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Monthly Program Report April 2014

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LANL Executive Summary

As part of a required Conduct of Operations review, on June 10, 2013, several key PF-4 Operation Procedures were paused halting most SNM operations in PF-4 prompting Laboratory Director Charlie McMillan to issue a temporary pause of all programmatic activities in PF-4. Resumption criteria, prioritization of resumption activities, procedure walk downs, procedure revisions, and approval are in process and are expected to take several more months to complete. In February 2014 ADPSM produced a detailed baseline resumption schedule and is publishing a bi-weekly resumption status report.

In April of 2014 the Plutonium Sustainment program at LANL completed or addressed the following high-level activities:

- 1) The W87 development plan was revised and an executive summary was issued to NNSA. The new plan details the experimental matrix and extends through FY18 (b) (5)
- 2) The Purchase order for the foundry power supplies was issued. Major issues with the power supply were overcome to reach a design and vendor selection that would provide suitable performance for our system. It is expected that the power supplies will be received in time for installation in FY14 in time to meet the L2 milestone.
- 3) LANL fabricated four MASS Mock power supplies for use by the DA. These were welded to the SNL's design drawings using the (b) (7)(F) system in RTG-ATF. The mass mocks were (b) (7)(F) marked using equipment that will be used in production.
- 4) Completed numerous BCRs for pit equipment to reflect the new milestone, resumption schedule, and budget/priorities.

All three NNSA Level 2 Milestones (MRT 4961, 4962 and 4963) associated with Plutonium Sustainment are on track for success in FY14.

The earned value metrics overall for LANL are within acceptable thresholds with the exception of the elements effected by resumption (pit development and small sample fabrication). There is no recovery plan until the facility is resumed.

Each of the five major LANL WBS elements is discussed in detail below.

LANL Response to February NNSA Comments

none

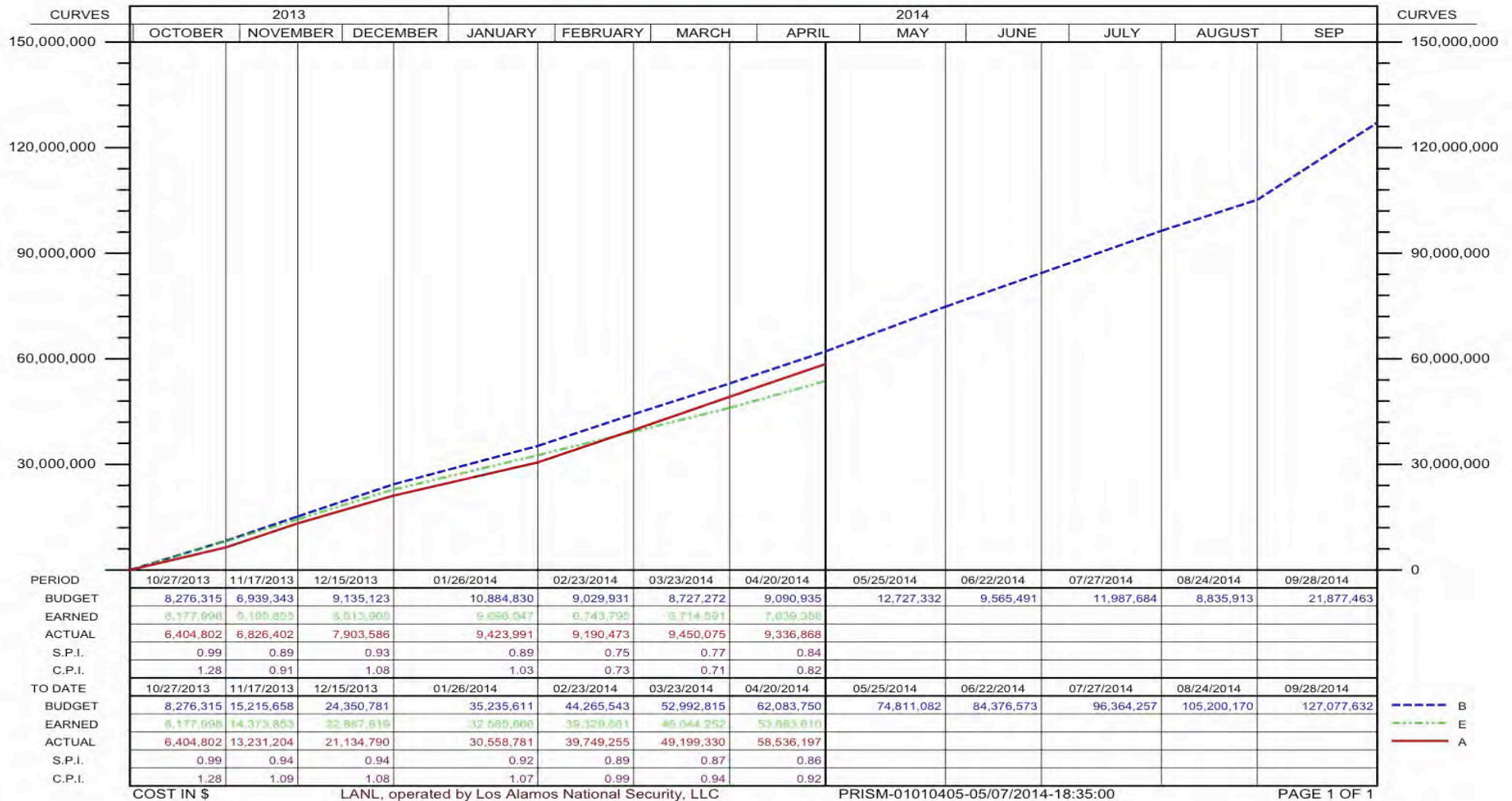
Table 1: April Baseline Change Requests

WBS	BCR #	BCR Description	Date Assigned	Date Approved	Impact	Cost Impact	Change Level
Pit Equipment	PSM-14-053	(b) (7)(F) Design, Procurement, and Related D&D	3/3/14	3/14/14	Schedule and cost	\$2,872k	1
Pit Equipment	PSM-14-054	D&D XB304 & XB305 Design	3/3/14	Pending	Scope, schedule and cost	\$846k	3
Pit Equipment	PSM-14-058	Precision Machining Line - Charge Code Re-allocation	3/15/14	4/10/14	Schedule	None	4
Pit Equipment	PSM-14-061	Foundry SWW GB D&D	3/17/14	3/24/14	Scope, schedule and cost	\$1,000k	3
Pit Equipment	PSM-14-066	CMM #1 Re-plan	3/25/14	Pending	Scope, schedule and cost	None	2
Production Support	PSM-14-070	AWG711 Shipping Container Scoping Study	4/14/14	4/22/14	Cost/schedule	\$30k	4
Pit Equipment	PSM-14-075	CMM #2 De-scope	4/14/14	Pending	Scope	None	
Pit Equipment	PSM-14-076	(b) (7)(F) Contract Award and Design	4/15/14	4/23/14	Schedule	None	3
Power Supplies	PSM-14-078	Power Supply Installations and Critical Spares	4/15/14	5/5/14	Schedule and cost	\$825k	3

Earned Value Metrics

PERFORMANCE S-CURVE

01.01.04.05 Plutonium Sustainment



[NOTE: September 2014 includes 6% FY15 carryover holdback of \$7.414M in addition to the five major WBS elements.]

1.0 LANL - Pit Development

MRT 4961		GREEN	Perform Activities to Sustain Base Pit Material		
			(b) (7)(F)		
1.	(b) (7)(F)		(b) (7)(F)		T.
2.	(b) (7)(F)				
Activity	Baseline Date	Status/Comments	Completion Date	RGYB	
(b) (7)(F)					
MRT 4962		GREEN	Continue Key Equipment Upgrade and Replacement Activities		
1. Complete ER Line Upgrades construction punchlist and execute successful cold test.					
2. Complete Pu Foundry GB 1 mechanical and electrical construction.					
3. Foundry GB 2 upgrade approved for installation.					
4. Complete CMM GB 30% design review and GB installation 30% design review.					
5. Complete CDS installation 60% design review.					
6. Finish installation (not including FCRs) on PML – Phase 2.					
ER Line Dry Run/Cold Test Complete	April 26, 2014	Cold testing of ER furnace control system software completed			RED
ER Line Punchlist Complete	August 15, 2014	Construction punch list completed	April 28, 2014		BLUE
Foundry GB1 Cooling Power Supply Received	June 2, 2014	Purchase of power supplies was approved on April 28, 2014			YELLOW
Foundry GB1 Cooling Furnace Housing Installation Complete	July 3, 2014	Removal of existing and installation of new GB1 furnace housing completed.	April 4, 2014		BLUE
Foundry GB2 Approved for Installation	September 30, 2014				GREEN
Complete location study for New GB & CMM	April 15, 2014	The location study was approved.	April 8, 2014		GREEN
Complete 30% CMM GB Utilities Installation Design Review	July 31, 2014				GREEN
Complete 30% CMM GB Fabrication Design Review	September 30, 2014				GREEN
Start CDS Engineering Development	October 1, 2013		October 1, 2013		BLUE
CDS Engineering Contract Awarded	February 16, 2014		January 9, 2014		BLUE
CDS 30% Installation Design Complete	June 1, 2014		January 28, 2014		BLUE
CDS 60% D&D Design Complete	August 11, 2014		January 9, 2014		BLUE
PML DCP Re-Activation Complete	January 10, 2014		December 12, 2013		BLUE
PML Construction Planning Complete	May 22, 2014	Does not include Field Change Requirements.	April 23, 2014		BLUE
PML Cold Testing Complete	July 3, 2013	Cold testing in progress.			GREEN

1.1 Technical Progress

- The W87 development plan was revised and an executive summary was issued to NNSA. The new plan details the experimental matrix and extends through FY18 (b) (5)
- The Purchase order for the foundry power supplies was issued. Major issues with the power supply were overcome to reach a design and vendor selection that would provide suitable performance for our system. It is expected that the power supplies will be received in time for installation in FY14 in time to meet the L2 milestone.
- The majority of pit manufacturing development is focused on resumption related activities. Accordingly, most of the budget and scope through January is captured in a "level of effort" activity. With the publishing of the prioritized resumption schedule in February, Earned value tracking has been temporarily suspended for the pit development flowsheet.

1.2 Equipment

- The plan to meet the grading criterion L2 milestone MRT 4962 includes the following by September 30, 2014:
 1. Complete ER Line Upgrades construction punch list and execute successful cold test.
 2. Complete Pu Foundry GB 1 mechanical and electrical construction complete.
 3. Foundry GB 2 upgrade approved for installation.
 4. Complete CMM GB 30% design review and GB installation 30% design review.
 5. Complete CDS installation 60% design review.
 6. Finish installation (not including FCRs) on PML – Phase 2.
- Electro-Refining Line Upgrade (b) (3)
 - o The connection of the Negative Pressure Chilled Cooling Water System (NPCCWS) was completed.
 - o Cold testing of ER (furnace) Control System (ERCS) software has been completed
 - o Punch list activities have been completed.
- Foundry Upgrade (b) (3)
 - o The Purchase Order for power supplies was issued. Additional engineering resources have been deployed to prepare mounting racks for receipt of power supplies.
 - o The existing furnace housing for GB-1 was removed. The installation of the new housing was completed.
 - o The removal of the existing upper lift from GB1 was completed.
 - o The Dual Limited Volume Chilled Water System (DLVCWS) was introduced into PF-4 for installation.
- Coordinate Measuring Machine (b) (3)
 - o Draft 30% glovebox fabrication design issues for review.
 - o Vendor response to RFP received. Financial and technical evaluations proceeding.
- Chlorine Distribution & Detection System (b) (3)
 - o 60% Installation Design review started.
- Precision Machining Line (b) (3)
 - o Installation of the airlock door control box started.
 - o Helium leak testing of gloveboxes has started.
 - o (b) (7)(F) test plans have been prepared. Plans are undergoing review and approval. Pressure safety legacy issues are being addressed.
 - o Construction planning continues.

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1.3 Issues

- None

1.4 Variance Analysis and Recovery Plan

- None

1.5 BCRs

- PSM-14-053: This BCR provides funding for the (b) (7)(F) project. After a discussion with the Pu Sustainment Federal Program Manager (NA-123.1) to review several candidate projects to be funded in FY14, the (b) (7)(F) project was selected. This BCR funds the project immediately while a follow-up BCR (PSM-14-076) details the resource-loaded schedule.
- PSM-14-054: This BCR provides funding for the removal of two boxes to provide a space for the new (b) (7)(F) (see BCRs PSM-14-053 and PSM-14-076).
- PSM-14-058: This BCR aligns funding and scope by work package for the recently re-scoped Precision Machining Line project.
- PSM-14-061: This BCR provides funding for the removal of a glovebox to provide space for the waist-banding lathe.
- PSM-14-066: This BCR provides a resource-loaded schedule for the newly re-scoped CMM project to reflect the need for the higher precision Infinity PMM.
- PSM-14-075: This BCR provides pushes all planned work yet to be done in FY14 for the second CMM to FY15 (funding was already moved to provide additional funding for the first Infinity PMM machine).
- PSM-14-076: This BCR provides resource-loaded schedule for the (b) (7)(F) project. This is a follow-up BCR to PSM-14-053 that provided funding to re-start the project.

1.6 Risk Table

Work	Description	Handling Strategy	Status
(b) (7)(F)	(b) (7)(F)	(b) (7)(F)	(b) (7)(F)
Completion of DCP	Equipment projects all require new or revised CSEs and procedures. Without CSEs these DCPs cannot be closed.	Identify all installation project CSEs & related DOPs, and prioritize by schedule/complexity. Complete supporting activities and request project resources available when needed. If resources are unavailable due to conflict with PF-4 Resumption, then the DCP closure will be removed for the L2 milestone requirement.	
Equipment Upgrades	The resumption process and related demands on criticality engineering and other project support create significant uncertainties for the FY14 equipment execution. - ER Line activities that may be impacted include cold testing, Zone 1 tie-in, and NPCCW tie-in. - Foundry Upgrade activities include criticality design/construction support and waste management processes.	Equipment project resource requirements will be reviewed and prioritized by Program. The projects will alternate work methods as contingencies. If necessary the milestone may be renegotiated.	

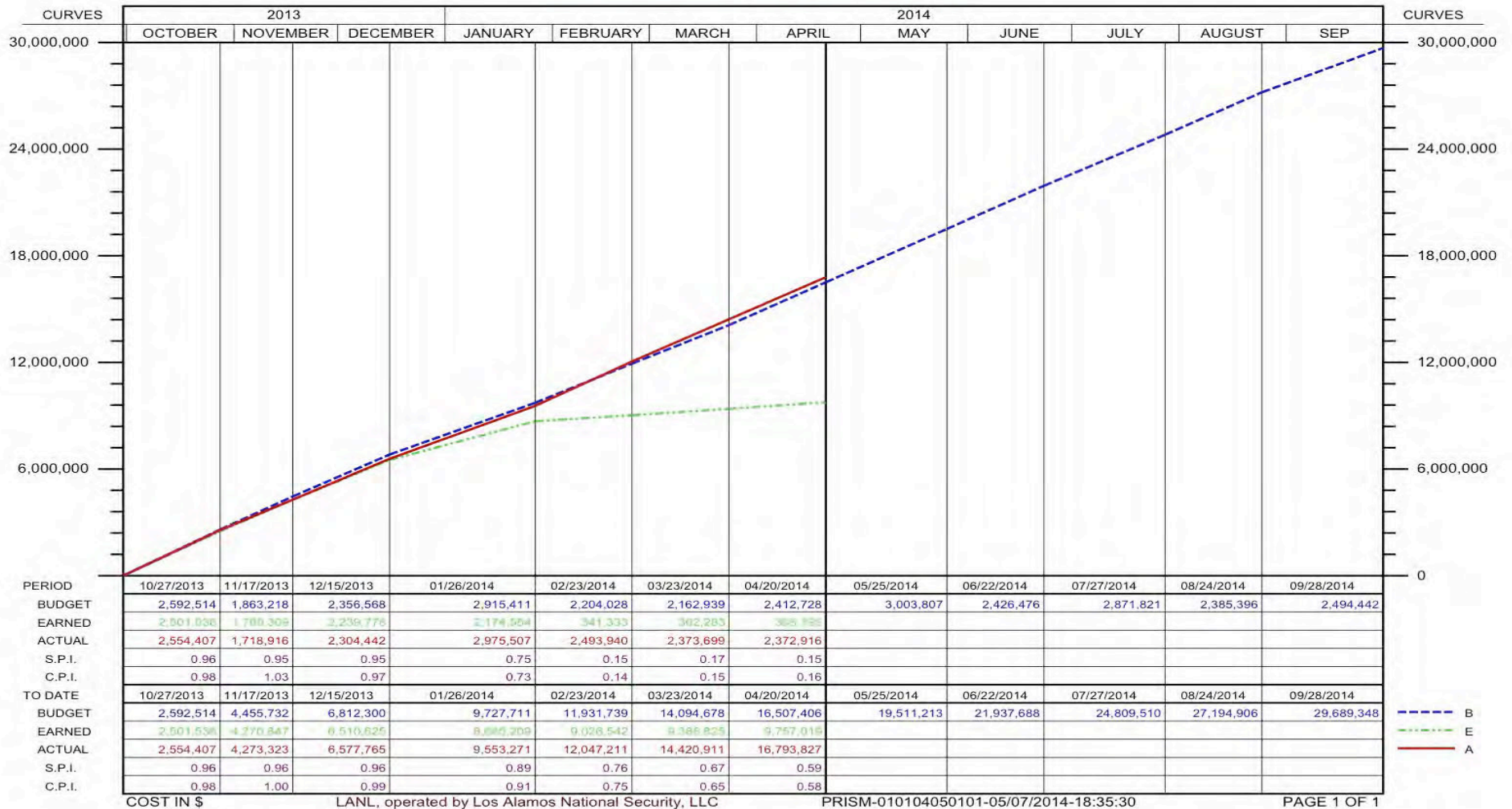
(b) (5)

(b) (7)(F)

1.7 Earned Value Metrics

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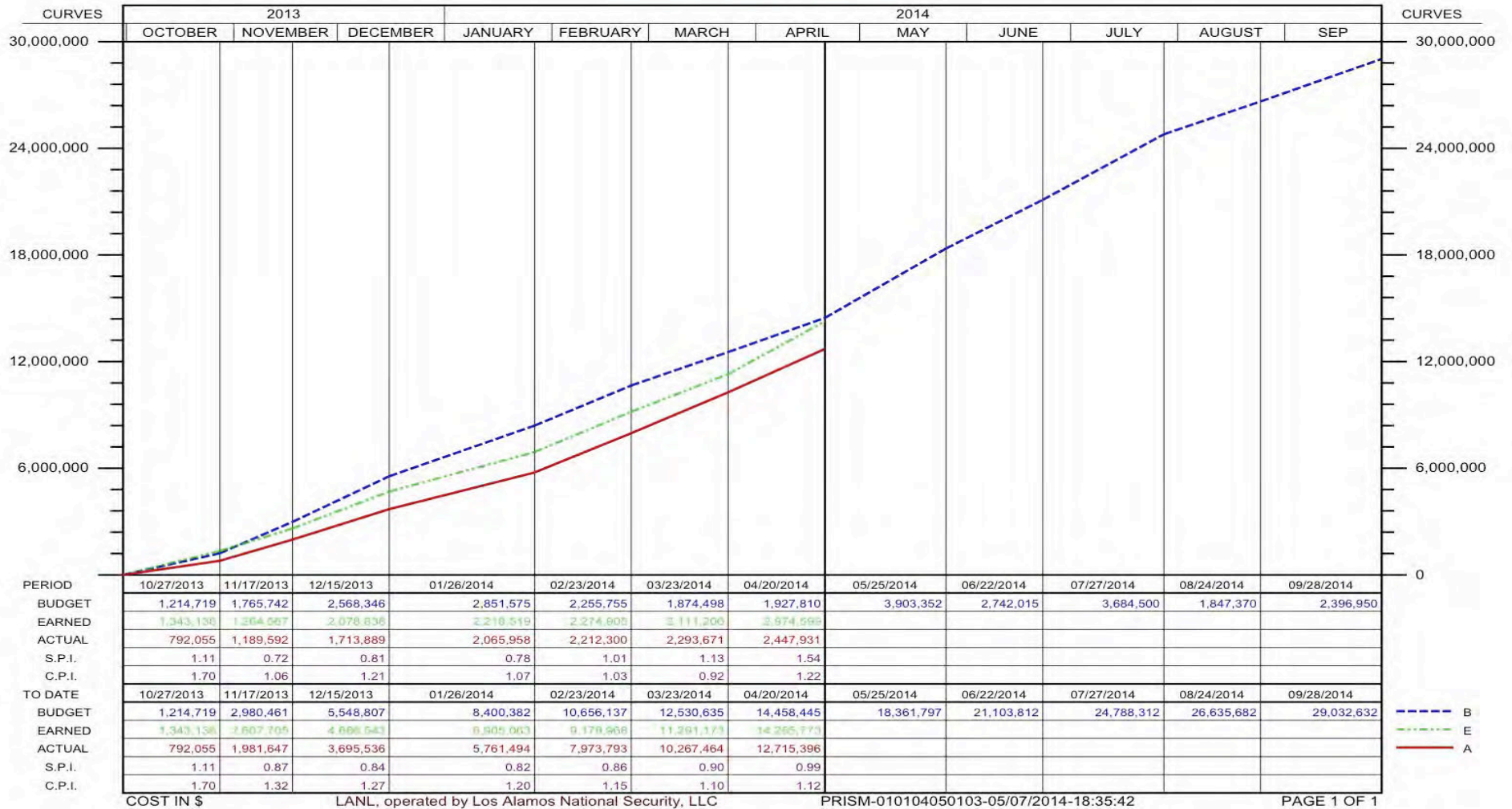
Pit Manufacturing & Design Development



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Pit Manufacturing Equipment



2.0 LANL - Power Supply

MRT 4963		GREEN	Progress Power Supply Development		
1. Complete (b) (7)(F) of inert heat sources.					
2. Start (b) (7)(F) of assembled Power Supplies.					
L3 Milestone (b) (3)	Baseline Date	Status/Comments	Completion Date	RGYB	
	January 13, 2014		November 15, 2013	BLUE	
	February 17, 2014		November 15, 2013	BLUE	
	March 10, 2014	(b) (7)(F)		RED	
	June 20, 2014			GREEN	
	August 29, 2014			GREEN	
	May 25, 2014		October 15, 2013	BLUE	

2.1 Technical Progress

- ☐ The SNL Heat Source Design Engineer issued a DRAFT (b) (7)(F) and (b) (7)(F) of heat source sub-assemblies. LANL Power Supply Welding and Product Engineers are reviewing document.
- ☐ (b) (7)(F) development and refinement continues. Development of the weld parameters for the strength member nears completion. The (b) (7)(F) development for the (b) (7)(F) strength member is nearing completion. A design of experiments (DoE) has focused the work on a set of parameters that produce reliable and repeatable welds. Radiography of parts for SNL's Pressure Tests showed no voids and adequate weld penetration. Metallography is being performed on a final set of (b) (7)(F). In addition, 20 more parts were strength member parts and were welded and sent to TA-8 for UT Inspection and analysis.
- ☐ Additional work to insure the (b) (7)(F) produces a quality beam includes:
 - ☐ Working with vendor on evaluation/fine tuning of recently procured Beam Measurement Tooling and software.
 - ☐ Performing detailed analysis of (b) (7)(F) Profile. Working issues real time with vendor.
 - ☐ Working real time with vendor on CCD camera issue.
- ☐ (b) (7)(F) development of liners is almost finalized with inspections (radiography, metallography, SEM and dimension) data being analyzed.
- ☐ New tooling and fixtures are being designed /developed to accommodate the most recent hardware design changes by the DA.
 - ☐ (b) (7)(F) systems maintenance was performed at SM-39 and refinement

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- Quality documentation has begun for the equipment in the RTG-AFT. This includes Process Qualification Plans (PQP) and the subsequent Process Qualification Reports (PQR). The draft PQPs were sent to the DA for signature and will serve as a basis for the QERs later in the program.
 - Detailed discussions were held between LANL and SNL regarding the PQR for Gamma FRAM. A Final Version of the document will be routed for signatures by Mid May 2014.
 - Detailed Operating Procedures (DOPs) are being developed and are in DRAFT for operations in PF-5.
- LANL fabricated four MASS Mock power supplies for use by the DA. These were welded to the SNL's design drawings using the (b) (7)(F) in RTG-ATF. The mass mocks were (b) (7)(F) marked using equipment that will be used in production.
- Hosted vendor rep for a week's on-site for evaluation of system and operational performance of the (b) (7)(F) systems in PF-5 and SM-39. It was determined that:
 - Fiber alignment is good (all 3 systems)
 - Beam density is good (all 3 systems)
 - Beam profile is good (all 3 systems)
 - Run power up to 6kW on all systems. Performed well

2.2 Equipment

- New accelerometers are being purchased from the vendor (Lansmont) using WR MT&E protocols. This will serve as the pilot for obtaining all necessary MT&E using the quality standards required to sell product.
- An E-Tester report has been generated and sent to KCP to help in the development of the production units. The report has several ergonomic and data display changes identified and as well as a status of the functionality of the prototype. It appears one channel is not functioning.

2.3 Issues

- The continued Pause in PF-4 operations coupled with procedural activities for resumptions, is affecting power supply production in the following areas:
 - FY14 Demo Fuel Run (Aqueous Processing and Fuel Fabrication)
 - Harvesting support activities: FSI opening and location/identification of fuel to increase current amounts
- FY14 funding cancellation for AMET Controller replacement in PF-4 and UT Development for installation at SM-39 will delay weld development activities. Note that the AMET Controller Replacement Project might be re-started with an approved BCR.

2.4 Variance Analysis and Recovery Plan

- None

2.5 BCRs

- PSM-14-078: This BCR provides funding for the installation of the two new (b) (7)(F) controllers and several critical spare parts associated with power supply production. Funding was made available based on under runs in the Line Management code due to several unfilled open positions across Pu Sustainment activities.

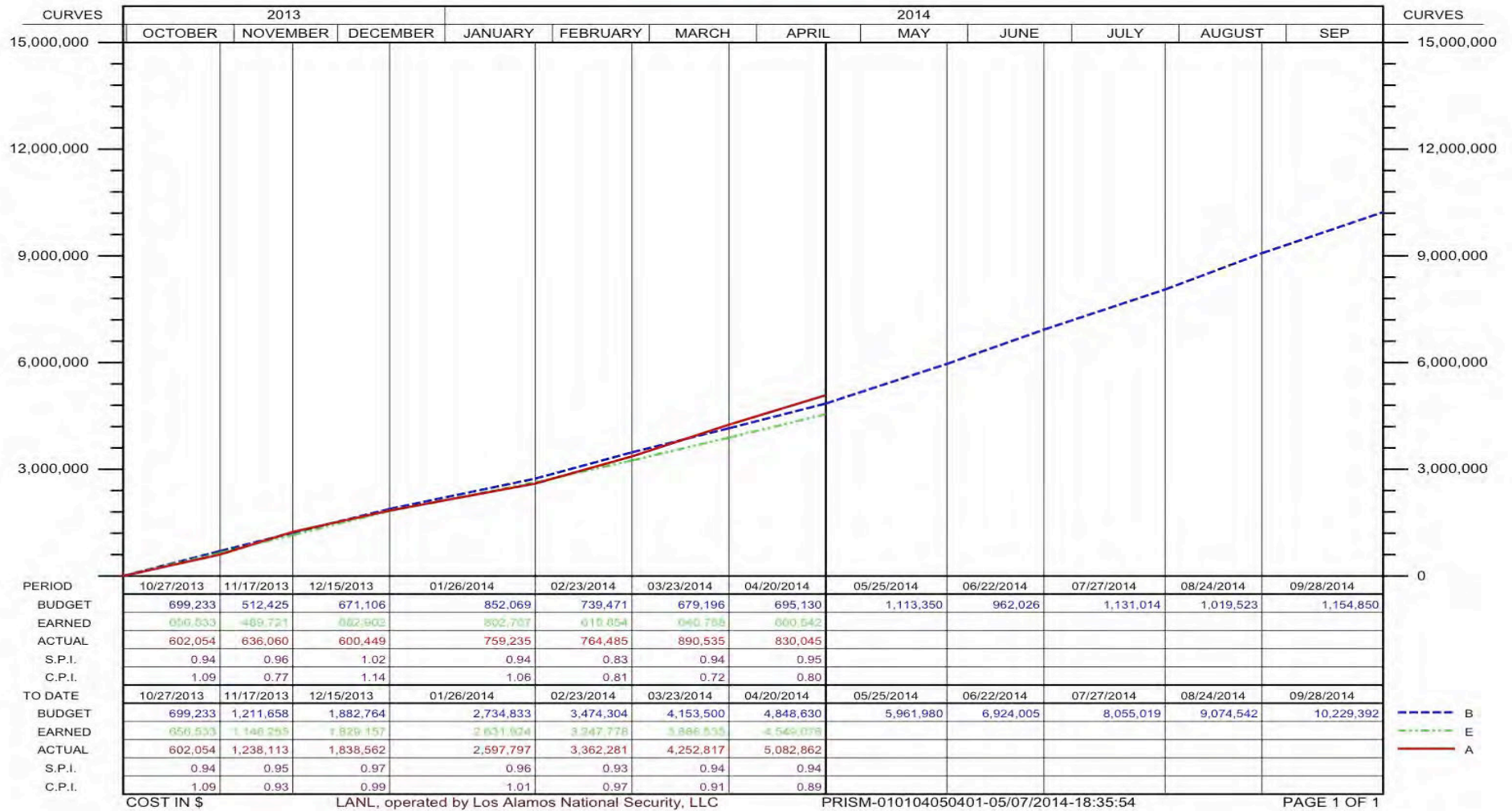
2.6 Risk Table

Work	Description	Handling Strategy	Status
Workforce development and recruiting	Dedicated staffing and depth of trained operators are both at risk to support the development, PPI, and Qual series for Power Supply manufacturing development. The plan to start hiring in FY13 for dedicated staffing did not occur. Staffing is shared with other programs and may not always be available as scheduled. Note that the increase in staff also was planned to maintain lower dose rates in the staff as part of LANL ALARA goals.	1. Communicate and integrate frequently with Power Supply surveillance, NE-75, and other programs to make the best use of available staff. 2. Request LANL and LAFO management to allow for increase in dose to staff assigned to this work. 3. Delay non-critical path activities until they become critical path for FPU.	LANL performed a cross-program review in October of the baselined P6 schedules with NE-75.
Design Maturation beyond PRT Schedule	Delays in the delivery of the various required design phases (AERs, BDR, etc) will lead to a delay in LANL's delivering the FPU.	1. Communicate and integrate frequently with the PRT on LANL design needs. 2. Provide monthly input into the PRT's Integrated Schedule to manage formally any delays.	LANL continues to provide input at the monthly PRT meeting. Topics of the October meeting included review of the most recent fuel specification.
(b) (7)(F)	(b) (7)(F)	(b) (7)(F)	
AMET Controllers Replacement	(b) (7)(F)	1. Delay until FY15 unless funding becomes available in FY14 (will not effect FPU schedule).	LANL to procure hardware, let contract for reps to be on-site and start disassembly/re-assembly and testing activities. Funding cancelled for FY14.
UT Cold Development	Develop and install a cold UT inspection station at SM39 that will be used for (b) (7)(F) development.	1. Working with other LANL groups to determine if equipment and resources are available to inspect (b) (7)(F) at another LANL location.	Hardware bought and on-hand. Equipment delivered at SM39 but installation/integration on-hold due to cancelled of FY14 funds.

2.7 Earned Value Metrics

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Power Supply Production



3.0 Program and Manufacturing Support Services

3.1 Program Management

- Supported the resumption scheduling effort with priority assignments and procedure list review.

3.2 Support

- The NPI-8 procurement team successfully processed 214 procurement requests for TA55 in April. The team was able to work through the period without the development of a substantial (> 1 week) and permanent backlog.
- Working on the ER line closeout efforts.
- Developing an automated procurement request form.
- Revised the TA55 Warehouse DOP to include worker feedback and recently acquired ergo equipment (hydraulic lift tables and a banding machine.)
- TA-55 Main Warehouse Transactions
 - o 1,797 Warehouse distributions at a cost of \$109,258.
 - o 1,435 Warehouse receipts at a cost of \$36,788.
 - o (\$72,470) change in warehouse valuation.
- Calibration
 - o The S&CL continues to work with dimensional inspection as requested to develop processes for re-certifying various M&TE in glove boxes that most benefits the Laboratory in regards to minimizing waste and maximizing the useful life of the M&TE.
 - o Continued working with detonator project leads to ensure the availability of calibrated M&TE to meet production needs. This collaboration has been successful in meeting production requirements.
 - o Continued progress on two Lean Six Sigma process improvement projects to address chronic underperformance in completing calibrations of dimensional measuring and test equipment and to improve the quality of calibration report packages.
 - o A total of 19 M&TE items were expected for April and 13 items were actually received. Calibrated 21 M&TE items in April. Successfully and consistently achieved target cycle time rates for equipment turn around to avoid mission and deliverable impacts.
- Records Management
 - o Document Control Results
 - New DARs received by the team = 284
 - New DARs received for MET-1 = 101
 - New DARs received for MET-2 = 5
 - Completed DARs by the team = 51
 - Completed DARs for MET-1 = 11
 - Completed DARs for MET-2 = 5
 - o Records Management Metrics
 - Boxes of records indexed and shipped out during month = 9
 - Boxes of records indexed and stored locally in VTR during month = 4.5
 - Boxes of records received during month = 0.4

- Preventive and Corrective Maintenance
Completed preventative maintenance on systems requiring maintenance while in pause.
 - o Glove inspections
 - o Status and Condition inspection of all Plant HEPA's**PF-4:** Continued HEPA Filter Change tool design, He gas line leak check plan, liquid utility line leak repair plans.

Corrective Maintenance

 - o Continued GB Door (pass-through chamber) gasket replacement
 - o Glovebox bubbler adjustments
 - o Electrical outlet replacements.
- Project Support
(b) (7)(F) Design – D&D and Maintenance Plan reviews
 - o Design of 300 area house vacuum system
 - o Design of 300 area Dri-Train installation
- New Work (planning and work package development)
 - o Develop standing IWD for Magnehilic test assembly installation and calibration
 - o Planning IWD for the removal of LVCCW system connected to (b) (7)(F)
 - o Testing new XM replacement controller supporting the AMET welding process
 - o Developing IWD for the replacement of all tuna can filter with a Nuc-fil filter
- Work Management & Control: Continued to collect specific equipment history.
 - o Supported MEL entries and label creation for HEPAs and Service Agreements
 - o CMMS upgrade to include new brief type (ISSUES)
 - o History and Equipment Briefs entered

3.3 Issues

- Metrology
 - o Funded to meet anticipated M&TE calibration requirements, however, aging calibration equipment is beginning to fail (one item failed in November) and replacement will be required to avoid impacts. Additional funds were allocated in February to partially fund service contract and equipment replacement needs and replacement equipment is being procured within budget constraints. This will continue to be an on-going issue until enough equipment is replaced to mitigate the potential for equipment failure.

3.4 Variance Analysis and Recovery Plan

- Through month end April under spending relative to planned on facility and production support activities. Developing recovery plans for work packages spending at rates higher than planned. Monitoring end of year plans for work packages spending below planned with multiple BCRs planned for equipment procurements.

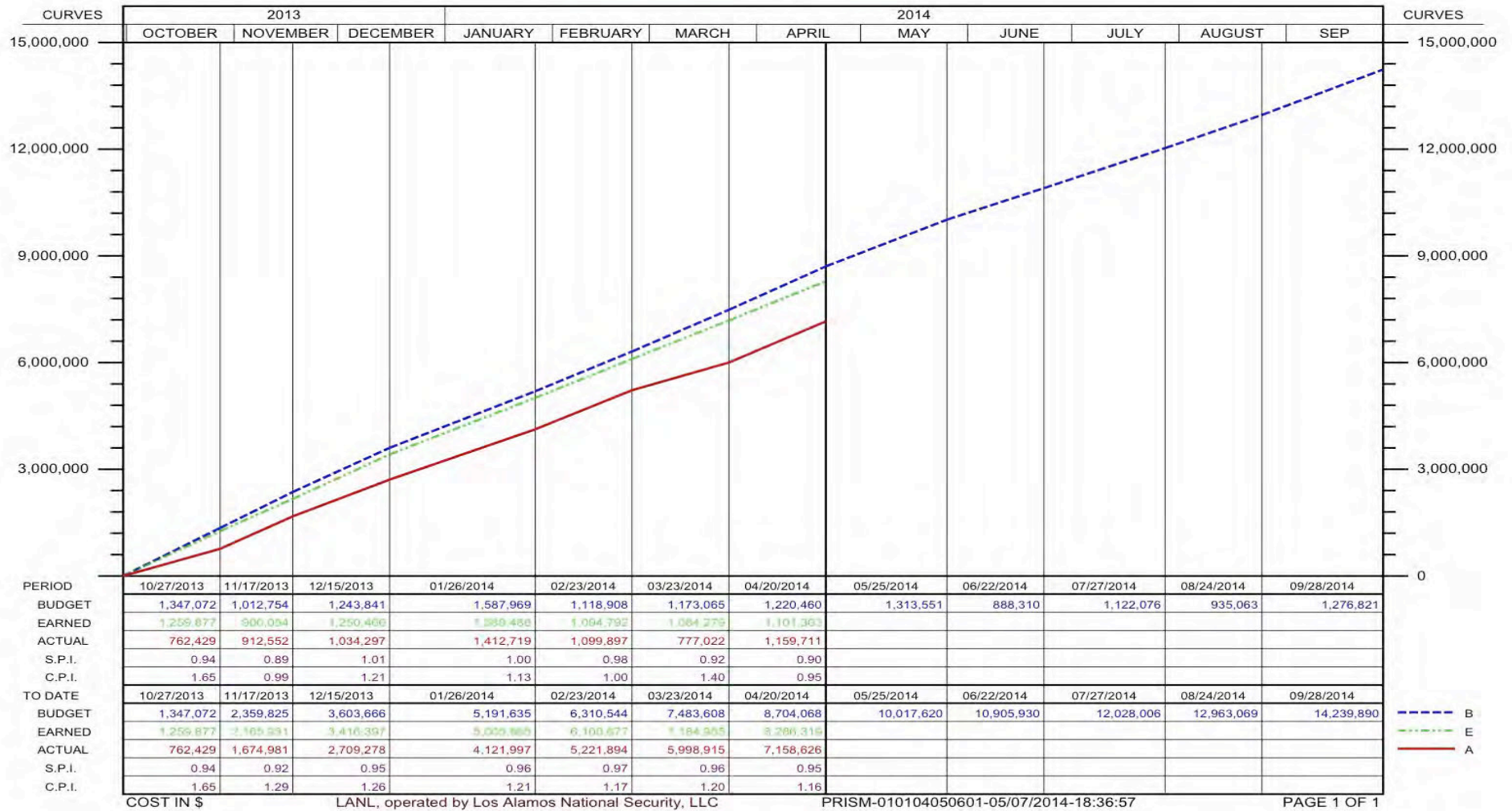
3.5 BCRs

- PSM-14-070: This BCR provides funding for a new project to develop site input to a preliminary feasibility determination for use of the AWG 711 container as directed by Steve Goodrum.

3.6 Earned Value Metrics

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Program & Manufacturing Support Services



4.0 Facilities, Waste and Institutional Support

4.1 Technical Progress

PF-4 Facility availability in December 92.73%

- An updated copy of the ADSPM Safety, Security, and Environmental Action plan distributed April 9th. The version contains April status updates from each of the subject matter owners: Safety ((b) (6)); Security ((b) (6)); and Environment ((b) (6)).
- The revised above subject memo titled “FOD Declaration of Readiness to Verify Implementation of TA55-ESS-13-003-R2, Evaluation of the Safety of the Situation (ESS): GPHS Containers Discovered to be in Nonconforming Condition” to documents that Safety Basis changes are adequately implemented.
- Multiple Year Software Agreements for FactoryLink, Rockwell and GE Software Maintenance Submitted (81.8 K with Cost Savings of 31.5 K through Utilization of Multiple Year Option)
- The Principal Associate Directorate for Weapons Programs has approved limited material movement to resolve PF-4 SNM inventory issues.
- Packaging, movement, and NDA/measurement of SNM items shall be approved by the TA-55 Operations Manager, scheduled through the TA-55 Integrated Plan of the Day, and performed according to fully resumed procedures.

Maintenance Modifications

- Bleed-off Sewer Vent Relocation
- Prepared for Hot Job and Sampling to re-route Bleed-off Exhaust Duct and Performed: All Results Non-Detectable
- Carpenters Building Scaffolds for Re-route of Bleed-off Exhaust Duct, April 14, 2014
- Consolidated Bill of Materials (CBOM) Submitted to Re-route Bleed-off Exhaust Duct Submitted, April 14, 2014

4.2 Equipment

- TA-55 deferred 2 preventive maintenance (PM) activities due to contamination/red light issues and one PM due to material. CMR deferred 1 PM due to equipment out of service. WFO deferred 2 PMs due to emergent work at other facilities and 1 PM due to WETF.

4.3 Issues

- Lack funding to complete Red Network upgrade work. This work will cost more and take longer to complete once the plant is back in operations.

4.4 Variance Analysis and Recovery Plan

- None

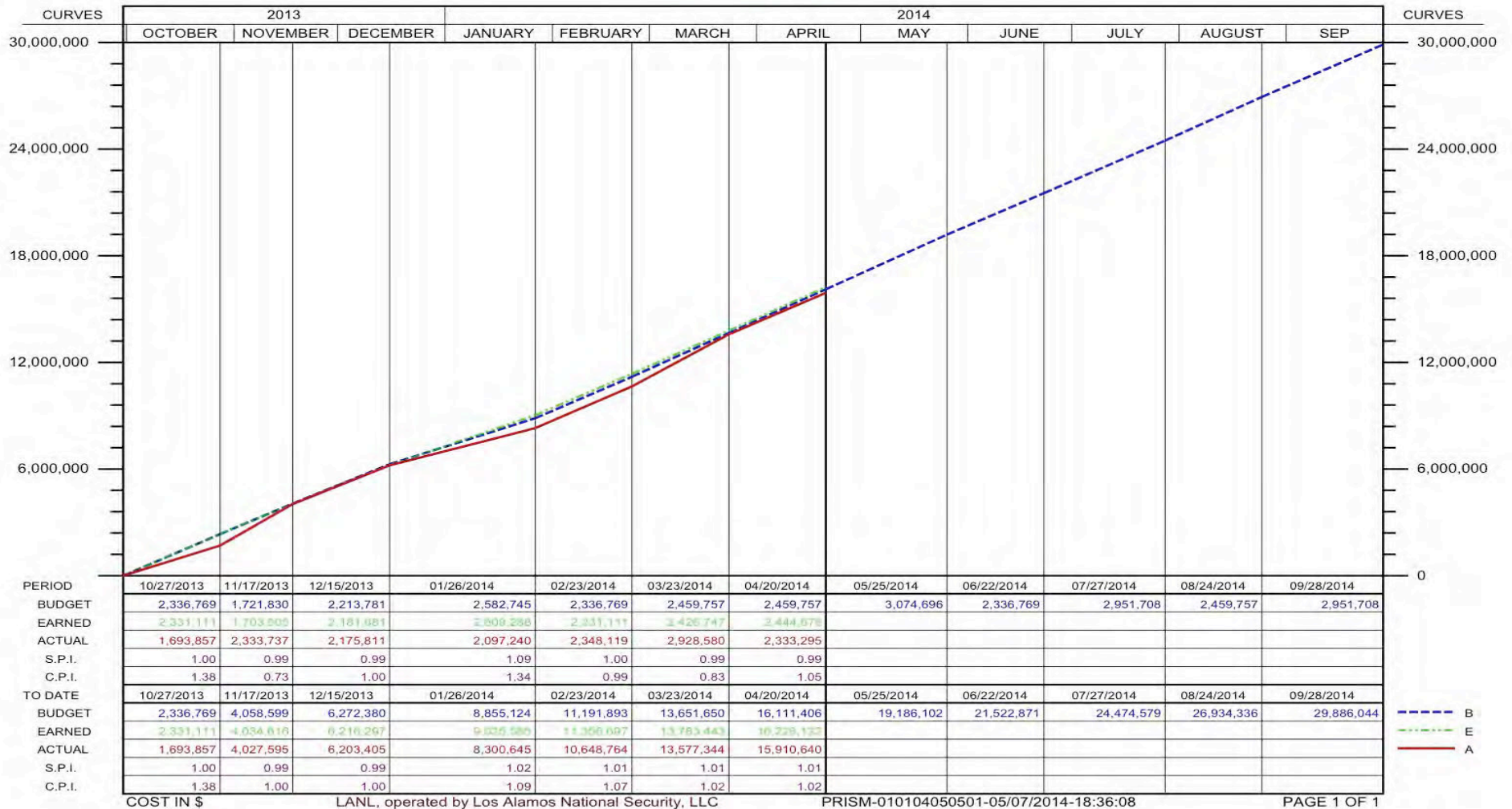
4.5 BCRs

- None

4.6 Earned Value Metrics

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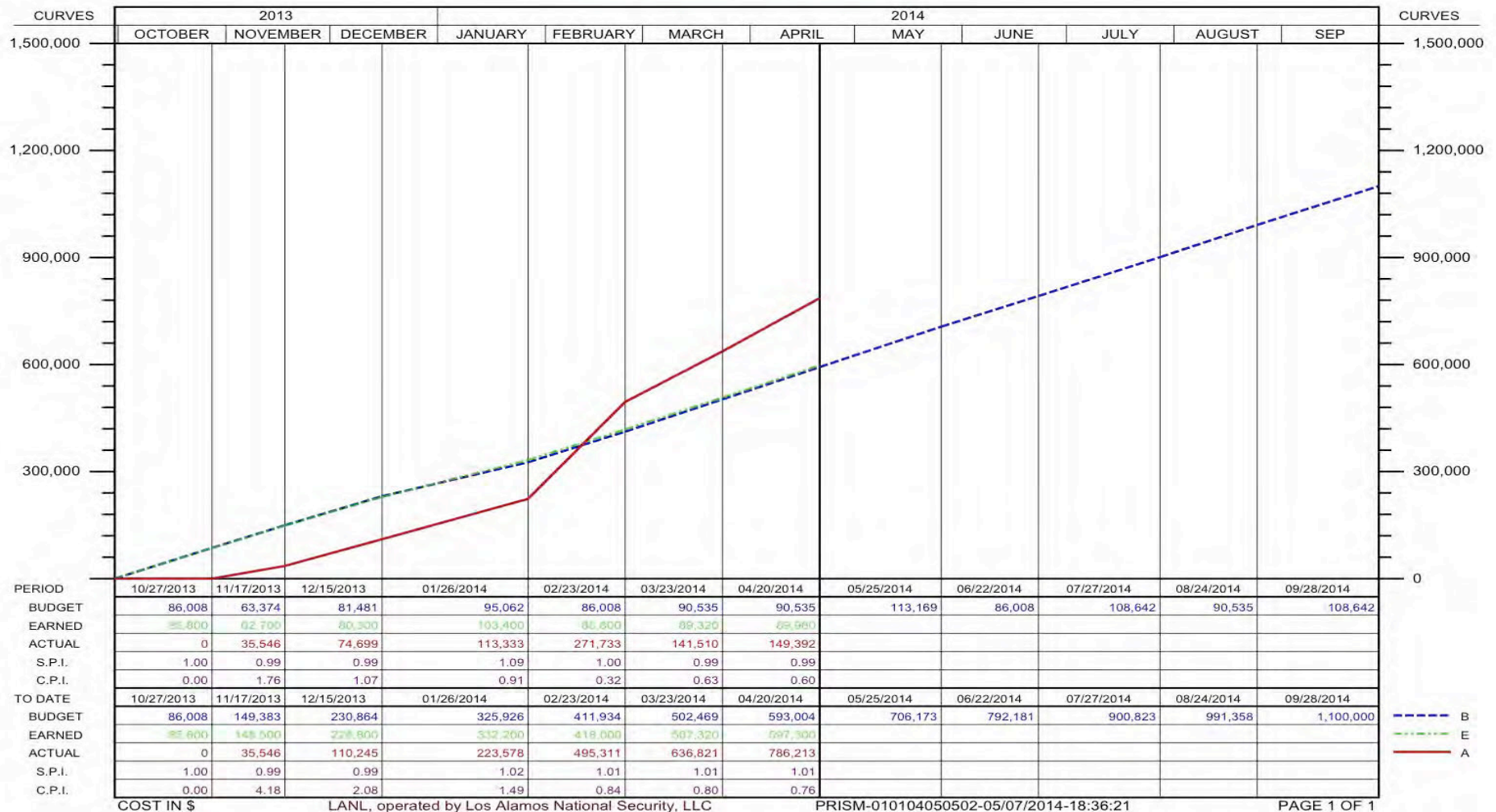
RTBF Recovery



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Waste & Other Landlord Recovery



5.0 Plutonium Experimental Device Fabrication

5.1 Technical Progress

- Resumption requirements were identified to meet the L2 milestone for Z-machine sample fabrication. The procedures and criticality safety documents required were prioritized and are being worked to meet an early June start date required to be successful.

5.2 Equipment

- None.

5.3 Issues

- Work is currently paused.

5.4 Variance Analysis and Recovery Plan

- None

5.5 BCRs

- None

5.6 Earned Value Metrics

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Plutonium Experimental Device Fabrication

