

# DUF6 Update



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Manager  
Piketon Plant

**Tom Robinson**

Manager  
Paducah Plant

**Feb. 29, 2012**

**Waste Management Symposium**

**B&W** conversion  
services.llc

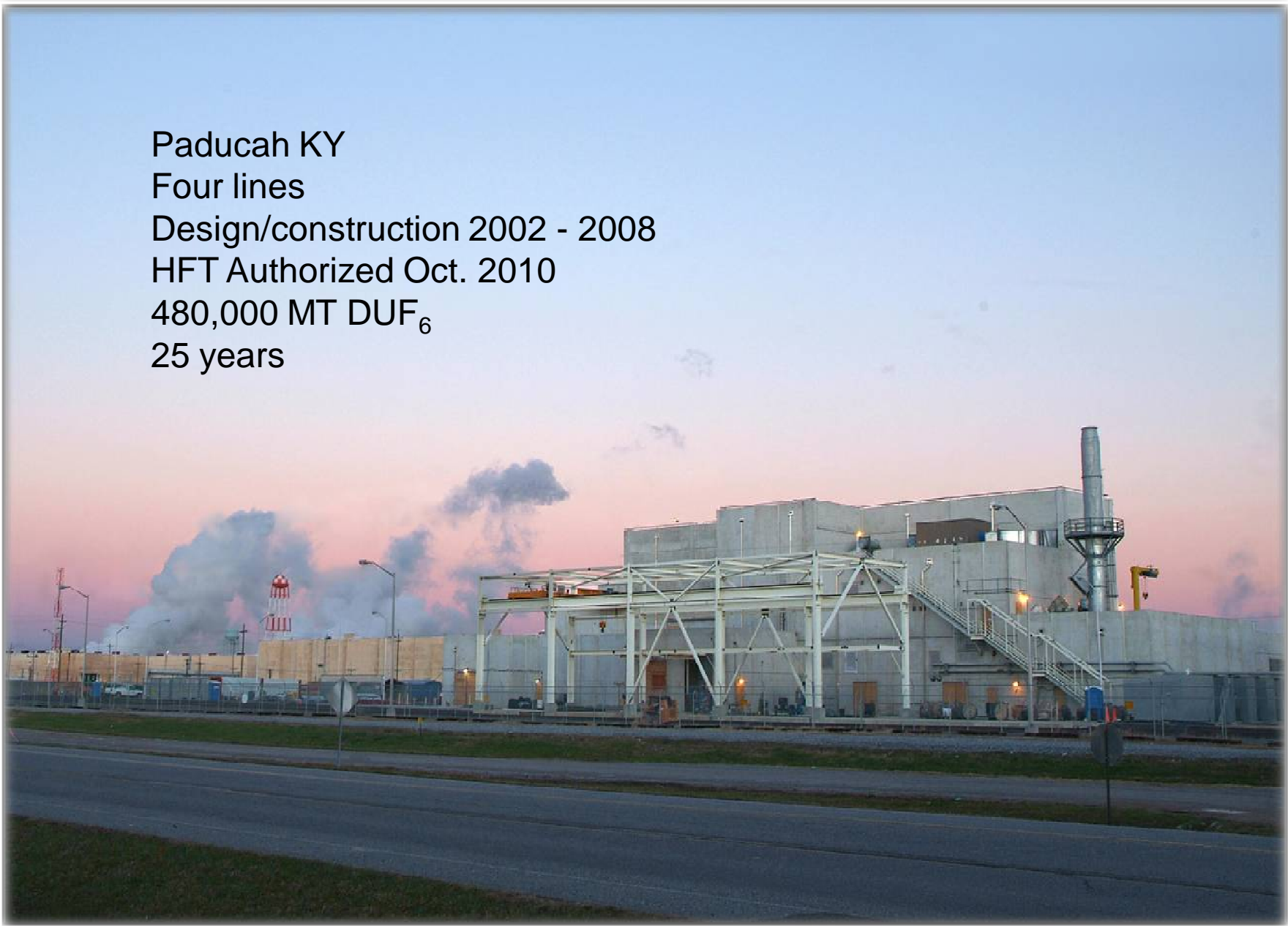
We are the big dogs



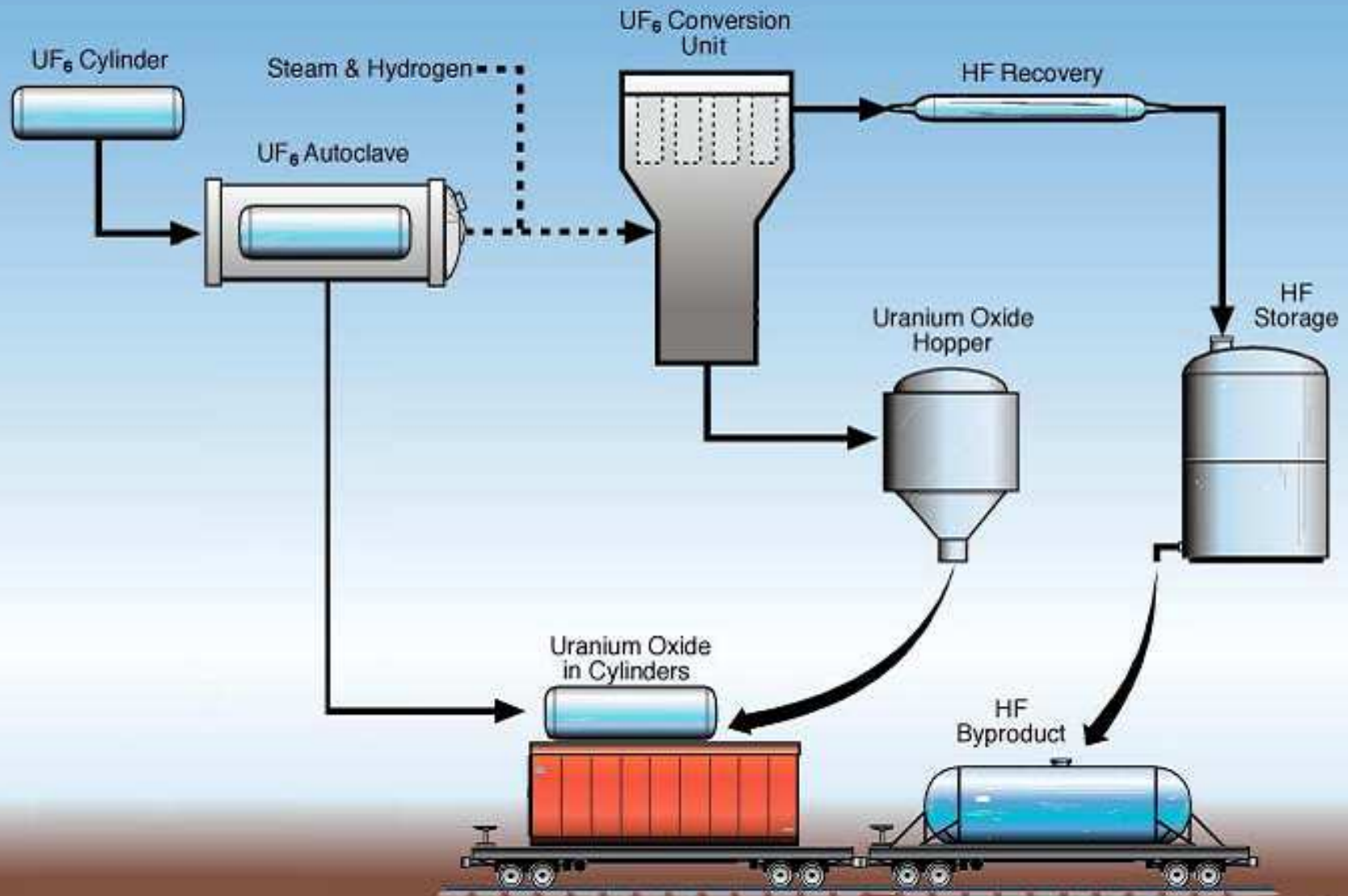
Piketon/Portsmouth OH  
Three lines  
Design/construction 2002 - 2008  
HFT authorized June 2010  
250,000 MT  $\text{DUF}_6$   
18 years



Paducah KY  
Four lines  
Design/construction 2002 - 2008  
HFT Authorized Oct. 2010  
480,000 MT DUF<sub>6</sub>  
25 years



# DUF<sub>6</sub> Conversion Process







Our plants occupy a small portion of the larger DOE sites.

We have 382 employees at three locations.

## Plant status at transition

- Accepted status of completion
  - Operational Readiness Reviews completed
  - Hot Functional Testing started
- Day of involvement
  - President's ES&H Forum
  - Site meetings with team
- Began operations risk assessment
  - Not repeating previous efforts
  - External expert
  - Transition Readiness
- Initiated **Phased Restart**
  - Operations of integrated systems
  - Safety-driven schedule





## A fair description

We are a startup,  
first of a kind  
manufacturing operation,  
building a long-term  
sustainable future.





## The Main Thing:

Operate the plants to convert  $\text{DUF}_6$  and disposition HF

- Safely
- In compliance
- Cost-effectively
- Reliably



## Building a success culture is also important to us.

Transition day  
President's ES&H Forum  
Responsible empowerment presentations  
Senior leadership presence at sites  
High Performing Organization survey  
Nuclear Safety Culture survey

Our core values:

- Safety
- Integrity
- Accountability
- Teamwork
- Excellence
- Leadership

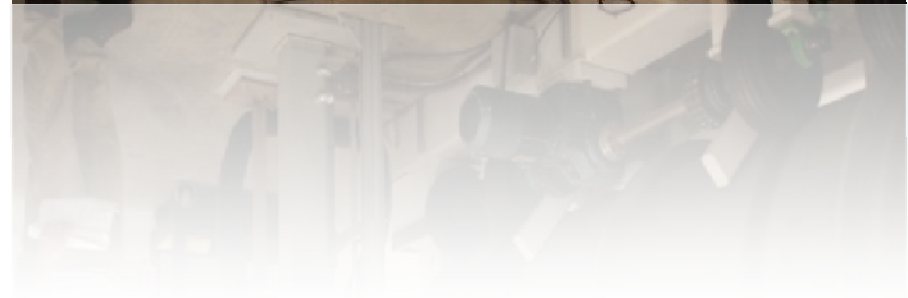
# Phased Restart

- Integrate and operate each line's equipment
- Bring each line to operational status
- Bring each line to fully operational (converting)
- Move to the next line



## Inherent challenges:

- Workforce accustomed to construction and testing
- Plants had never been fully operated
- New manufacturing operation/ typical startup issues
- Many processes to integrate
- No steady state commercial experience
- Bench to production scale
- Integrating three cultures



# Startup Challenges

- Equipment failures
- Spare parts
  - Inventory was thin
  - Quality issues
  - Lines had been cannibalized
- Plant support systems were unreliable
- Training operators and teams for production and preventive maintenance
- Design enhancements



# Things no one knew or anticipated) . . .



**. . . slowed us down.**



**. . . problems that are typical in manufacturing startups.**







## **Our Task:**

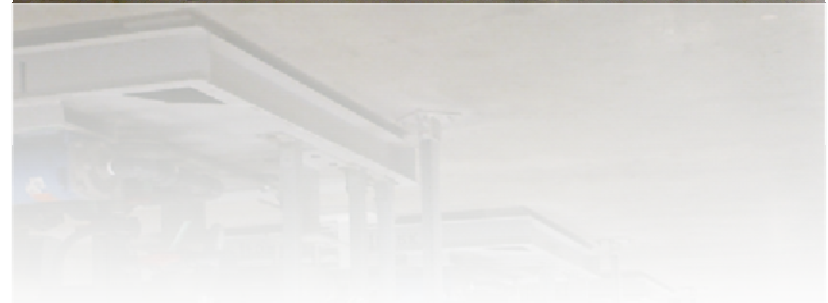
Bring both plants to full commercial production at design throughput by the end of FY 2012.

# We are currently in **partial conversion operational mode:**

Integrate all lines and support systems

Run as long as possible

Keep learning





**Questions?**

