



CLEANUP PROGRESS REPORT

JULY – SEPTEMBER 2000

Fluor Hanford



CONTENTS

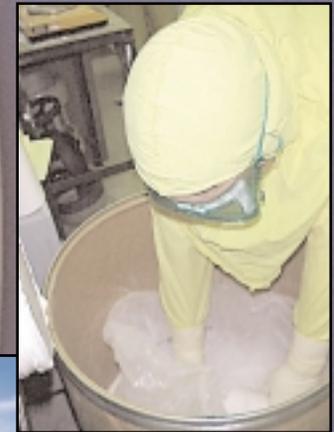
Highlights.....	2
Hanford Site Map	3
Nuclear Material Stabilization.....	4
River Corridor	7
Spent Nuclear Fuel.....	10
Waste Management & Analytical Services.....	13
Fast Flux Test Facility	16
Site Services	17
HAMMER.....	19
Environment, Safety and Health	21
Economic Transition	22
Community Involvement.....	23
Other Hanford Cleanup	24
Contacts.....	25

Prime Contractor:

Fluor Hanford, Inc., A Fluor Global Services Company

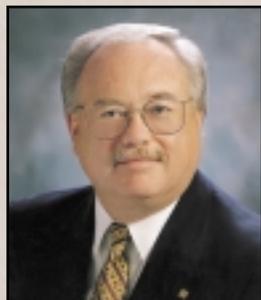
Contributing Subcontractors:

- **DynCorp Tri-Cities Services, Inc.**
- **Numatec Hanford Corporation**
- **Protection Technology Hanford**
- **Waste Management Federal Services of Hanford, Inc.**
- **Westinghouse Safety Management Solutions LLC**



CONTENTS

4TH QUARTER FISCAL YEAR 2000 HIGHLIGHTS



Ron Hanson,
Fluor Hanford President
and Chief Executive Officer

Undaunted by a fire that covered 45 percent of the Site, our workers pushed to safely achieve important cleanup milestones this past quarter:

- Completed extensive tests of systems, equipment and operators to start removing aging spent fuel from the K West Basin this November.
- Now safely stabilizing, neutralizing or packaging for safe interim storage nearly every form of plutonium remaining at Hanford.

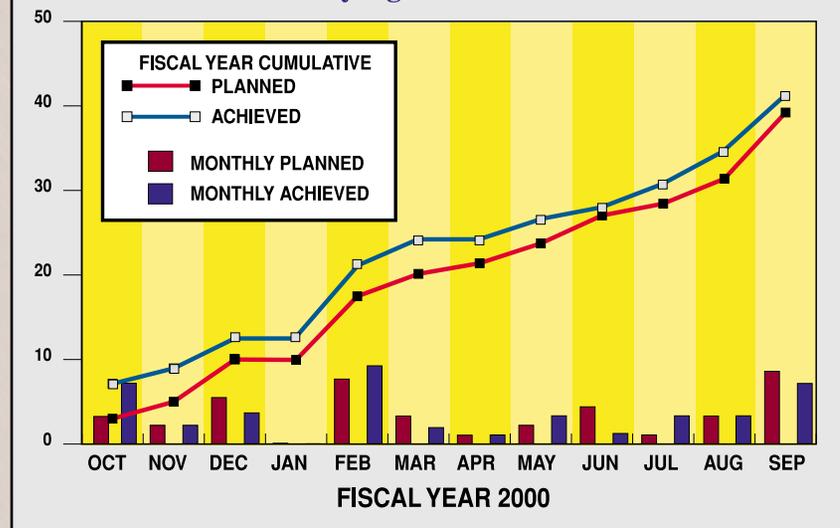
- Shipped the first batches of transuranic waste to the Waste Isolation Pilot Plant in New Mexico. Also beat a Tri-Party Agreement target for low-level waste treatment and direct disposal by more than two years.
- Sent a third of Hanford's excess uranium offsite.

Our 5,000-plus team members have accomplished this while achieving a record nine million hours without a lost away workday injury.

Along with substantial, safe cleanup progress, the Fluor Hanford team has a valuable impact on the quality of life in our community. Page 23 offers a brief glimpse at just a few of those efforts.

As we enter the fifth year of the Project Hanford Management Contract, I look back with pride on our team's professional and personal achievements, and look forward to reporting further progress in the coming 12 months.

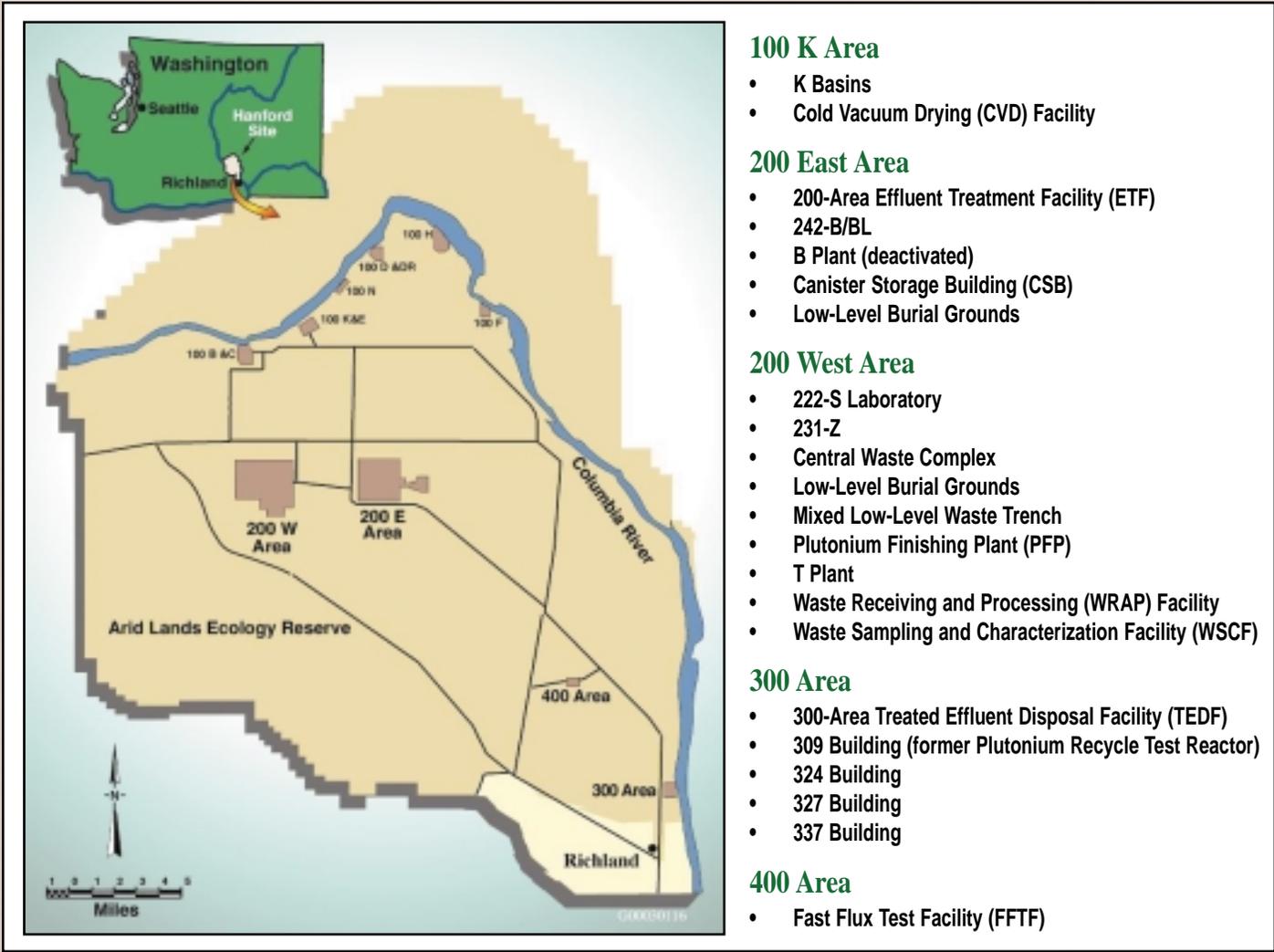
Tri-Party Agreement Milestones



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HANFORD FACILITIES FEATURED IN THIS REPORT



HANFORD SITE MAP

NUCLEAR MATERIAL STABILIZATION

Expectation:

Safely stabilize special nuclear materials at the Plutonium Finishing Plant (PFP) and then deactivate the facility to minimize risk to workers and the environment while decreasing cost to taxpayers.

Status:

- By making several key operational and process improvements, we thermally stabilized more than 650 plutonium-bearing material items this fiscal year. This is a more than four-fold increase over last year's production level. Five small ovens, called muffle furnaces, are now operating for this task.
- Successful partnering with the Department of Energy (DOE) and state regulators enabled early startup of residue packaging. About 3,000 items stored at PFP are already stable, require no further treatment and will be packaged and, ultimately, shipped offsite to the Waste Isolation Pilot Plant in New Mexico.



Packaging of residues is under way at PFP. Here, prior to startup, two certified nuclear chemical operators train a third worker on the packaging process. Inset shows the top of a so-called "pipe-and-go" overpack, which contains a can of plutonium residues inside a 55-gallon drum. The process, developed at DOE's Rocky Flats Site, eliminates unnecessary processing, reduces volume and minimizes dose rates to workers.

NUCLEAR MATERIAL STABILIZATION



NUCLEAR MATERIAL STABILIZATION

Status: (continued)

- Started stabilizing plutonium nitrate solutions, using a magnesium hydroxide precipitation process. The process was customized by Fluor Hanford and the Pacific Northwest National Laboratory, working together, and is used to remove plutonium from the solutions and produce solids that can go right into the muffle furnaces for final stabilization.
- Began operating the first bagless transfer system for packaging stabilized plutonium material. The new method allows the material to be packaged in welded stainless containers without removing it from the glovebox, which is safer for workers and speeds packaging. Construction is under way for a second system, slated to be operational next spring.
- The Defense Nuclear Facilities Safety Board noted substantial improvements in the PFP criticality safety program. Improved areas include independent assessment and oversight, training and better ownership of operations with strong self-assessments.



A DOE facility representative monitors PFP's new solutions stabilization process, while a Fluor Hanford operator retrieves magnesium hydroxide from a barrel. The chemical is added to plutonium solutions in a process that produces solids that can be stabilized by baking in a muffle furnace.

NUCLEAR MATERIAL STABILIZATION

What's Next:

- Continue to work closely with the Westinghouse Savannah River Company, which is fabricating the bagless transfer packaging system, to explore opportunities to accelerate delivery of the second unit.
- Begin efficiently stabilizing PFP's remaining inventory of metals for storage this fall. Rather than convert all of the metals to oxide powder in the muffle furnaces, rust-like oxides on the outside of the metal will be brushed off and the stable metals placed directly into storage cans, using the new bagless transfer system. The brushed-off oxides will then be thermally treated in the furnaces.



In this 1980s-era photo, a Hanford worker safely holds a plutonium "button" produced at PFP for U.S. defense programs. Contrary to popular belief, the material is not always dangerous to touch. In this stable form, the worker only needs thin shielding. But much of PFP's inventory of plutonium must be stabilized before the PFP complex can be cleaned up and dismantled. Several stabilizing methods now under way will continue until the task is complete in mid-2004.

NUCLEAR MATERIAL STABILIZATION



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RIVER CORRIDOR

Expectation:

Safely deactivate contaminated facilities, including several near the Columbia River, to reduce risk to workers and the environment while decreasing cost to taxpayers.

Uranium Disposition:

- Safely shipped 670 metric tons of surplus uranium trioxide powder to a DOE facility in Portsmouth, Ohio. This important element in cleanup of the Hanford Site removed about one third of the excess unirradiated uranium from the Site.

327 Building Deactivation:

- Packaged and shipped 32.5 cubic meters of bulk waste, exceeding our fiscal-year target.
- Packaged and shipped 103 legacy waste buckets to compliant storage, 28 more than planned this year.
- Packaged and shipped to the Central Waste Complex 90 percent of the 297 sample cans of radioactive materials from dry storage.



A framed and inverted funnel-like container called a T-hopper, filled with uranium oxide powder, is loaded for shipment to a DOE site in Portsmouth, Ohio. It took 147 T-hoppers to ship the 670 metric tons of powder. Another 235 metric tons in the form of billets will also be shipped. Of the nearly 1,900 metric tons of surplus unirradiated uranium at Hanford, the powder and billets are the only two forms deemed to have potential market value.



RIVER CORRIDOR

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RIVER CORRIDOR

327 Building Deactivation: *(continued)*

- Packaged and shipped eight fuel pin tubes as planned.
- Packaged and shipped all accountable fissile material from the hot cells.
- Completed interim cleanout of H Cell.

324 Building Cleanout:

- Shipped the first two steel waste-disposal boxes to the Central Waste Complex. Special steel boxes are being used to store grout containers that hold some of the more highly contaminated waste items and pieces of dismantled equipment from the Building's B Cell.
- Completed all 17 planned shipments of grout containers to compliant storage in the 200 Area.
- Shipped 80 of 88 backlog low-level waste drums to the 200 Area.



A steel waste disposal box containing transuranic mixed waste from the 324 Building's B Cell is loaded for shipment to the Central Waste Complex in the 200 West Area.

RIVER CORRIDOR

Other Project Achievements:

- **Project workers achieved 1,250,000 safe work hours without a lost-time injury. The last lost-time injury was in December 1998.**
- **Completed closeout activities 10 days ahead of a state-imposed deadline and transferred full responsibility for surveillance and maintenance of the deactivated B Plant to the environmental restoration contractor, Bechtel Hanford.**
- **200-Area Accelerated Deactivation Project workers devised a comprehensive biological contamination cleanup procedure for two former research facilities, 242-B/BL and 231-Z, one of which had not been used in 30 years. The effort earned kudos from DOE observers and was cited as a major strength by Integrated Environment, Safety and Health Management System assessors.**
- **A Defense Nuclear Facilities Safety Board review of Hanford fire protection programs cited the excellence of those documented for the 324 and 327 facilities.**

What's Next:

- **Meet a key Tri-Party Agreement milestone, removing B Cell's mixed waste and equipment by November 30.**

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RIVER CORRIDOR

SPENT NUCLEAR FUEL

Expectation:

Protect the Columbia River by safely moving more than 2,100 metric tons of deteriorating spent nuclear fuel from aging, wet storage near the river to safe, dry, interim storage on Hanford's central plateau.

Fuel Movement Preparations:

- Completed cold testing in the K West Basin with pieces of pipe designed to resemble irradiated, or spent, fuel.
- Conducted a readiness assessment to begin hot testing of the K West Basin fuel retrieval and water treatment systems. Ready to begin hot testing by “decapping” a select number of the actual canisters containing spent fuel. The tests are part of a phased approach to demonstrate equipment performance and worker proficiency prior to start of fuel movement in November.
- Completed integrated testing of the K West Basin cask transportation system with other key components of the fuel-removal process.
- Installed impact absorbers in the Canister Storage Building tubes where the dried spent fuel will be kept until later shipment offsite.



Impact absorbers like this one being tested were installed in the bottom of the 40-foot tubes at the Canister Storage Building, ready to cushion the multi-canister overpacks (MCOs) containing baskets of dried spent fuel and scrap from the K Basins. A similar impact absorber will be placed on top of each MCO, once it's in the storage tube, to cushion it from the MCO to be stored above it.

SPENT NUCLEAR FUEL

Fuel Movement Preparations: (continued)

- Began our operational readiness review of all K West Basin, Canister Storage Building and Project transportation systems.
- Successfully executed four drying cycles at the Cold Vacuum Drying Facility, using simulated fuel.
- A local vendor fabricated equipment that will be used to dry 15.7 metric tons of spent fuel from the Shippingport (Pennsylvania) Atomic Power Station reactor that has been stored in a pool at Hanford's T Plant since the 1970s. Another vendor will fabricate 18 special canisters to hold this fuel. These are part of efforts, in concert with Fluor Hanford's Waste Management Project, to prepare T Plant for compliant storage of sludge from the K Basins.



A worker at HiLine Engineering in Richland puts the finishing touches on equipment that will be used to dry some non-K Basins spent fuel now stored in a pool at T Plant. This non-K Basins spent fuel will be moved to make way for compliant storage of some of the sludge from the K Basins.

SPENT NUCLEAR FUEL

Safety and Compliance Update:

- Became Hanford's first cleanup project certified by the National Spent Nuclear Fuel Program to satisfy requirements of the Office of Civilian Radioactive Waste Management. This means the Project meets quality assurance standards for ultimate acceptance of the dried fuel at the proposed federal high-level waste repository in Nevada.

What's Next:

- Complete operational readiness reviews leading to the start of fuel movement out of the K West Basin in November.
- Plan modifications in the K East Basin in preparation for fuel movement activities to start in fiscal 2002.



A National Spent Nuclear Fuel Program auditor observes Fluor Hanford machinists ready to stencil newly fabricated spent fuel baskets. DOE rated the Project's quality assurance "effective" in all 20 criteria to handle, dry, monitor and store spent fuel that will one day be sent to a federal high-level waste repository.

WASTE MANAGEMENT & ANALYTICAL SERVICES

Expectation:

Safely treat, store and dispose of solid wastes and liquid effluents; store cesium and strontium capsules; provide waste generator, environmental and waste minimization services; and integrate and provide analytical laboratory services to the Site.

Transuranic (TRU) Waste:

- Safely completed the first three shipments of Hanford TRU waste to the Waste Isolation Pilot Plant (WIPP). About 2,500 shipments will be made over the next 35 years.
- Processed 539 drum equivalents of TRU waste at the Waste Receiving and Processing Facility this fiscal year, well exceeding a goal of 500. “Drum equivalents” are a composite representing the number of containers fully or partially processed by non-destructive examination, non-destructive assay, visual exam, radiography or repackaging.
- Retrieved 437 drums, exceeding our goal of 425, and designated them as either TRU or low-level waste.



DOE Richland's Assistant Manager for Environmental Restoration and Waste Management Beth Bilson, Washington Congressman Doc Hastings, and DOE Richland Manager Keith Klein add their names to a poster commemorating the start of Hanford's TRU waste shipments. Lower photo: the first shipment arrives safely for inspection at its destination in New Mexico.

WASTE MANAGEMENT & ANALYTICAL SERVICES



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WASTE MANAGEMENT & ANALYTICAL SERVICES

Waste Treatment and Disposal:

- Completed treatment or direct disposal of 1,654 cubic meters of mixed low-level waste, exceeding a September 2002 Tri-Party Agreement milestone of 1,644 cubic meters by more than two years.
- Disposed of 8,079 cubic meters of low-level waste from Hanford and offsite generators in the 200-Area low-level burial grounds in fiscal 2000.
- Protected Site groundwater by treating more than 17 million gallons of radioactive or hazardous wastewater this fiscal year at the 200-Area Effluent Treatment Facility.



A 20-ton Category 3 (certified high-integrity) waste container, holding 37 cubic meters of waste, is disposed in Hanford's Mixed Low-Level Waste Trench.

WASTE MANAGEMENT & ANALYTICAL SERVICES

Analytical Services:

- 222-S Laboratory and Waste Sampling and Characterization Facility workers completed analysis and characterization reports this quarter for high-level waste in tanks AZ-101 and AY-102, as well as vapor analysis on tank AZ-101 mixer pump test samples. These efforts support DOE's Office of River Protection.

What's Next:

- Ship mixed low-level waste to the local Allied Technology Group facility for thermal treatment after they complete construction and installation of a new plasma melter.
- Prepare for receipt in the Central Waste Complex of TRU waste generated by DOE's Rocky Flats Site, now being stabilized at Hanford's Plutonium Finishing Plant. The waste will ultimately be sent to the Waste Isolation Pilot Plant.



A plasma melter under construction at the Allied Technology Group (ATG) facility in Richland will thermally treat mixed low-level waste from Hanford. This fiscal year, Fluor Hanford shipped ATG nearly 1,200 cubic meters – 11 percent more than objective – of a different type of mixed low-level waste for non-thermal treatment.

FAST FLUX TEST FACILITY

Expectation:

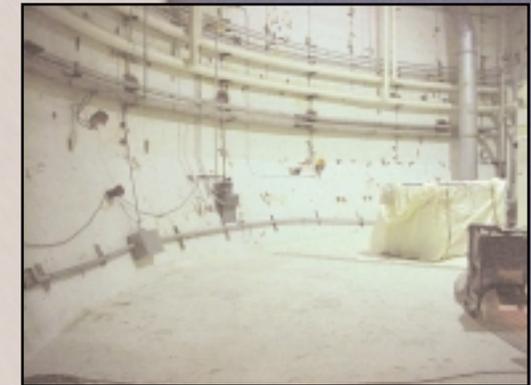
Maintain the Fast Flux Test Facility (FFTF) in a safe and compliant condition. Prevent facility degradation and optimize the ability to respond cost effectively to a DOE mission decision. Continue deactivation of related legacy facilities in the 300 Area.

Deactivation of Legacy Facilities:

- Completed cleanout on the lower levels of the 309 Building containment structure, the former Plutonium Recycle Test Reactor. About 7,000 square feet of surface area were wiped down to remove loose surface contamination. Surfaces were painted at least eight feet above floor level to fix any remaining contamination, minimizing potential for personnel contamination during long-term surveillance. More than 500 cubic feet of low-level waste were collected for disposal.
- Cleaned the residual sodium-potassium alloy from the 337 Building high-bay cooling system. The resulting solution is being disposed of through the 300-Area Treated Effluent Disposal Facility. Successful completion of the task is a result of teamwork among several FFTF organizations and Fluor Hanford subcontractors COGEMA Engineering and Fluor Federal Services.

What's Next:

- A final decision on the future mission of the FFTF is expected in December.



The lower level of the containment structure at the 309 Building is shown before and after cleanup. After a thorough wipe-down, surfaces were painted to fix any remaining contamination in place, which will protect personnel during long-term surveillance of the facility.



FAST FLUX TEST FACILITY

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SITE SERVICES

Expectation:

Provide site services ensuring that the infrastructure, safeguards and security, emergency services, engineering laboratories and corrective action management functions are properly aligned to support Hanford projects.

Spent Nuclear Fuel Basket Fabrication Project:

- Shipped 216 multi-canister overpack (MCO) baskets to the Spent Nuclear Fuel Project two weeks ahead of schedule, bringing the total number fabricated to date to 276. The baskets will hold the K Basins spent fuel throughout the drying and interim storage process, set to commence in November.

Reducing Cleanup Costs:

- Continue to successfully divert legacy equipment destined for disposal as low-level waste by decontaminating it for possible sale or reuse. For example, a 100-ton rail car was prepared for offsite transport, trucked to a vendor in Tennessee, and melted for use in DOE's Shield Block Program at Oak Ridge. Only the wheels of the well car were disposed onsite in the low-level burial grounds. Three other legacy rail cars were readied for transfer to the Tri-City Asset Reinvestment Corporation.



Some of Hanford's legacy equipment is being made available for sale or reuse, avoiding the expense of onsite burial or other methods of disposal. This rail car was transported to Tennessee for use in a DOE program there.



SITE SERVICES

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SITE SERVICES

Fire Response and Recovery:

- A wildfire that burned 164,000 acres, or 255 square miles – including roughly 45 percent of the Site – had just ended as we went to press with our last edition of this report.
- No vital Site structures were damaged, but 11 homes offsite were damaged or destroyed. Prior preparation of waste sites and good fire-prevention measures near Site facilities, along with exhaustive efforts of more than 850 firefighters and many other support personnel, were important factors in limiting damage to the Hanford Site facilities and vegetation.
- Recovery efforts to restore native vegetation in the most severely burned areas are under way.

Other Achievements:

- Fluor Hanford's subcontractor, DynCorp Tri-Cities Services, providing much of the Site's infrastructure services, marked one million hours without a lost workday accident for the third time in three years.



At top, an aerial view shows how close a wildfire came to the FFTF complex. There and elsewhere on the Site, prior preventive measures and the efforts of fire-fighters largely limited damage to vegetation.

VOLPENTEST HAMMER TRAINING AND EDUCATION CENTER

Expectation:

Host, broker and provide training to the Hanford workforce with hands-on use of realistic props and settings to save lives, reduce injuries and increase worker productivity, and serve as a catalyst for regional training.

Hanford Support:

- Delivered 520 classes this quarter for a total of 8,778 student days, including 489 classes for Hanford workers, HAMMER's first priority.
- Began site preparation for a new electrical distribution prop. Hanford electrical workers will one day train at the 40-acre site, a partnership effort of HAMMER, DOE, the Northwest Public Power Association and the Eastern Washington Electric Utility Group.
- Conducted global positioning system equipment training for Fluor Hanford workers through certified instructors from Electronic Data Solutions.



Respiratory training for Hanford workers is now offered in HAMMER's new Training Support Building Annex. HAMMER's cumulative student-day total has reached 85,401 since its opening three years ago.

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HAMMER



VOLPENTEST HAMMER TRAINING AND EDUCATION CENTER

Hanford Support: (continued)

- Collaborated with the state Fire Marshall's Office to obtain International Fire Service Accreditation Congress certification for those who take certain fire-fighter and hazardous-material (HAZMAT) courses at HAMMER.

Federal Support:

- Held Transportation Emergency Preparedness Program "train-the-trainer" sessions in North Carolina, Illinois, Tennessee and New Hampshire.
- Piloted a Web-based National Transportation Program Regulatory Compliance Training course, gathering feedback from national experts. HAMMER plans to launch the course this fall.



Completed a \$250,000 U.S. State Department-funded port-of-entry building. The prop's first students were foreign border officials from Lithuania.

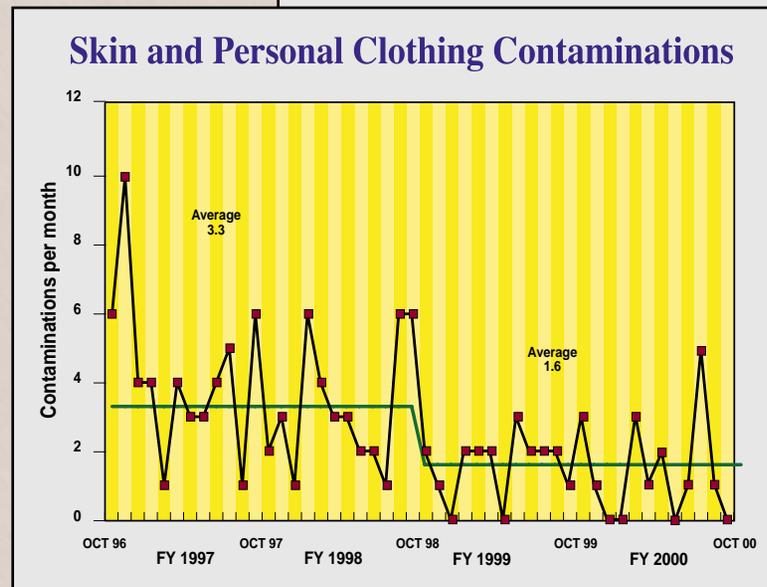
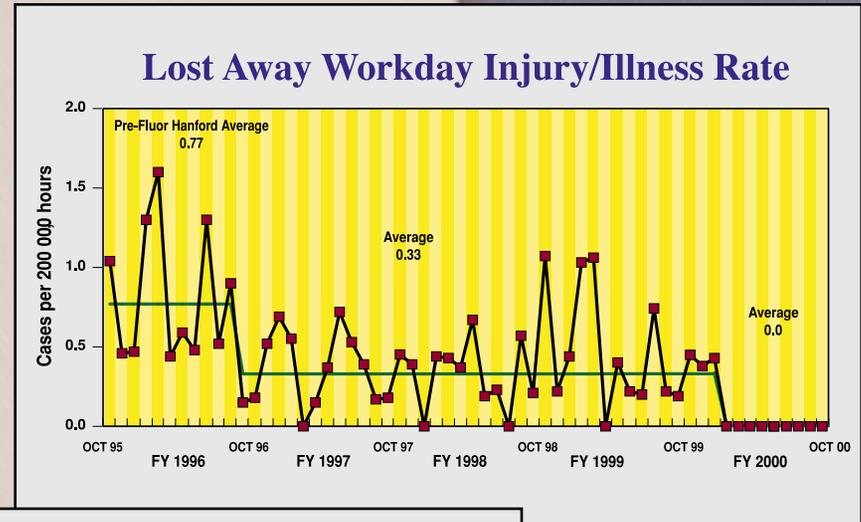
ENVIRONMENT, SAFETY AND HEALTH

Expectation:

Achieve safe, compliant, quality performance by implementing an Integrated Environment, Safety and Health Management System (ISMS).

Status:

- DOE validated the Fluor Hanford team's ISMS implementation two months ahead of the September 30 deadline. Fluor Hanford will assist DOE in hosting a national DOE ISMS workshop in December to spotlight Hanford and other DOE efforts to improve use of ISMS as the foundation for safe performance of work.
- Fire recovery operations are under way to restore about 970 acres of severely burned vegetation adjacent to the 200 West Area to alleviate worker safety issues and potential equipment damage associated with blowing dust. About 170 acres have been reseeded with native grasses and 7,000 sagebrush tublings.



The record string of hours worked without a lost away workday injury surpassed nine million by the end of September. Overall, the Fluor Hanford team has achieved a 70-percent reduction in injuries and illnesses over four years.

The number of personnel contaminations has remained stable at 1.6 per month, more than a 50-percent reduction from the rate in effect two years ago.

ENVIRONMENT, SAFETY AND HEALTH



ECONOMIC TRANSITION

Expectation:

Support economic diversification and growth in the Tri-Cities by collaborating with regional economic development entities.

Status:

- Completed the \$4.1-million Fluor multi-purpose industrial building five months ahead of schedule to accelerate business-attraction activities.
- Local companies continue to benefit from underutilized and excess Hanford equipment. Recently assisted were LaMarr Motor Coach, Sun Signs, Richland Specialty Extrusions, and Applied Geotechnical Engineering & Construction. More than 100 new Tri-City jobs will be created from asset-conversion activities this past quarter.
- Fluor Hanford, DynCorp, Hanford labor unions and Columbia Basin College formed a training alliance to integrate Hanford and the College's resources to create, promote and coordinate local vocational-technical training opportunities.
- Fluor provided financial assistance to the nearby Prosser Economic Development Association and Tri-Cities Enterprise Association to help fund job-creating projects.
- Fluor Global Location Strategies delivered the final four of eight target-industry feasibility studies to the Tri-City Industrial Development Council (TRIDEC). The studies will help TRIDEC market the Tri-Cities to potential industrial clients.



Two dozen companies have looked at the new Fluor multi-purpose industrial facility. Two chose to locate in the Tri-Cities as a result, although at alternate sites. One of them, LaMarr Motor Coach, is expected to create 200 local jobs in the next two years, and has already spun off a subsidiary that is also expected to grow to 200 employees in two years.



COMMUNITY INVOLVEMENT

In addition to safely and effectively performing Hanford cleanup for the Department of Energy, the Fluor Hanford Team contributes to improving the quality of life in the community.

- Invested \$13.5 million in the Tri-Cities since 1997, with more than \$2.9 million going into community-service projects, including \$300,000 in scholarships and education programs.
- Largest single corporate contributor to the local United Way drive and, with our employees' donations, provide more than a quarter of the annual \$4 million budget of the United Way of Benton and Franklin counties.
- Recognized locally, regionally and statewide for superior community service, particularly for leadership in education and literacy programs.
- In the last 18 months, nearly 350 individuals volunteered 4,200 hours on 25 community projects for 18 different organizations as part of the Fluor Community Involvement Team – not to mention the thousands of hours and charitable and civic contributions countless other Fluor Hanford employees make on their own throughout the community.



The Association of Washington Business gave its annual Community Beautification Award to Fluor Hanford for the Children's Center volunteer landscaping effort. The project saved the Center more than \$150,000 and enabled an on-time opening of the much-needed new facility.



COMMUNITY INVOLVEMENT

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OTHER SIGNIFICANT HANFORD CLEANUP

Environmental Restoration Project:

- Completed removal of the fuel storage basin at DR Reactor a month early. Began demolition of the F Reactor basin in August, about two months ahead of the already accelerated schedule.
- Environmental Restoration Contractor (ERC) employees who transport contaminated soil and debris from sites along the Columbia River to the Environmental Restoration Disposal Facility attained four million accident-free miles.
- ERC workers began remediation efforts at N Area with removal of soil and debris from cribs and trenches. Ultimately, 150,000 tons will be removed in the 26-month project.
- A new technology, Small-Diameter Geophysical Logging System, was used at F Area to reduce the amount of soil requiring removal by nearly 200,000 tons, avoiding nearly \$7.4 million in waste disposal costs. Funds to deploy the system came from DOE's Return-on-Investment program.
- A robot was used to characterize a 24-inch-diameter drain line in U Plant. DOE and regulators will use the data, gathered as part of the Canyon Disposition Initiative, to help determine the fate of Hanford's five chemical processing plants – U Plant, B Plant, T Plant, PUREX and REDOX.



A 16-month effort to remove 17,000 feet of steel piping at D and DR reactors was completed one month ahead of schedule. The piping was used from 1950-67 to carry contaminated water underground from the reactors to retention basins.



FOR MORE INFORMATION....



- **U.S. Department of Energy**
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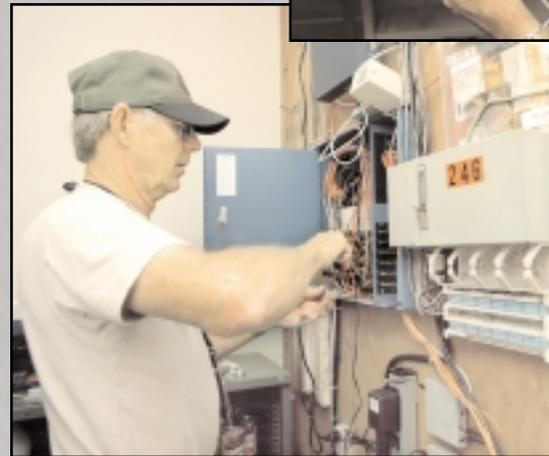
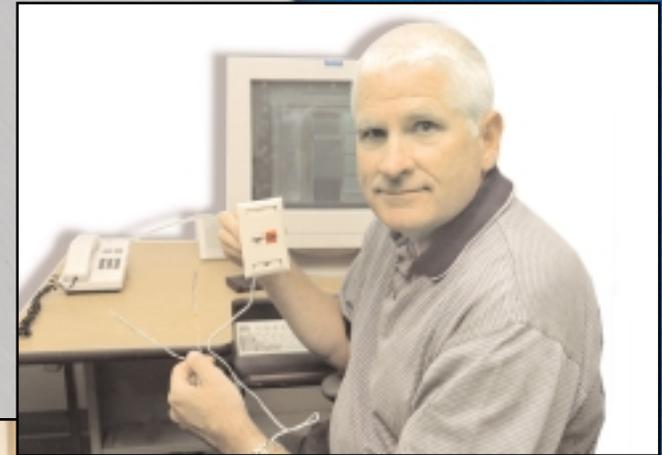
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- Visit the Hanford Homepage at:
<http://www.hanford.gov>

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Previous editions of this report can be viewed at <http://www.hanford.gov/doe/progress/progress.htm>.



On any given day, obsolete network wiring in as many as 215 buildings on Site can interrupt the productivity of up to 3,000 Hanford workers with computer lockups. Fluor Hanford's Chief Information Office teamed with Site labor, subcontractor Lockheed Martin Services, and Qwest Communications on a deceptively simple solution that will save \$1.7 million

in capital costs and reduce the downtime of Site computer users. Rather than upgrading a dual infrastructure for voice and data communications, both voice and data will be transmitted over wiring already in place.



CONTACTS