an EDU build.
- Received all critical-path tooling from KCP.
- All FY12 milestones completed.
- Evidence package for MRT4196 submitted.

## 1.2 Equipment

- Laser Welder
  - All FY12 milestones completed.
  - Last FY12 milestone completed August 23, 2012.
  - Evidence package for MRT4196 submitted.
- Electron Beam Welder
  - All project milestones completed.
  - Last project milestone completed June 28, 2012.
  - Evidence package for MRT4196 submitted.
- Surface Preparation
  - All project milestones completed.
  - Last project milestone completed June 26, 2012.
  - Evidence package for MRT4196 submitted.

## 1.3 Issues

- None

## 1.4 Variance Analysis and Recovery Plan

- None

## 1.5 BCRs

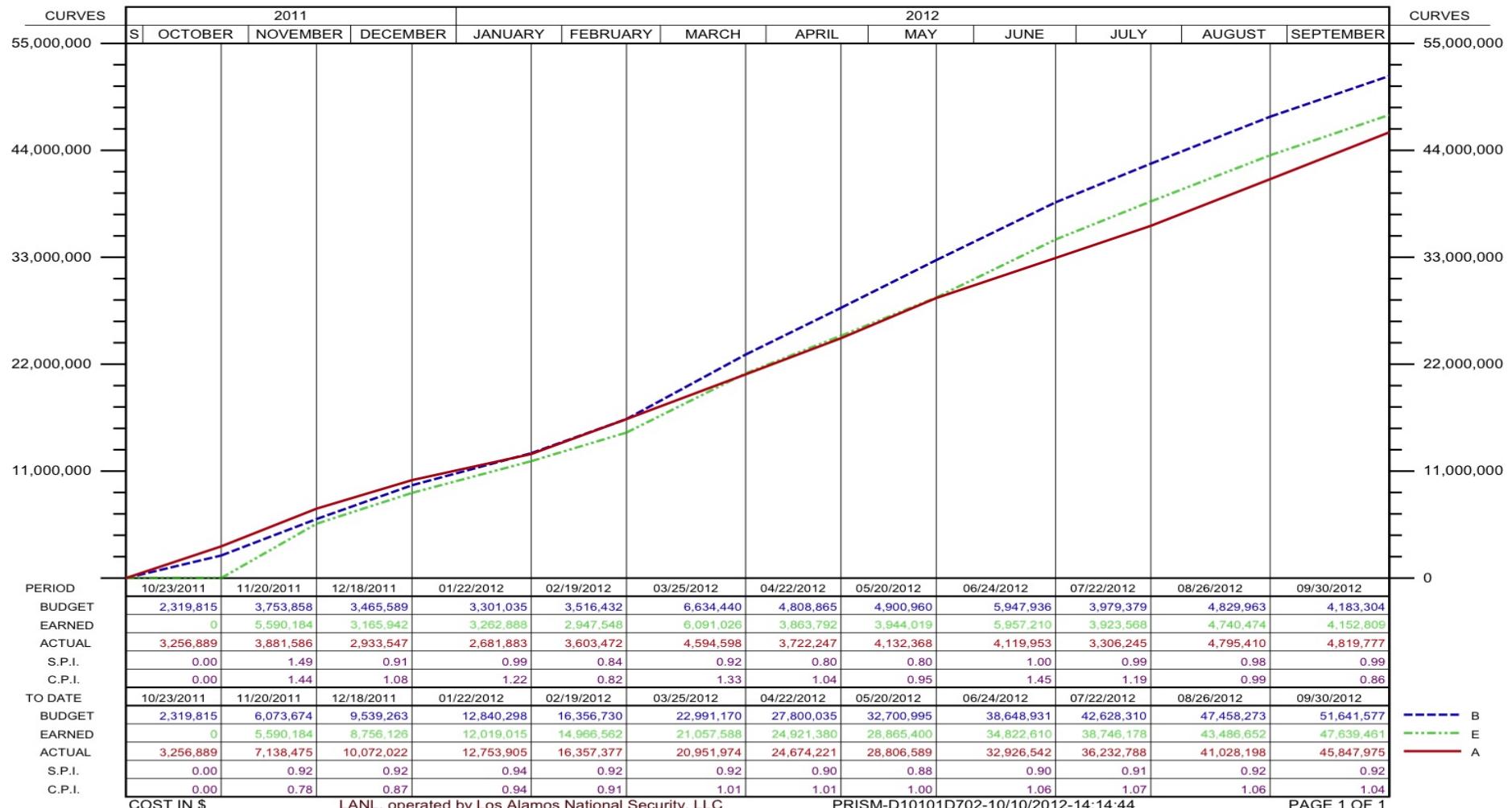
- None

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## 1.6 Earned Value Metrics

## PERFORMANCE S-CURVE

Pit Manufacturing



## 2.0 LANL – Experimental Component

4198	BLUE	<i>Perform activities to sustain base pit material processing and fabrication capability through Experimental Component Fabrication</i>		
1. Experimental Component Fabrication and Shipment of Gemini/Pollux in accordance with PEP but no later than October 31, 2012 (revised date from Sept 30, 2012)				
L3 Milestone	Baseline Date	Status/Comments	Completion Date	RGYB
Start Cold Machining	January 10, 2012		Nov 18, 2011	BLUE
Start Hot Machining	February 21, 2012		March 23, 2012	BLUE
Casting Complete	February 27, 2012		February 27, 2012	BLUE
Complete Castor Sub-Assembly	May 3, 2012		May 31, 2012	BLUE
Start Hot Development Assembly	May 7, 2012	First assembly chosen as a shipping fixture test in lieu of hot assembly.	May 14, 2012	BLUE
Complete Machining Lot 1 – DEV	June 14, 2012	MET-2 has elected not to perform a hot DEV build		BLACK
Complete Machining Lot 2 – Pollux	August 1, 2012		August 13, 2012	BLUE
Start Pollux Assembly	August 13, 2012		September 4, 2012	BLUE
Pollux Complete	September 6, 2012		October 9, 2012	BLUE

### 2.1 Technical Progress

- Completed Pollux assembly and inspection.
- Completed final DA acceptance of assembly.
- Plan to ship Pollux from LANL TA-55 and receive it at NNSS DAF in October.

### 2.2 Equipment

- none

### 2.3 Issues

- none

### 2.4 Variance Analysis and Recovery Plan

- SPI – Project complete – 3% variance due to dropped risk mitigation scope.
- CPI – Final negative variance of 16%. The cost variance is largely due to several factors
  - New hardware capabilities and upgrades
    - Quindos 7 CMM upgrade – required to provide greater precision
    - LUNA optical fiber analysis system – for post assembly surface inspection
    - On-machine gauging probes for the Precitech precision lathes – allowed compensated cutting to correct for tool wear, etc.
  - Troubleshooting and development of these new capabilities
    - Troubleshooting/training for Quindos 7
    - Difficult tie-in with classified LAN system for LUNA system
    - Extensive “in-house” software development for on-machine gauging

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- Overtime due to late Gemini project integration milestones
  - The Gemini/Pollux design was not finalized until mid-second quarter – several months later than scheduled
  - The non-nuclear parts and assembly fixtures were 3-8 weeks late causing a delay in the Pollux build schedule and no opportunity for a second build attempt to recover should the first build attempt fail without a significant schedule slip.
  - No non-nuclear parts and assembly fixtures were provided for a developmental build as a risk mitigation.
- Aggressive budget allocations assuming a success oriented planning basis
  - No additional budget was provided for unanticipated scope (see bullets 1 and 2 above)
  - No additional budget was provided to cover overtime (see bullet 3 above)
  - No additional budget was provided to cover VSP impact
- The final Pu Sustainment cost for Pollux was \$12M in FY11/12. This is significantly less than the original estimate of \$21M and the start of the project.

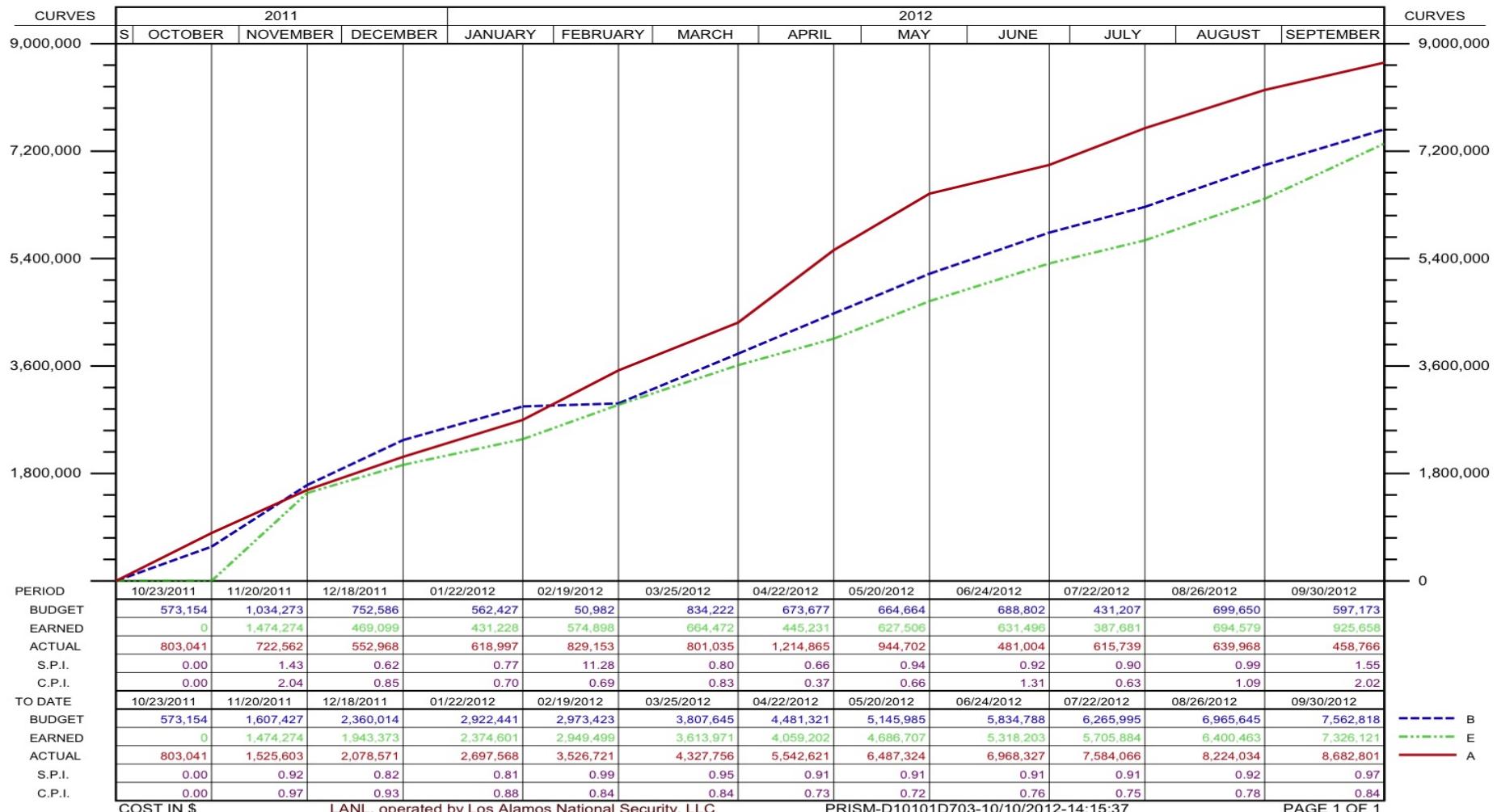
**2.5 BCRs**

- None

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## 2.6 Earned Value Metrics

### PERFORMANCE S-CURVE Experimental Component Manufacturing



### 3.0 LANL - Power Supply

<b>4195</b>	<b>BLUE</b>	<i>Install the Power Supply Assembly Area Equipment and Upgrades per the FY2012 Power Supply PEP</i>
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1. Begin construction on the PSAA by March 31, 2012.
2. Start installation of the Analytical Chemistry GBs by June 30, 2012.
3. Start installation of the low voltage E-Beam Welder by June 30, 2012.

<b>L3 Milestone</b>	<b>Baseline Date</b>	<b>Status/Comments</b>	<b>Completion Date</b>	<b>RGYB</b>
Start Construction – Capital (PSAA)	December 15, 2011		Dec 7, 2011	BLUE
Start Construction – Facility (PSAA)	December 15, 2011		Dec 7, 2011	BLUE
GB-1240 - Construction Field Start (Pu Assay)	March 1, 2012		May 7, 2012	BLUE
GB-1241 - Construction Field Start (Radiochemistry)	March 9, 2012		May 7, 2012	BLUE
Mobilize and Field Start (LVEBW)	June 14, 2012		April 30, 2012	BLUE

<b>4197</b>	<b>BLUE</b>	<i>Complete FY 2012 Power Supply material recovery activities IAW the Plutonium Sustainment PEP</i>		
1. Dismantle lesser of 480 units or 95% of the Pantex items received by June 30, 2012				
2. Recover and store the oxide by Sept 30, 2012				
<b>L3 Milestone</b>	<b>Baseline Date</b>	<b>Status/Comments</b>	<b>Completion Date</b>	<b>RGYB</b>
Material Recovery Complete Shipment #1	October 18, 2011		Oct 18, 2012	BLUE
Material Recovery Complete Shipment #2	January 4, 2012		Dec 22, 2011	BLUE
Material Recovery Complete Shipment #3	March 8, 2012		Feb 15, 2012	BLUE
Material Recovery Complete Shipment #4	April 25, 2012		Mar 15, 2012	BLUE
Material Recovery Complete Shipment #5	June 27, 2012		June 21, 2012	BLUE

#### 3.1 Technical Progress

- Material Recovery
  - Received FY 13 Shipment #1 and #2 (received in July and August, respectively).
    - All units from both shipments are dismantled.
    - Completed fuel recovery and storage of Shipment #1 (1 of 5 FSOs failed radiography – weld to be redone)
    - Completed recovery of Shipment #2 with fuel stored in FSIs ready for FSOs.
- RTG Process Development
  - Welding platforms are being established in SM39 to continue the development of the liner (GTA), strength member (LVEB), and clad (LVEB) welds.
  - Power to all the platforms has been established.

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- Significant work has occurred to develop constitutive equations for the Haynes-25 material. The methods for dealing with the complex metals have now been established and the ability to provide direct input to the SNL impact models has been established.
- RTG assembly fixturing has been designed and incorporated into the 6kW laser workstations. It has been tested at the vendor site and meets the design criteria.

### **3.2 Equipment**

- Power Supply Assembly Area (PSAA)
  - Construction continues and is on track.
  - Continued finishing of gypsum wallboard.
  - Continued installation of new sheetrock walls;
  - Placed concrete in exterior equipment pad.
  - Placed concrete for vibration blower pad.
  - Completed rebar installation and placed concrete for the transformer pad.
  - Completed concrete placement of curb and gutter.
  - Started installation of jib crane.
  - Started installation of process chilled water piping.
  - Started installation of electrical raceways for Red Net and fire alarm.
  - Moved new AC unit into the elevator equipment room.
  - Completed installation of new primary electrical conductors and energized new PSAA transformer on Sat Oct 6, 2012.
  - Drafted and signed BCP 008: Incorporate Burden Adjustments Required by the Institutional Voluntary Separation Plan.
- The Low Voltage Electron Beam (LVEB) Welder
  - Continued installation (vendor at LANL to work with LANL SMEs).
- Analytical Chemistry glove boxes (Pu Assay and Radiochemistry)
  - Moved glove boxes into PF-4.
- SM-39 Development Laboratory
  - Started electricity installation for process equipment.

### **3.3 Issues**

- None

### **3.4 Variance Analysis and Recovery Plan**

- None

### **3.5 BCRs**

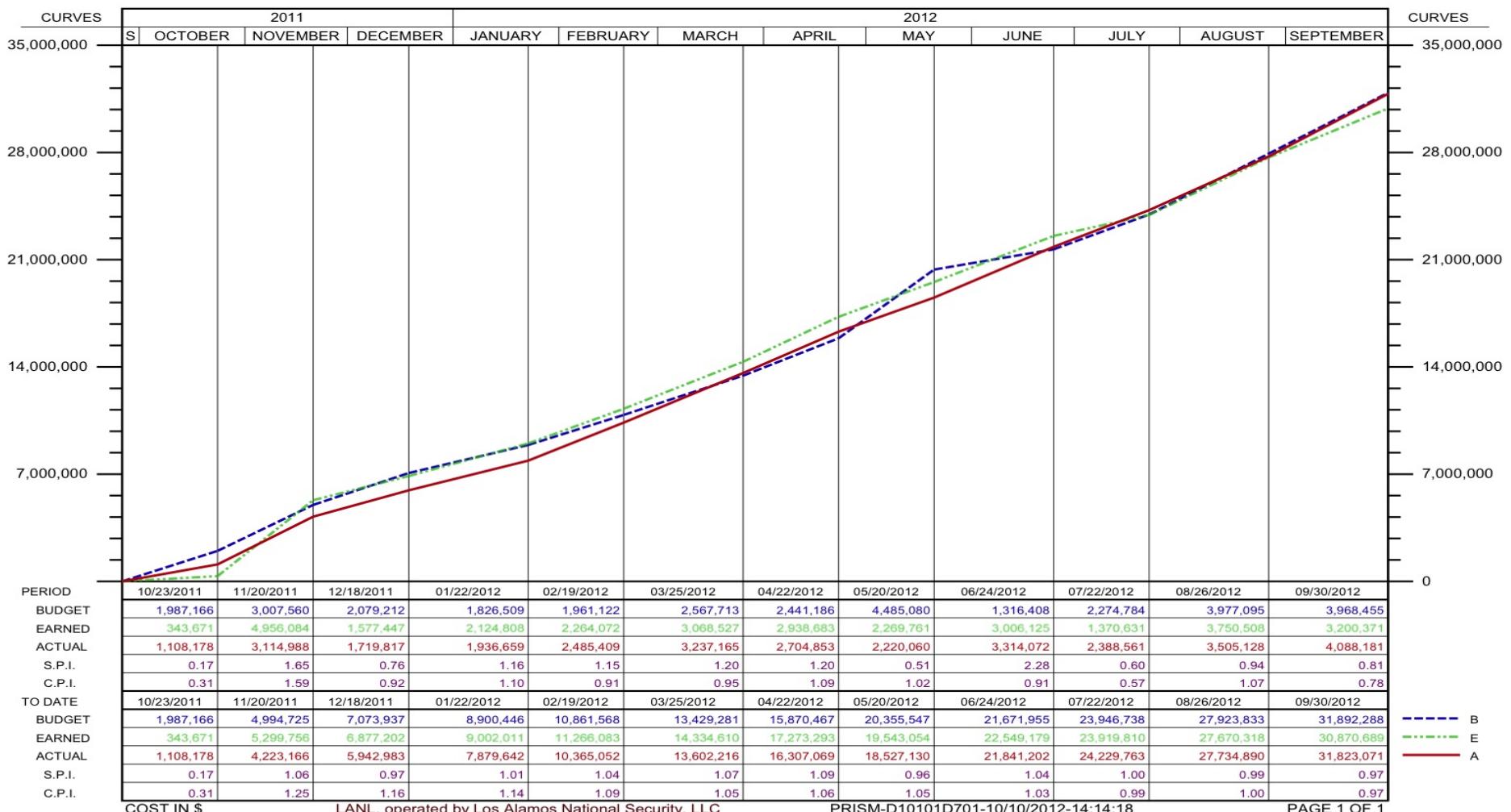
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### 3.6 Earned Value Metrics

## PERFORMANCE S-CURVE

Reconstitution of Power Supply Manufacturing



## **4.0 Program Management and Support**

### **4.1 Technical Progress**

- Documented completion of all LANL FY12 Plutonium Sustainment Level 2 milestones
- Submitted draft Program Implementation Plan for FY13.
- Evidence packages for MRT4195, MRT4196, MRT4197, and MRT4198 submitted

### **4.2 Equipment**

- None

### **4.3 Issues**

- None

### **4.4 Variance Analysis and Recovery Plan**

- Note that the planned (budget) and earned value for September includes planned carryover holdbacks (no allocation) with no associated FY12 costs. This has a significant (positive) impact on the C.P.I. (see section 4.6). The C.P.I. for September neglecting the \$10.75M holdback is 1.23. Likewise, the C.P.I. for FY12 is 0.98.

### **4.5 BCRs**

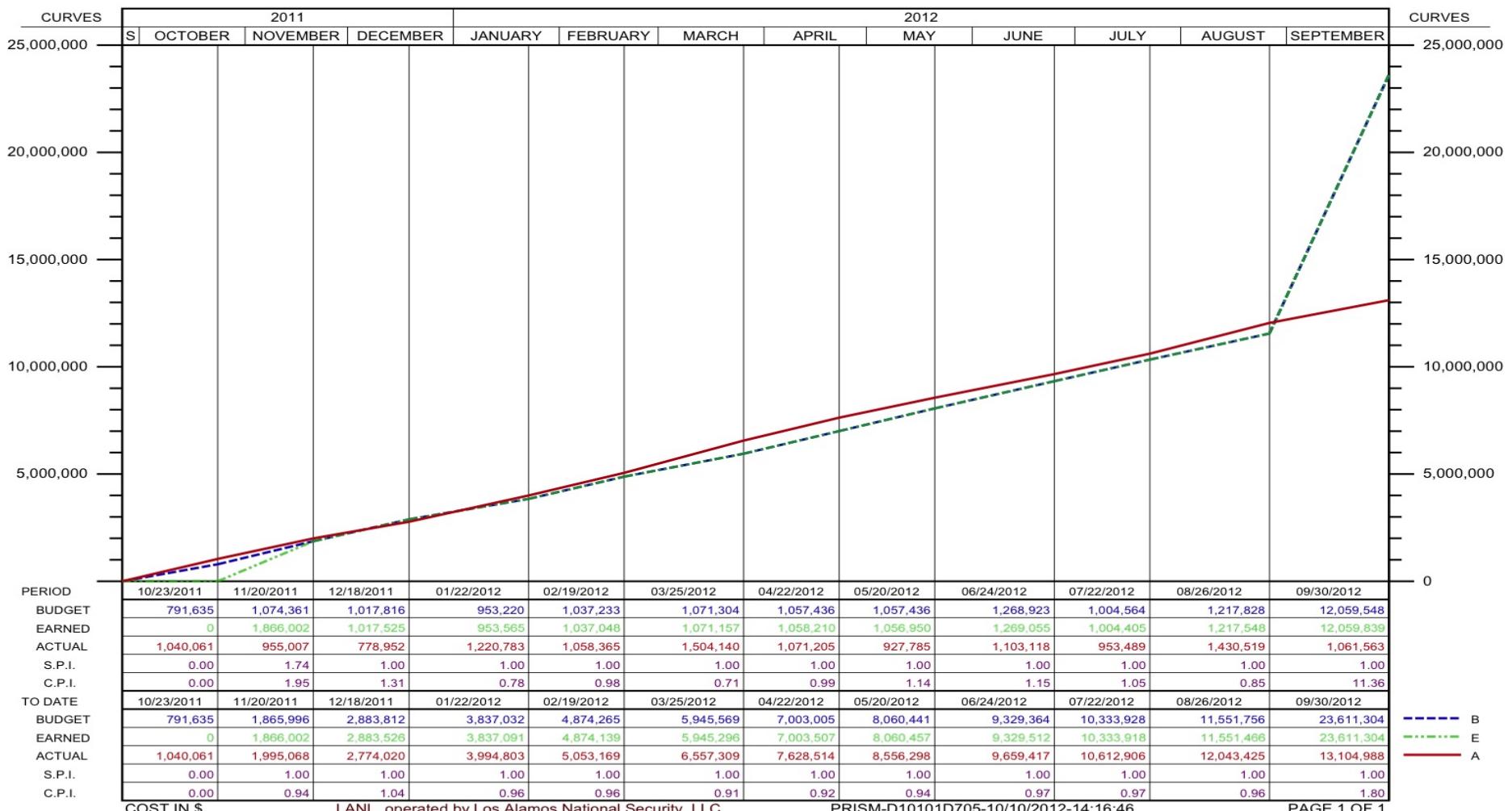
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## 4.6 Earned Value Metrics

## PERFORMANCE S-CURVE

Program Office



## 5.0 Facilities, Waste and Institutional Support

### 5.1 Technical Progress

- PF-4 Facility Availability: September 85.14%
  - 100 Area: 83.71%
  - 200 Area: 74.29%
  - 300 Area: 99.79%
  - 400 Area: 82.79%

### 5.2 Equipment

- None

### 5.3 Issues

- Rad-Con, Caustic Waste Line leak, and Dryer

### 5.4 Variance Analysis and Recovery Plan

- None

### 5.5 BCRs

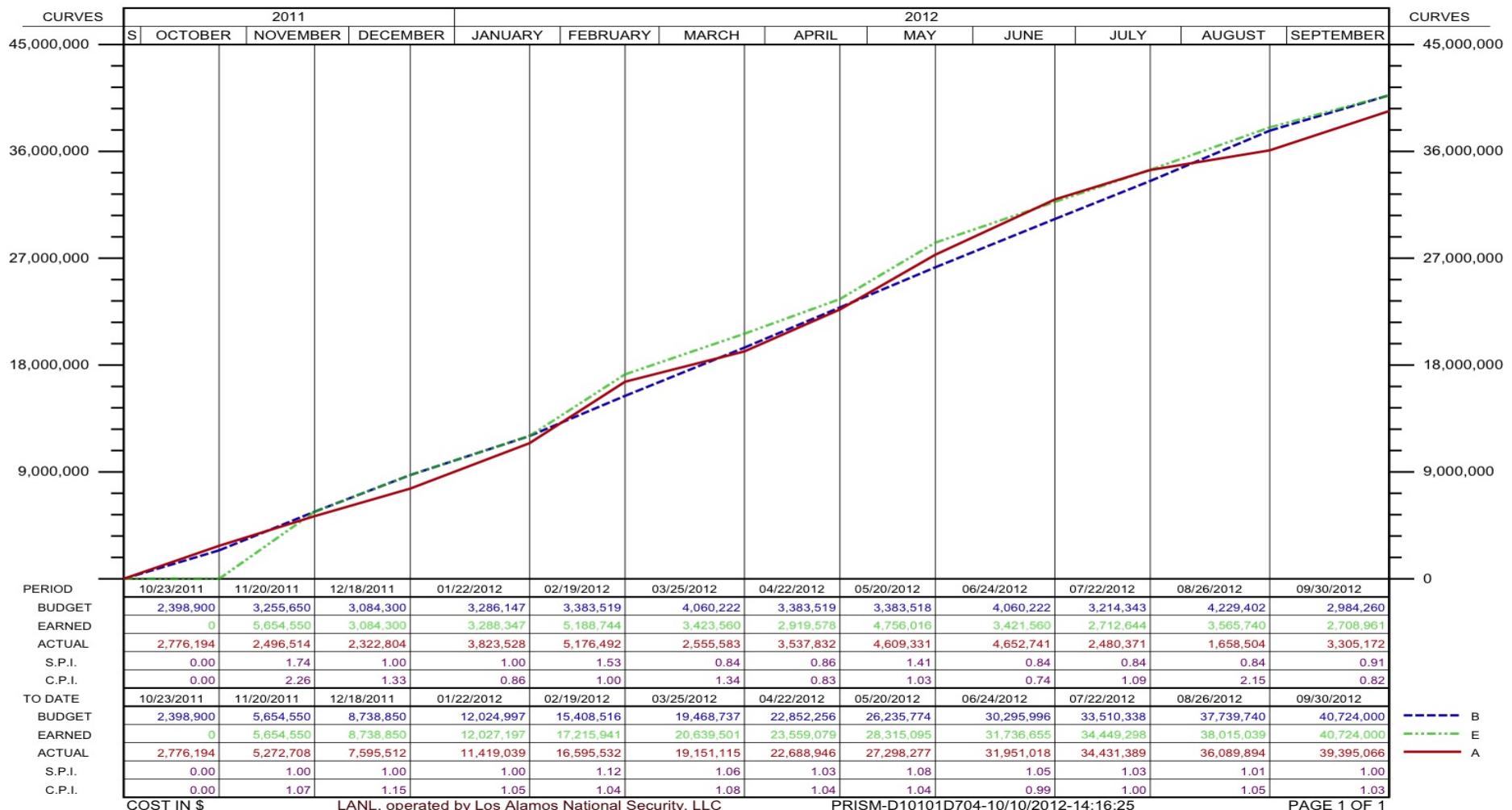
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## 5.6 Earned Value Metrics

## PERFORMANCE S-CURVE

Facility Infrastructure



## 6.0 LLNL

MRT 4196	BLUE	<b>Perform Activities to Sustain Base Pit Material Processing and Fabrication Capability</b>		
L3 Milestone	Baseline Date	Status/Comments	Completion Date	RGYB
LLNL Tasks to supports FY2013 EDU	9/30/2013	EDU Criteria and CMM Qualification Requirements Documents issued	9/30/2012	BLUE
Initial cold testing of modern foundry	9/30/2012	Several systems have been cold tested and report issued	9/30/2012	BLUE
Evaluate selected Pit Manufacturing Processes for initial phase of "W87 -Like" fabrication	9/30/2012	Machining In-Progress	9/14/2012	BLUE
Package and Ship Pu metal to LANL	6/30/2012	Shipments completed	6/28/2012	BLUE

### 6.1 Technical Progress

- The pit production IPT issued EDU Criteria Memo CODT-2012-1320 and CMM Qualification Memo CODT-2012-1321.
- Troubleshooting of the Moore T-base 1 lathe in progress after erratic performance of machine while machining second part outer surface.
- "Sheffield Gage Transition and Operations Plan," LLNL-AR-586172 issued September 21, 2012

### 6.2 Equipment

- Modern Foundry: Completed initial cold testing of the Modern Foundry Equipment and issued the Milestone Report titled, "Modern Foundry Initial "Cold" Testing FY12" LLNL-AR-585652 on September 30, 2012.

### 6.3 Issues

- None

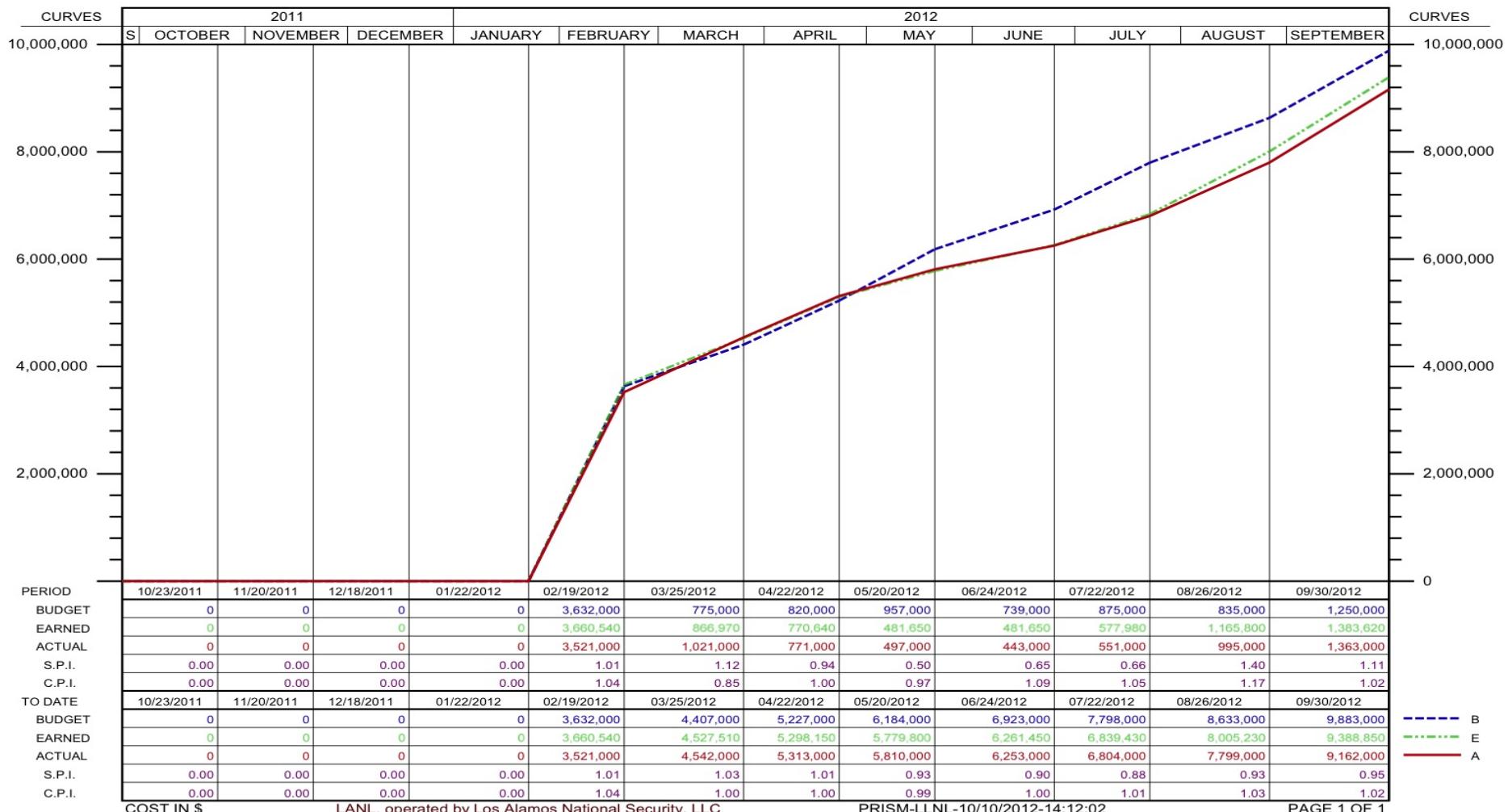
### 6.4 Variance Analysis and Recovery Plan

- CPI and SPI - Spending and Progress was back on target with additional staff to work at LANL in September.
- Recovery Plan – Continue staffing level to meet plan.

### 6.5 BCRs

- None

## 6.6 Earned Value Metrics

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LLNL

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