



# Welcome to the Partners in Excellence Workshop

**UNCLASSIFIED**

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Authority DC/RO and confirmed to be UNCLASSIFIED.  
Name: Bridgette Nelson  
Date: 05/08/2023  
CNS eDC/RO ID: 598470

# Reminders for Our Amarillo and Oak Ridge Participants

- No food or drink
- Please silence your phones and other electronic devices
- Exit doors
- Restrooms
- CNS as well as Small Business Development Center and APEX Accelerator representatives are in attendance to answer your questions

# Reminders for Our WebEx Participants

- You are muted and cannot unmute yourself.
- If you need assistance, please send a message to the Host via Chat.
- Questions should be sent to Host using the Chat option.
- If your audio is not functioning, please call in using the information below.
- Keep these numbers accessible in case you lose connection.

**Phone Number: US Toll +1(415) 527-5035**  
**Webinar Number (access code): 2761 755 8874**  
**Webinar Password: 2c4ePtmitg5**  
**(22437864 from phones and video systems)**

# Safety Is Our Top Priority

## May Is Healthy Vision Month

- Get regular comprehensive dilated eye exams.
- Know your family's eye health history.
- Eat right to protect your sight.
- Maintain a healthy weight.
- Wear protective eyewear when playing sports or doing activities around the home.
- Quit smoking or never start.
- Wear sunglasses that block 99–100% of ultraviolet A (UVA) and ultraviolet B (UVB) radiation.
- Wash your hands before taking out your contacts and properly clean lenses.
- Practice workplace eye safety.



### Resources:

<https://www.cdc.gov/visionhealth/healthyvisionmonth/index.htm>

<https://www.cdc.gov/visionhealth/index.htm>

# Agenda

<i>Time EDT</i>	<i>Time CDT</i>	<i>Agenda Item</i>	<i>Person</i>
2 p.m.	1 p.m.	Welcome & Safety Share	Greta Ownby, Y-12 Small Business Program Manager
2:10 p.m.	1:10 p.m.	Opening Comments	Dr. Richard Tighe, President & CEO of Consolidated Nuclear Security
2:30 p.m.	1:30 p.m.	CNS Projects—LookAhead	Mike Robinson, CNS Vice President, Project Management Stephen Cruz, Pantex Senior Director, Project Management Alan James, Y-12 Senior Director, Project Management
2:50 p.m.	1:50 p.m.	Lithium Processing Facility: The next big project	Brian Rygwelski, Y-12 Construction Operations
3:05 p.m.	2:05 p.m.	Cyber Hygiene for Suppliers	George Haynes, Deputy Chief Information Officer for Y-12 Christopher Ickles, Deputy Chief Information Officer for Pantex
3:25 p.m.	2:25 p.m.	Procurement Forecast	Rick Hillert, Acting Senior Director, CNS Supply Chain Management
3:40 p.m.	2:40 p.m.	Closing Remarks	Rick Hillert
3:45 p.m.	2:45 p.m.	Networking	



## Opening Comments

**Richard Tighe**

*[Richard.Tighe@pxy12.doe.gov](mailto:Richard.Tighe@pxy12.doe.gov)*

President & CEO

Consolidated Nuclear Security, LLC





## **CNS Construction and Design Opportunities**

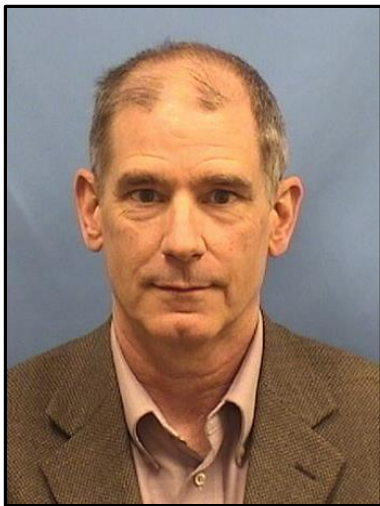
**Michael Robinson**

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Vice President, CNS Project Management







**Stephen Cruz**

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Pantex Senior Director, CNS Project  
Management

**Alan James**

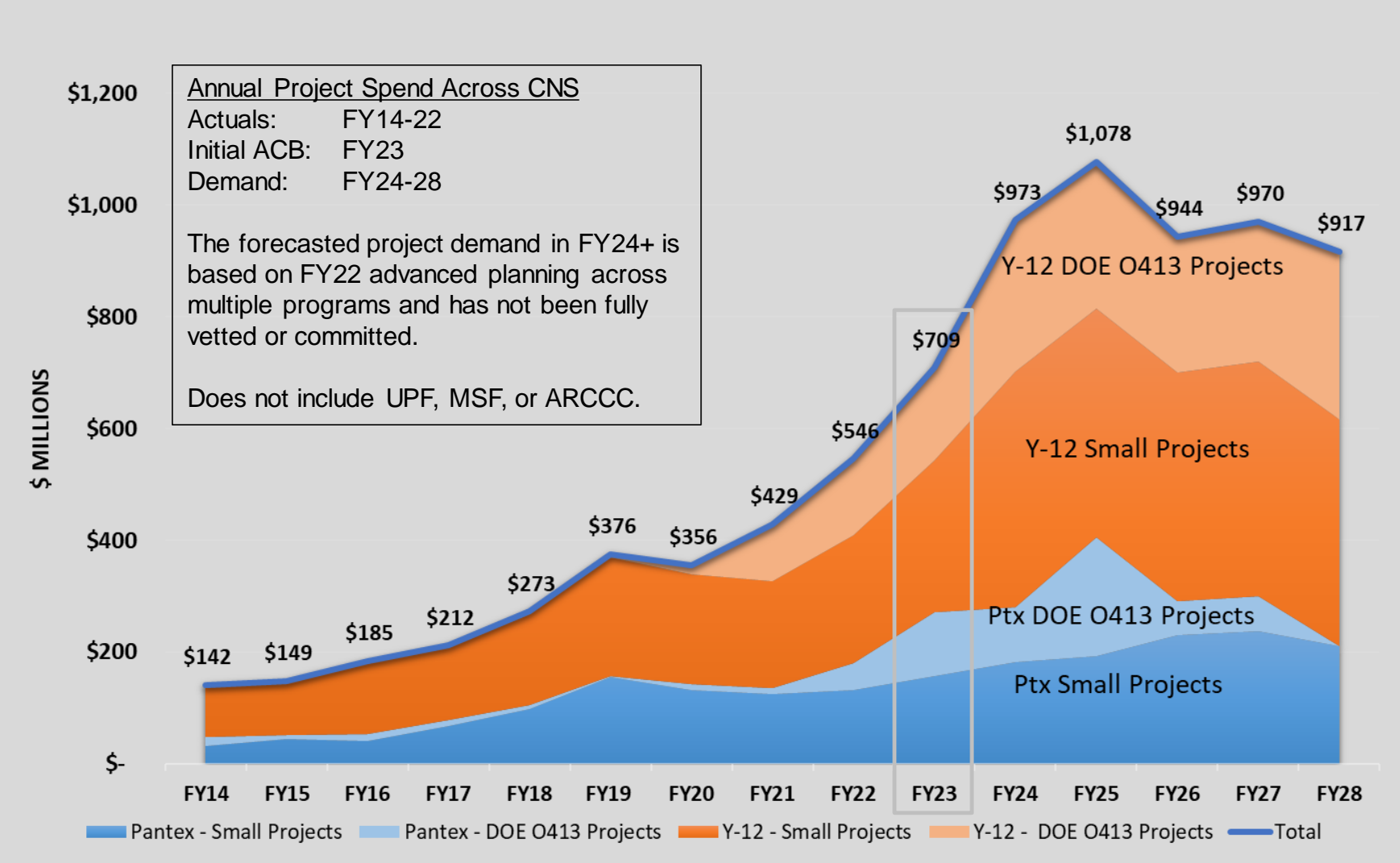
*[Alan.James@pxy12.doe.gov](mailto:Alan.James@pxy12.doe.gov)*

Y-12 Senior Director, CNS Project  
Management



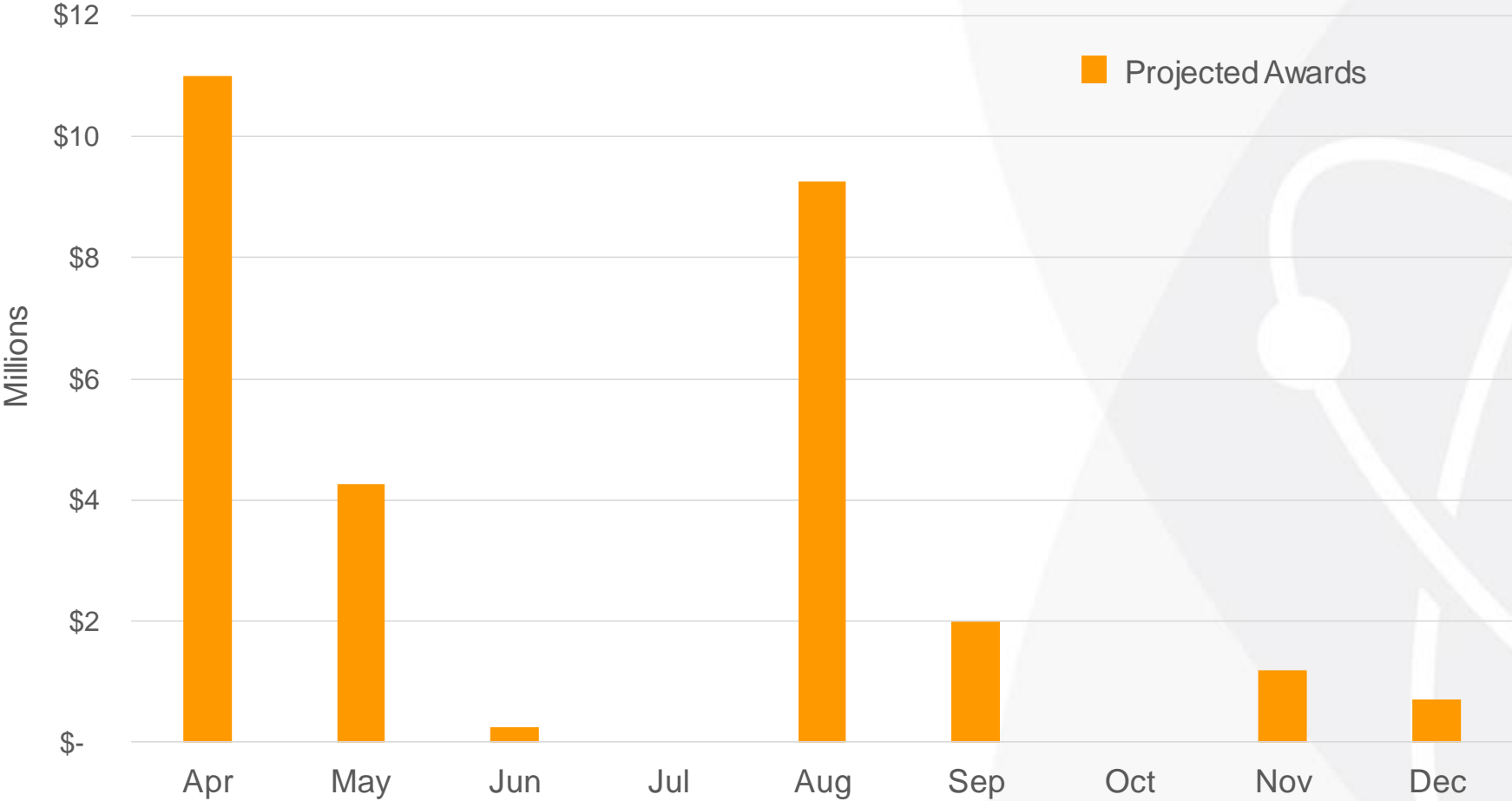


# CNS Project Workload



# Upcoming Awards: Pantex

- FY22 - \$170M Awarded
- \$79M Total Projected for FY23
  - \$52M awarded thru Q2
  - \$27M remaining to be awarded



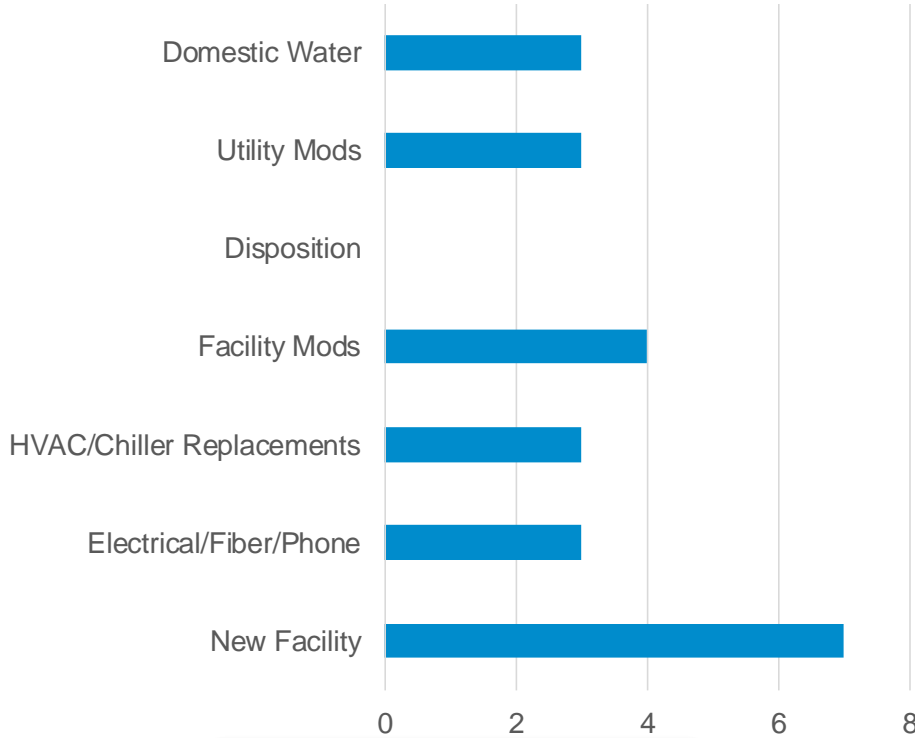
# FY23 Q3-Q4 and FY24 Q1 Awards: Pantex

Project Name	Discipline	RFP Issue Date	\$ Estimation
Pump House and Tank Upgrades	A/E Design	April	\$500K–\$1M
Boiler Controls & UPS	Mechanical	April	\$500K–\$1M
Drainage Improvements	A/E Design	May	\$500K–\$1M
HVAC BOA	A/E Design	June	\$5M–\$10M
Fire Damper Replacements	A/E Design	June	\$100K–\$300K
Rotoclone System Replacement	Equipment	Aug	\$1M–\$3M
FACP Replacement	Construction	Sept	\$100K–\$300k
Production Tooling	Construction Contract	Sept	\$500K–\$1M
Compressed Air System	A/E Design	Oct	\$150K–\$350k
Gas Analysis Facility	Design/Build	Oct	\$10M–\$15M
Heat Treat Oven Facility Modifications	Construction Contract	Dec	\$1M–\$3M
UESC for HVAC/Chiller	Construction Contract	Dec	\$1M–\$3M
Install New HPFL Lines for Tank House	Construction Contract	Dec	\$3M–\$6M

\* Procurement presentation will discuss contacts for RFPs

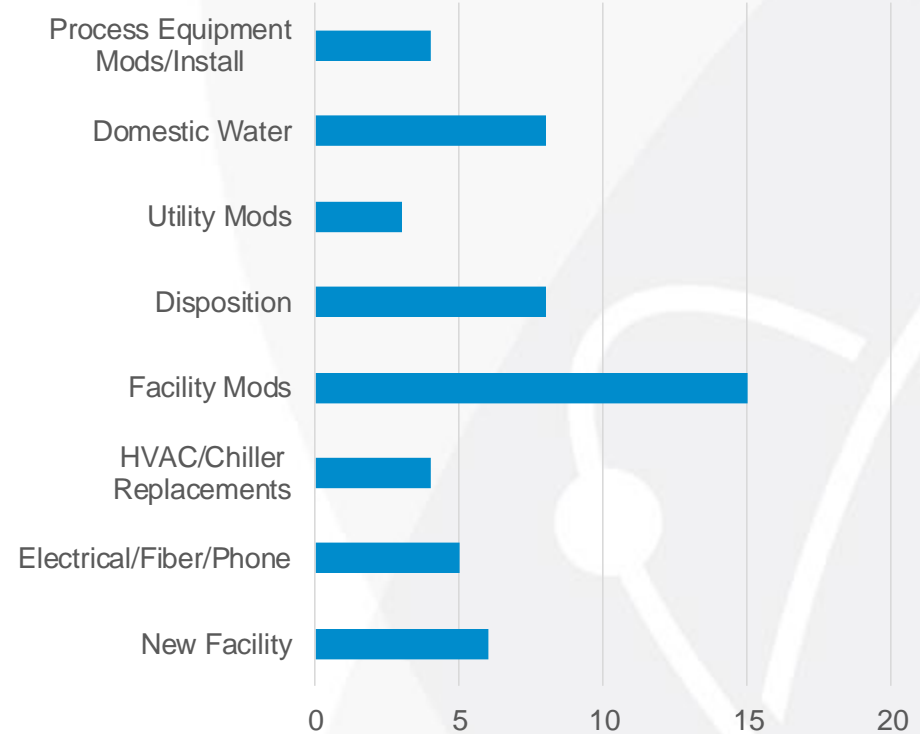
# FY24–26 Projected\* Awards: Pantex

## FY24-26 A/E Designs Opportunities



**Projected Total - 23**

## FY24-26 Construction Opportunities



**Projected Total - 53**

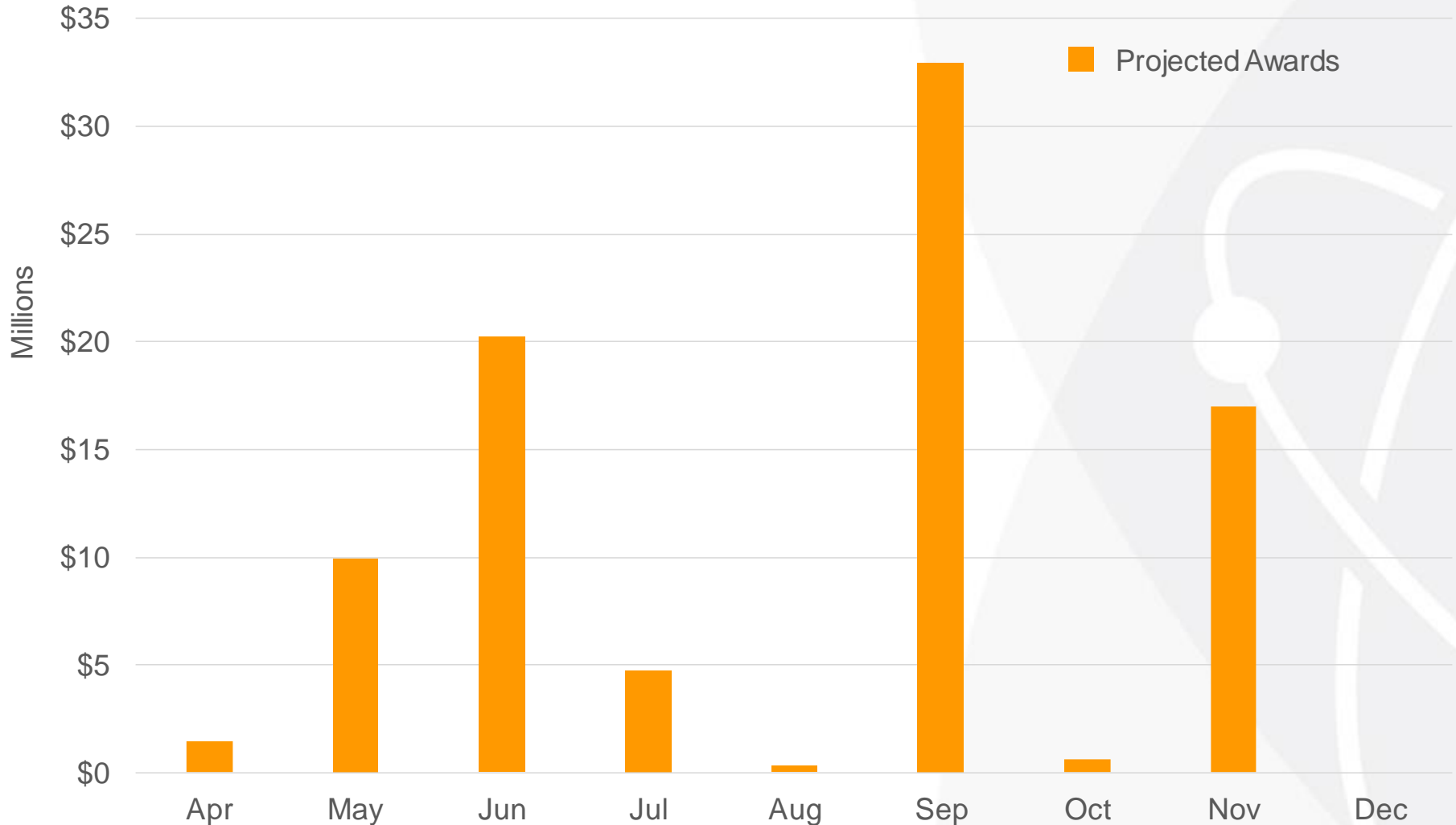
### FY24 Procurements include:

- Expanded Design/Build opportunities:
  - Gas Analysis Laboratory (\$10M–\$15M) RFP projected October 2023
  - Environmental Sampling Facility (\$15M–\$20M) RFP projected April 2024
- HVAC Replacements (\$2M–\$5M)
- Utility Modifications (\$2M–\$5M)

\*Dependent upon funding receipt

# Upcoming Awards - Y-12

- FY22 - \$108M Awarded
- \$121M Total Projected for FY23
  - \$52M awarded thru Q2
  - \$69M remaining to be awarded



# FY23 Q3–Q4 and FY24 Q1 Awards: Y-12

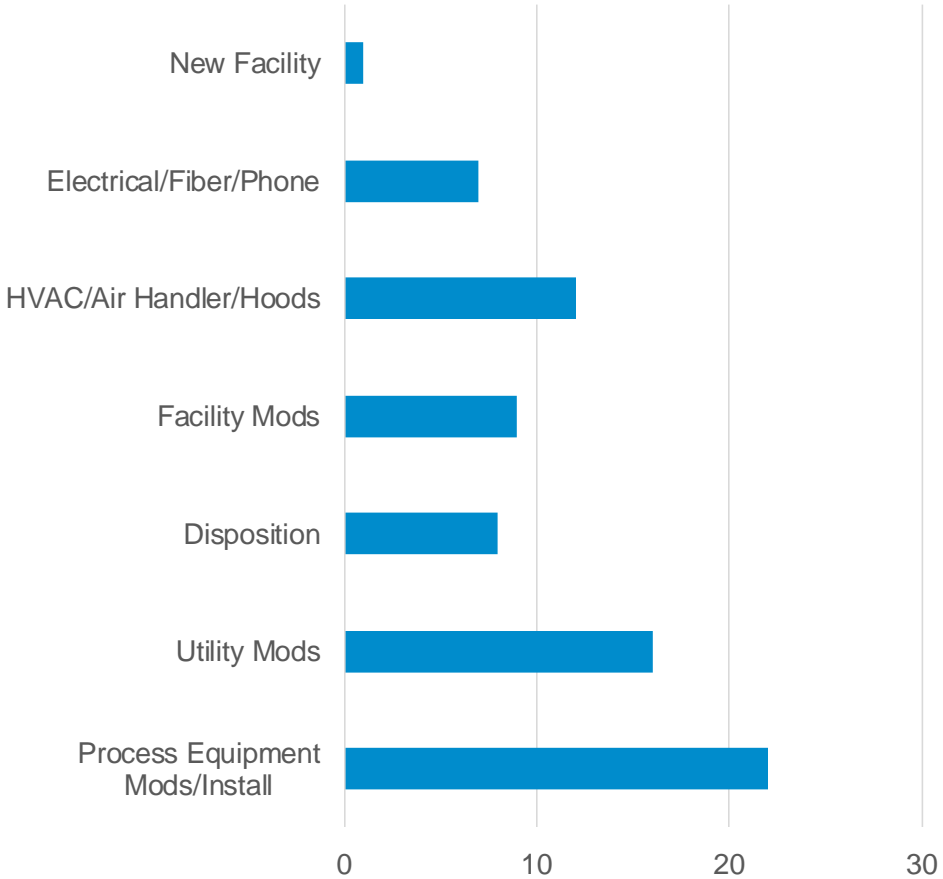
Project Name	Discipline	RFP Issue Date	Range
Elec Panel Feeder Syst	A/E Design	April	\$300K–\$700K
LPF	General Construction	April	\$15M–\$30M
225 kV Microfocus/450 kV CT No. 2	Electrical	April	\$1M–\$3M
Nuclear Magnetic Resonance (NMR)	Equipment Install	May	\$2M–\$3M
South eBeam Welder	Mechanical	May	\$500K–\$1M
General Electrical Upgrade	HVAC	May	\$500K–\$1M
IGPP Building Revitalization	A/E Design	May	\$500K–\$1M
LPF	Equipment	May	\$5M–\$10M
Annealing Furnace Replacement	A/E Design	May	\$10K–\$100K
DUM Foundry Direct Cast Production Furn	A/E Design	May	\$3M–\$10M
Electropolisher	Equipment	May	\$10K–\$30K
Ancillary Facility Dispo Exec.	Disposition	May	\$1M–\$3M
Machine Capability Lathe #2	Lathe	May	\$1M–\$3M
Electropolisher	Equipment	June	\$150K–\$500K
Switchgear 810	A/E Design	June	\$150K–\$500K
Switchgear 810	Electrical	June	\$150K–\$500K
Enhanced Backfill Station	Mechanical	June	\$200K–\$300K

\* Procurement presentation will discuss contacts for RFPs



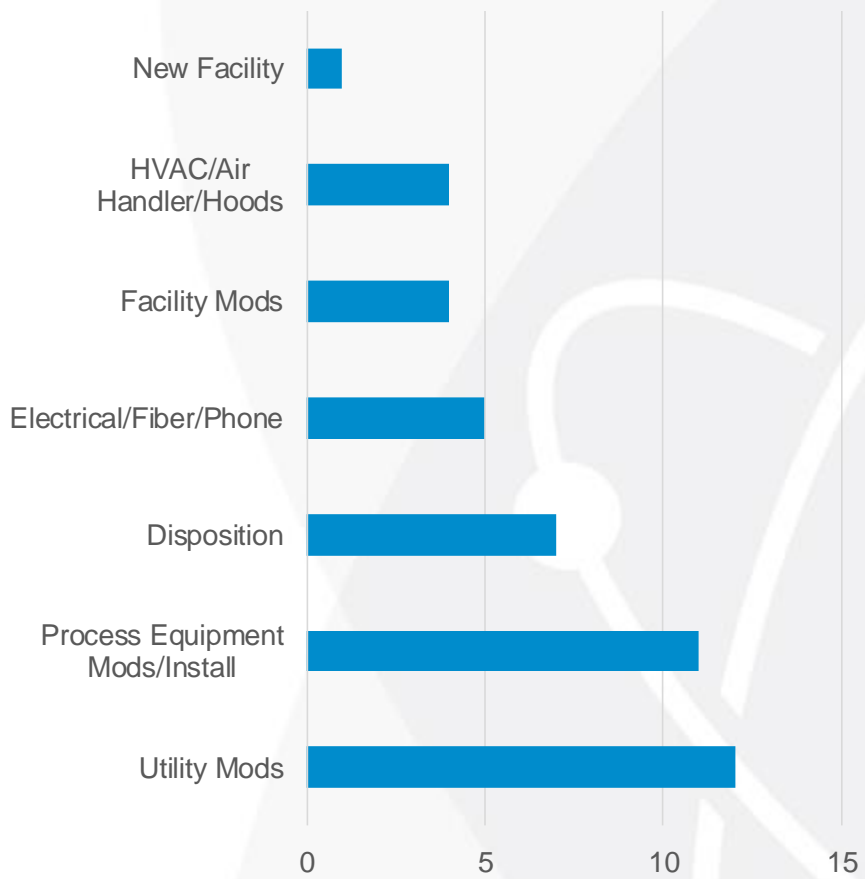
# FY24–26 Projected\* Awards: Y-12

## FY24–26 A/E Design Opportunities



**Projected Total - 75**

## FY24–26 Construction Opportunities



**Projected Total - 44**

\*Dependent upon funding receipt



## Question & Answer

***Please Submit Questions Using Index Cards  
or Via Chat in WebEx (Send to Hosts)***



## **LPF: The Next Big Project**

**Brian Rygwelski**

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Y-12 Construction Operations



## Project Overview — Lithium

- Processing of lithium at Y-12 began in 1950s
- Current lithium processing facility has exceeded its expected life
- Manufacturing process for new Lithium Processing Facility (LPF) is based on the existing process with new technology, safety, and process updates
- Design for new LPF is based on legacy processes and equipment function
- Lithium reacts with water and is flammable

## Project Overview — Scope

- Project situated at Y-12 outside the Protected Area, formerly the Biology Complex
- Constructability and main construction to be completed by the Construction Manager at Risk
  - Onboarded early in design phase
  - Constructability occurring now, main construction awarded later
- Site preparation work for LPF will be performed by separate contractor
- LPF building footprint is approximately 230,000 square feet
- Process areas in concrete building structure; however, not NQA-1
- Multiple exterior chemical storage areas and chemical storage tanks
- Exhaust stacks and HVAC to be mounted on roof of process building

# Site Prep Scope of Work — Overview

- Site Prep ~1.5 years; Q4 2023 to Q1 2025
  - Performing underground and dirt work to include:
    - Storm sewer
    - Cut and backfill to rough grade
    - Pile driving
    - Removal of existing slab and underground tank
    - Establishing detention basins and erosion control
    - Cutting existing bank and raising elevation of the site
    - Installing temporary facilities and utilities for main construction
  - To be performed by subcontractor to CNS
    - Contract to be bid and awarded in 3<sup>rd</sup> quarter 2023
  - Anticipate ~100 craft
    - Most crafts included but large portion to be civil earthmoving-related work
    - Other subcontractors and craft related to trailer installation, temporary utilities, and civil testing.



# Main Construction Scope of Work — Overview

Main Construction, Procurement, and Start-up (~4 years; Q1 2025 to Q4 2028)

- Full scope of construction of LPF including start-up; procurement of all materials/ components/equipment (except GFE); turnover to Company for commissioning
- Performing procurement, construction, and start-up to include
  - Underground utilities
  - Dirtwork to final grade and placement of asphalt/concrete driving surfaces
  - Concrete work to include walls, floor slabs, elevated floor slabs, and roof
    - Concrete will be provided by local dedicated batch plant
  - Mechanical equipment and skid installation
  - Electrical power feed and distribution system
  - Controls and communications systems
  - Utility and process piping systems
    - To include mainly carbon, stainless, and Inconel B31.1 and B31.3 piping
  - HVAC system install and testing & balancing
  - Indirect and all construction support and temporary utility services
- To be performed by Construction Manager at Risk subcontractor to CNS
  - Contract to be bid and awarded in 4<sup>th</sup> quarter 2024

# Main Construction Scope of Work — Overview (Cont'd)

- Main Construction, Procurement, and Start-up (~4 years; Q1 2025 to Q4 2028)
  - Anticipate ~300-600 craft. Craft mix will follow standard industrial facility construction
  - Anticipated subcontracting of scopes from CMAR:
    - Pre-engineered buildings for exterior utility and chemical storage structures
    - HVAC system equipment install plus testing & balancing (including duct work fabrication and install)
    - Fire protection & sprinkler installation
    - Heat tracing
    - Scaffolding
    - Coatings and painting
    - Insulation
    - Electrical testing
    - Quality testing
    - Paving
    - Landscaping
    - Security
    - Trucking and logistics
    - Fuel services
    - Waste management, portable toilet, and haul-off services
    - Crane rental
    - Commissioning services (hydrolazing, air blows, line cleaning, water treatment, etc.)
    - Survey

# Design Features and Largest Scopes of Work

## Fireproofing

- Fireproof walls
  - ~2000 linear ft of 3' thick, ~45' tall reinforced concrete walls
  - Large spread footers required
- Fireproofed structural steel and ceilings
- Multiple 2h- and 4h-rated walls throughout facility

## Independently-supported Bays Between Firewalls

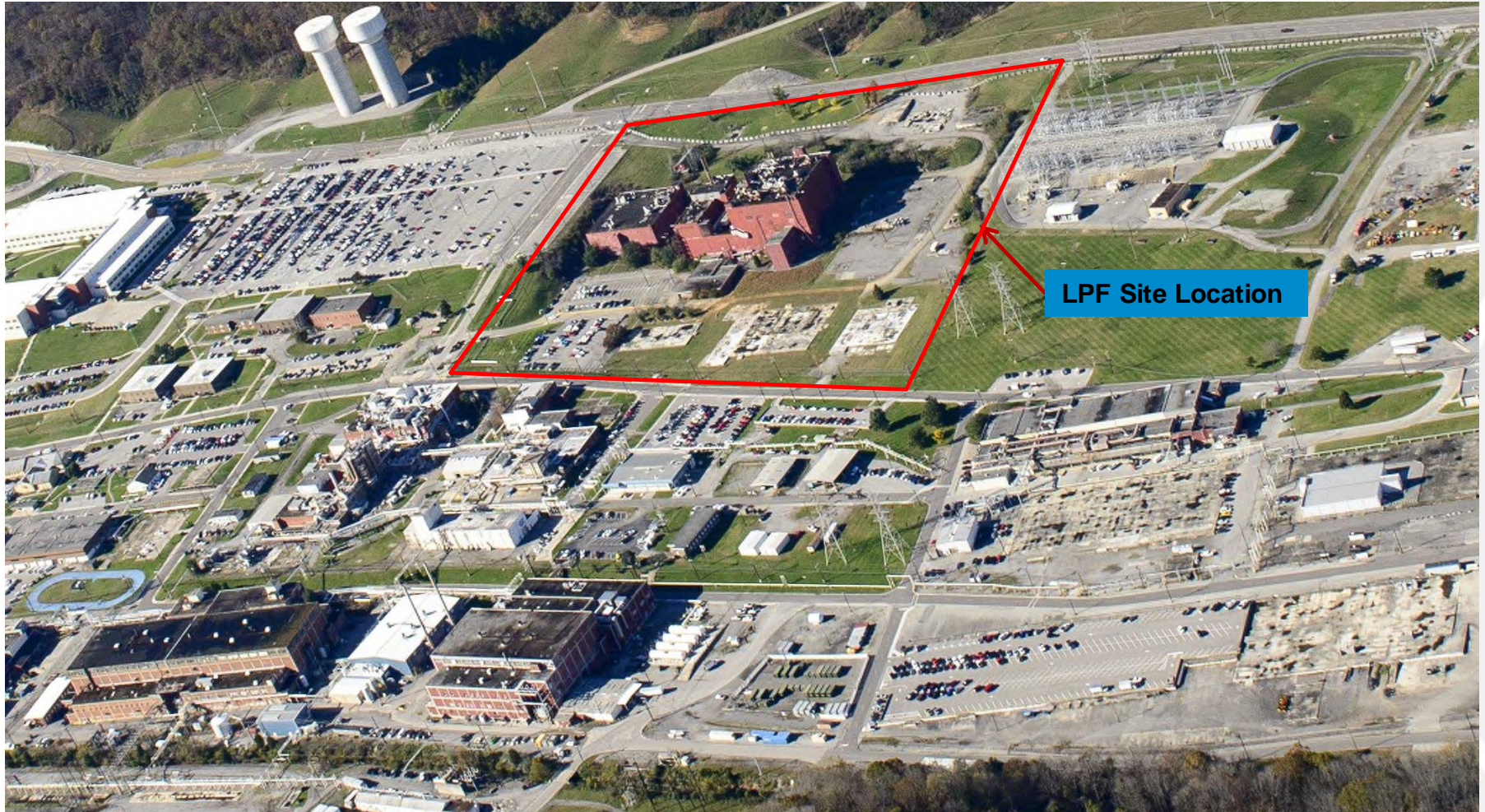
- Steel column-supported metal roof system independent of firewalls

## Specialized Processing Equipment

- Specially designed and purchased Electrolytic Cell, Press, and Crusher Grinder
- Multiple large gloveboxes
- De-humidifying HVAC units and extensive HVAC duct system



# Project Site Information





# Project Site Information



*Figure B-2. Lithium Processing Facility Site Map.*



## Question & Answer

***Please Submit Questions Using Index Cards  
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## Cyber Hygiene Supplier Information



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Deputy Chief Information  
Security Officer - Pantex

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Deputy Chief Information  
Security Officer - Y-12



## What We Will Cover

- Threat Introduction, LinkedIn Risks, and Warning Signs
- Contract Language
- See Something – Say Something

# Threat Introduction

**Who:** Advanced Persistent Threats (APTs) can be nation state actors or skilled hackers targeting our networks

**What:** Millions of intrusion attempts blocked on a daily basis (i.e. network scans, any unsolicited connection attempts).

**How:** APTs target you, Pantex, and Y-12 with data derived from external websites, social media platforms (e.g., LinkedIn, Facebook, Monster, etc.), and other sources to find personal and professional information (e.g., e-mails, names, phone numbers, and company affiliations).

## Some Tools APTs Use

- **Phishing campaigns:** Phishing attacks are the biggest threat against our networks. A successful phishing e-mail can bypass all of the security devices and allow an attack access into the network.
- **Ransomware:** Ransomware is often downloaded through a malicious e-mail link or through a malicious link on a compromised website.
- **Third party/compromised vendors:** if one of our vendors is compromised due to a phishing e-mail or poor cybersecurity practices on their network, this could be a direct window into our network as well. When this happens we have no choice but to block all e-mails and web access to the compromised site until security is restored and validated.

# LinkedIn Vulnerabilities

LinkedIn provides a target-rich environment for cyberthreat actors to gain personal and professional information that is a threat to both you and your company.

**“I keep getting e-mails from people I don’t know..  
How did they find out my information?”**

*The information you post can give cyberthreat actors the ability to target you!*



- In 2023, North Korea used realistically convincing LinkedIn accounts to gather data for cyber espionage.
- In 2022, LinkedIn was reported by “Check Point Research” **as the #1 source for e-mail phishing.**
- In 2021, a data breach of LinkedIn exposed 92% of their users’ personal data.

## LinkedIn Vulnerabilities (continued)

Tactics of threat actors (APTs): Use fake accounts to impersonate known industry professionals or companies and pretend to be recruiters, business partners, salespersons, etc. Fake accounts can include typos, grammatical errors, and various amounts of linked contacts.

Goals of threat actors:

- Primary targets include Human Resources, Finance, Logistics, Security researchers, and IT departments.
- Use e-mail addresses and personal information to launch targeted phishing and spear phishing campaigns designed to specifically steal data, exploit personnel, and/or obtain financial benefits (ransomware).

**Online resumes and personal information found on social media sites can provide significant amounts of Personally Identifiable Information (PII) that allow attackers to craft a tailored attack on you.**

# Warning Signs

1. Unsolicited E-Mails
  - External senders
  - Business partners
2. Suspicious Attachments
  - Unsolicited
  - Can follow familiar naming conventions
3. Suspicious Links
  - External website
  - Website address is slightly “off”
4. Link Directs User to a Website
  - Normally directed to false login page
  - User is prompted to enter login information
  - Credential is harvested
  - May fail the initial login attempt and redirect to legitimate site

# Contract Language - Example

## SECTION G - DATA SECURITY

A. The Seller agrees to utilize administrative, physical, and technical safeguards to protect Company data from unauthorized access, disclosure, acquisition, destruction, or use. The Seller shall maintain an up-to-date Cybersecurity software and firewall for the duration of the time that Seller possesses Company data.

B. In the event of unauthorized access, disclosure, acquisition, release, or use of Company data, or the possibility of an event is suspected, the Seller must provide notification to the Company that a data security incident has or may have occurred as soon as possible but no later than the next business day. Notifications must be sent by email to the Buyer and [noc-soc@pxy12.doe.gov](mailto:noc-soc@pxy12.doe.gov). Contracts containing Personally Identifiable Information (PII) must comply with the reporting requirements detailed in UCN-26608, *UCNI/OUO Information Protection Requirements for CNS Suppliers*.

## Contract Language — Example (continued)

a. Notifications must include as much information at the time of incident. If known, Seller should provide the following information regarding the incident:

- i. a general description (including, but not limited to, relevant details such as products, versions, and configuration settings, ransomware, data exfiltration, PII);**
- ii. name and contact information of the Seller;**
- iii. list of the information that was or may have been affected;**
- iv. the date or estimated date of occurrence;**
- v. how the incident was discovered; and**
- vi. the instigator.**

C. Immediately following a data security incident, the Seller must investigate whether or not the incident impacts the data integrity of their system(s) and take the necessary steps as directed by Company to stop future unauthorized releases of Company data.

D. The Seller also agrees to report any suspicious activity or attempted data attacks, whether they are successful or not.

E. Seller must flow this requirement down to all its lower-tier subcontracts.



# Information Protection Clause: Contractor Offsite Network Requirements

A. For Contractor Offsite Networks, **CNS flows down cybersecurity requirements to subcontractor networks using the framework specified in NIST SP 800-171, Protecting Controlled Unclassified Information in Nonfederal Systems and Organizations.** CNS, as an M&O, acts on behalf of the federal government to evaluate compliance with NIST SP 800-171 requirements and document compliance. Once CNS has concurred the subcontractor network meets the minimum requirements of NIST SP 800-171, CNS clears the CUI data to be released to the subcontractor for processing on the associated network.

B. CNS Cybersecurity executes oversight of Contractor Offsite Networks as follows:

a. CNS evaluates subcontractor networks for compliance with NIST SP 800-171 requirements and **conducts site visits to verify compliance with the submitted site security plan.**

b. CNS requires the following from subcontractors:

- **Notification of any incidents on the associated network within 24 hours**
- **Notification of any changes to the security controls on the associated network within 72 hours**
- **Quarterly updates until all POA&M issues are resolved on the associated network**

# What Should You Do?

- DO check links before you click (hover over link).
- DO check for HTTPS on web sites.
- DO beware of social engineering traps (i.e., LinkedIn).
- DO use password complexity rules:
  - At least 12–14 characters long;
  - A combination of uppercase letters, lowercase letters, numbers, and symbols; and
  - Not a word that can be found in a dictionary or the name of a person, character, product, or organization.
- DO NOT use same password for multiple sites.
- DO NOT use business e-mail for personal work.
- DO NOT open suspicious e-mails: Report them! Use the Forward to Spam button in Outlook to forward to Cyber Operations.
- DO NOT share or openly store passwords.
- DO NOT forget about mobile security (i.e., unsecure apps, default permissions).

**Report it! – See something / Say something  
You could be the next target!**

# See Something — Say Something!

**If you see something, report it!**

1. **During business hours**, contact the Pantex & Y-12 Service Desk at (865.574.4000)
2. **After hours**, if you suspect something suspicious or something does not feel right, directly contact the Network Operations Center/Security Operations Center (NOC/SOC).

**The Network Operations Center/  
Security Operations Center**

**Pantex & Y-12, 24/7 call center for all IT and  
Cybersecurity-observables**

**806.477.6010**

**NOC-SOC@pxy12.doe.gov**



## Question & Answer

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## CNS Procurement Forecast

**Rick Hillert**

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Acting Senior Director, CNS Supply Chain  
Management



## FY23 Procurement Opportunities: Pantex

Project	Comp Type	Est Price	Est Date	Comment
Environmental Chambers & Equipment Skids	Small Business Set-aside	\$250K–\$1M	Q3	Construction
Future Fire Alarm Control Panel	Full and Open	\$1M–\$10M	Q3	Construction
Axis Mill (facility modification)	Small Business Set-aside	\$250K–\$1M	Q4	Construction
CNC Saw Replacement (facility modification)	Small Business Set-aside	\$250K–\$1M	Q4	Construction
Special Tooling Nexus Mill	Small Business Set-aside	\$250K–\$1M	Q4	Equipment
Generator Load Bank	Small Business Set-aside	\$1M–\$10M	Q4	Construction
Rotoclone System Replacement	TBD	\$1M–\$10M	Q4	Construction



## FY23 Procurement Opportunities: Y-12

Project	Comp Type	Est Price	Est Date	Comment
Paving & Road Repair BOA	Full and Open	TBD	Q3	Construction
Argon Annealing Furnace and Conveyor System	Full and Open	\$2M–\$4M	Q3	Equipment
Electrical BOA's	Full and Open	TBD	Q3	Construction
LPF Site Prep	Full and Open	\$10M–\$20M	Q3	Construction
Fabricate 10 Liter Steel Tank	Full and Open	>\$250K	Q3	Equipment
Backfill Station	Full and Open	\$100K–\$300K	Q3	Equipment
PLC/HMI Hardware/Software Award	Full and Open	\$400K–\$500K	Q3	Equipment

## Additional Forecast Details

CNS Procurement provides the forecast of subcontracting opportunities for FY2023.

- These requirements may be revised or canceled, depending on program budget funding or departmental needs.

### CNS Forecast Site

<https://www.y12.doe.gov/suppliers/procurement/subcontracting/subcontracting-forecasts/cns-forecast>

If you have questions or would like to express an interest in any of the opportunities listed in the previous slides, contact:

procurement@pantex.com (Pantex)

procurement@y12.doe.gov (Y-12)

## Working with CNS

- All offerers must be registered with the System for Award Management (SAM.) Offerers not registered will be ineligible for award.
  - SAM registrations have to be renewed annually
  - To register or renew: <https://www.sam.gov> or call: (866) 606-8220
  - For assistance (create an incident report or initiate a live chat) visit the Federal Services Desk at: <https://www.fsd.gov>.
  - Initiate registration renewal no later than one month before expiration.
  - To avoid delays, register/renew via sam.gov, not a third party.
  - Free assistance is available through local APEX Accelerator (formerly Procurement Technical Assistance Center) and Small Business Development Centers.
- Ensure your company information is in the Small Business Administration Dynamic Small Business Search
- Provide a one-page capability statement
- Visit the CNS, Pantex, and Y-12 websites
- Know the CNS mission and how your business can support it



## Question & Answer

***Please Submit Questions Using Index Cards  
or Via Chat in WebEx (Send to Hosts)***



## Closing Comments

**Rick Hillert**

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Acting Director, CNS Supply Chain Management



# Small Business Program Managers

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