



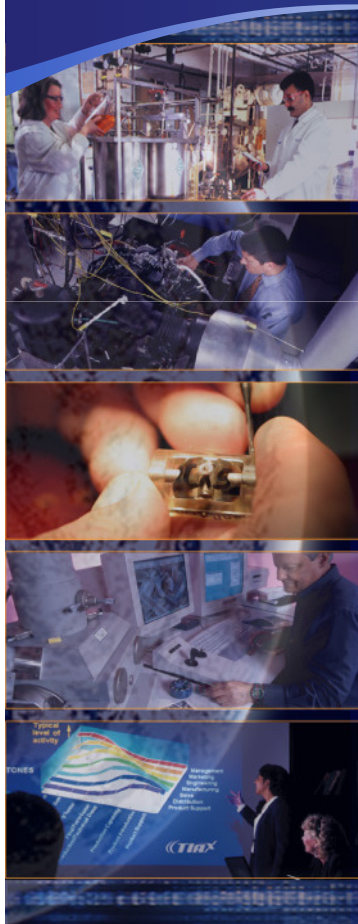
Direct Hydrogen PEMFC Manufacturing Cost Estimation for Automotive Applications

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Overview

The 2009 & 2010 PEMFC cost analyses are based on updates to the bottom-up high-volume stack and BOP cost models developed in 2008.

Timeline

- ◆ Base Period: Feb 2006-May 2008
 - » 100% complete
- ◆ Option Yr 1 & 2: May 2008-Feb 2010
 - » 100% complete
- ◆ Option Yr 3: Feb 2010-Feb 2011
 - » 15% complete

Barriers

- ◆ Barriers addressed

- » B. Cost

	Cost Targets (\$/kW)		
	2009	2010	2015
Fuel Cell System	60	45	30
Fuel Cell Stack		25	15

* Manufactured at volume of 500,000 per year.

Budget

- ◆ Total project funding
 - » Base Period = \$415K
 - » No cost share
- ◆ FY08 = \$50K
- ◆ FY09 = \$51K
- ◆ FY10 = \$92K

Partners

- ◆ Project lead: TIAX
- ◆ Collaborate with ANL on system configuration and modeling
- ◆ Yong Yang¹ : mfg. cost modeling
- ◆ Feedback from Fuel Cell Tech Team, Developers, Vendors



Objectives

	Objectives
Overall	<ul style="list-style-type: none"> ◆ Bottom-up manufacturing cost assessment of 80 kW direct-H₂ PEMFC system for automotive applications
2009	<ul style="list-style-type: none"> ◆ High-volume (500,000 units/year) cost projection of ANL 2009 PEMFC system configuration assuming an NSTFC-based MEA and a 20 µm PFSA membrane <ul style="list-style-type: none"> ➤ Bottom-up manufacturing cost analysis of <i>both</i> stack and BOP ➤ Sensitivity analyses on stack and system parameters ◆ Independent peer review of cost analysis methodology and results ◆ Comprehensive report on the 2008 PEMFC cost analysis (high-volume, bottom-up stack and BOP cost)
2010	<ul style="list-style-type: none"> ◆ Preliminary high-volume (500,000 units/year) cost projection of ANL 2010 PEMFC system configuration assuming an NSTFC-based MEA and a 20 µm reinforced PFSA membrane <ul style="list-style-type: none"> ➤ Metal bipolar plates ➤ Stack conditioning



BOP = Balance-of-Plant

NSTFC = Nano-Structured Thin Film Catalyst

MEA = Membrane Electrode Assembly

PFSA = Perfluorosulfonic acid

Background

Over the past year, we updated the PEMFC cost assessment based on input from ANL on the 2009 stack performance parameters.

- In 2009, we updated the system configuration, stack performance assumptions and stack and BOP component specifications based on ANL modeling results
 - Based cost assessment on ANL 2009 PEMFC system configuration assuming an NSTFC MEA and a 20 μ m PFSA membrane
 - Updated bottom-up cost assessment of stack, balance of stack and stack assembly
 - Replaced EWH by planar MH for cathode air and anode fuel humidification
 - Costed HT & LT radiators, fans, coolant pumps; air precooler; flow orifice for CEM
 - Participated in independent peer-review of our cost analysis methodology and results
 - Submitted a comprehensive report to DOE on our 2008 PEMFC cost analysis
- In 2010, we are working on changes based on ANL 2010 PEMFC system:
 - NSTFC MEA with 20 μ m reinforced PFSA membrane
 - Metal bipolar plates – thermal nitrided, Au-Nanoclاد
 - Non-woven carbon paper GDL
 - Eliminate anode fuel humidifier, pleated planar MH for cathode air humidification
 - Other BOP updates pending ANL input
 - Stack conditioning pending funding authorization from DOE



MEA = Membrane Electrode Assembly
EWH = Enthalpy Wheel Humidifier
PFSA = Perfluorosulfonic acid

NSTFC = Nano-Structured Thin Film Catalyst
MH = Membrane Humidifier

Approach Costing Methods

We used a bottom-up approach to determine high-volume (500,000 units/year) manufacturing cost for the major stack and BOP components.

Stack Components	BOP Components
<ul style="list-style-type: none">• Catalyst Coated Membrane• Electrodes• Gas Diffusion Layer (GDL)• Membrane Electrode Assembly (MEA)• Bipolar Plates• Seals <ul style="list-style-type: none">» Develop production process flow chart for key subsystems and components» Obtain raw material prices from potential suppliers» Estimate manufacturing costs using TIAX cost models (capital equipment, raw material costs, labor rates)	<ul style="list-style-type: none">• Radiators (HT, LT)• Cathode Planar Membrane Humidifier (MH)• Anode Planar MH• Compressor-Expander-Module (CEM)• H₂ Blower <ul style="list-style-type: none">» Develop Bill of Materials (BOM)» Obtain raw material prices from potential suppliers» Develop production process flow chart for key subsystems and components» Estimate manufacturing costs using TIAX cost models and Boothroyd Dewhurst Design for Manufacturing & Assembly (DFMA®) software

- We used literature/experience-based estimates for stack components such as sensors, controls, control board and wire harness. We scaled quotes/catalog-based estimates for BOP components such as air precooler, flow orifice, coolant pumps, radiator fans, H₂ ejectors, valves/regulators and piping/fittings.
- We used the TIAX technology-based bottom-up cost model for the HT/LT radiators, and cathode/anode planar MH, while we used the DFMA® bottom-up manufacturing cost model for the CEM and H₂ blower.



Progress 2009 Stack Cost Scenarios

The high-volume manufactured cost of the 2009 PEMFC stack for six scenarios^{1, 2} is estimated to range between \$19/kW and \$40/kW.

Key Cost Assumptions		2009 Stack Scenarios ^{1, 2}					
		S1	S2	S3	S4	S5	S6
System net power	kW _e	80					
Stack gross power ²	kW _e	91.5	92.1	92.3	91.6	91.8	92.1
Cell voltage (rated power) ²	V	0.729	0.690	0.659	0.736	0.693	0.661
Stack gross power density ²	mW/cm ²	479	658	789	451	701	886
Pt loading (total) ²	mg/cm ²	0.25			0.15		
Stack Pt content	g/kW _{gross}	0.52	0.38	0.32	0.33	0.21	0.17
System Pt content	g/kW _{net}	0.60	0.44	0.37	0.38	0.25	0.20
Stack efficiency (rated power) ²	% LHV	57.4	54.5	52.1	57.4	54.6	52.1
System efficiency (rated power) ²	% LHV	50.0	47.3	45.0	50.0	47.3	45.0
System voltage (rated power)	V	300					
System active area	m ²	19.1	14.0	11.7	20.3	13.1	10.4
Stack cost³	\$/kW_{net}	40.2	30.0	25.9	33.2	22.3	18.7

¹ All scenarios assume a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, 20 µm PFSA membrane, and stack operating conditions of 90 °C and 2.5 atm.

² Based on stack and system modeling results by ANL for 2009 PEMFC system: R. K. Ahluwalia and X. Wang, March 6-July 21, 2009.

³ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).



We developed stack specifications for the 2009 baseline scenario S5, consistent with the performance predicted by ANL's stack and system modeling.

TIAX Assumptions	Units	2005 ¹	2007 ^{2,3}	2008 ⁴	2009 ⁵
Number of stacks per system	#	2	2	2	2
Number of cells per stack	#	231	221	219	217
Active area to Total area	%	85	85	85	85
Active area per cell	cm ²	323	260	277	304
Cell pitch	cells/inch (cells/cm)	9.55 (3.76)	9.75 (3.84)	9.75 (3.84)	10.57 (4.16)
System voltage (rated power)	V	300	300	300	300

¹ E.J. Carlson et al., Cost Analysis of PEM Fuel Cell Systems for Transportation, NREL/SR-560-39104, Sep 30, 2005

² R.K. Ahluwalia and X. Wang, Reference Fuel Cell System Configurations for 2007: Interim Results, ANL, Feb. 6, 2007

³ R.K. Ahluwalia, X. Wang and R. Kumar, Fuel Cell Systems Analysis, DOE Hydrogen Program Review, May 15-18, 2007

⁴ R. K. Ahluwalia, X. Wang and R. Kumar, Fuel Cell Systems Analysis, 2008 USDOE Hydrogen Program Review, Arlington, VA, June 9-13, 2008

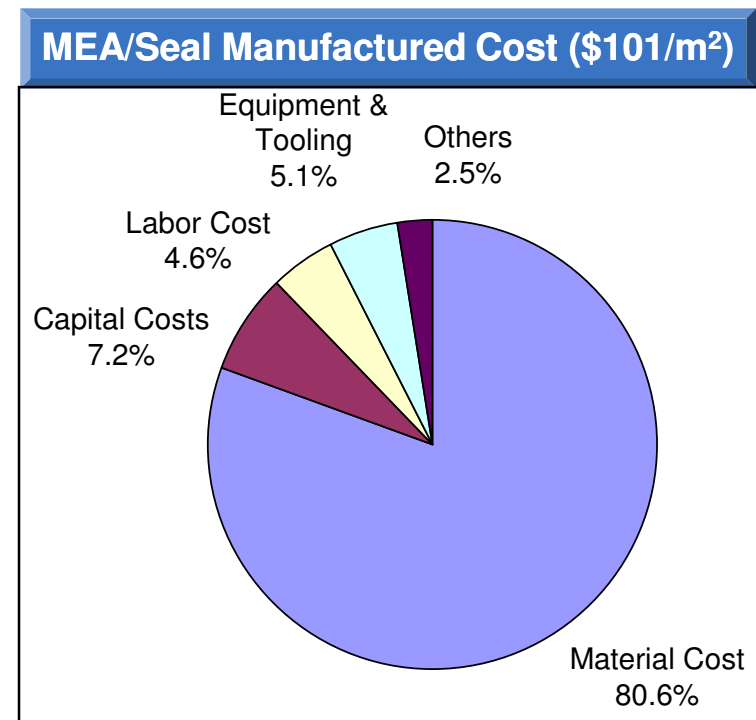
⁵ R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

Using S5 as the 2009 baseline scenario, we estimated that the MEA and seal together cost ~\$101/m², of which material costs represent ~81%.

Manufactured Cost ¹	MEA (\$/m ²)	Frame Seal (\$/m ²)
<i>Material</i>	76.70	
- Membrane	- 9.77	
- Electrode	- 58.69	4.78
- GDL	- 8.23	
<i>Capital Cost</i>	6.18	1.14
<i>Labor</i>	3.85	0.81
<i>Tooling & Equipment</i>	4.21	0.95
<i>Other²</i>	2.03	0.45
Subtotal	92.97	8.13
Total	101.11	

¹ Manufactured cost on an active area basis

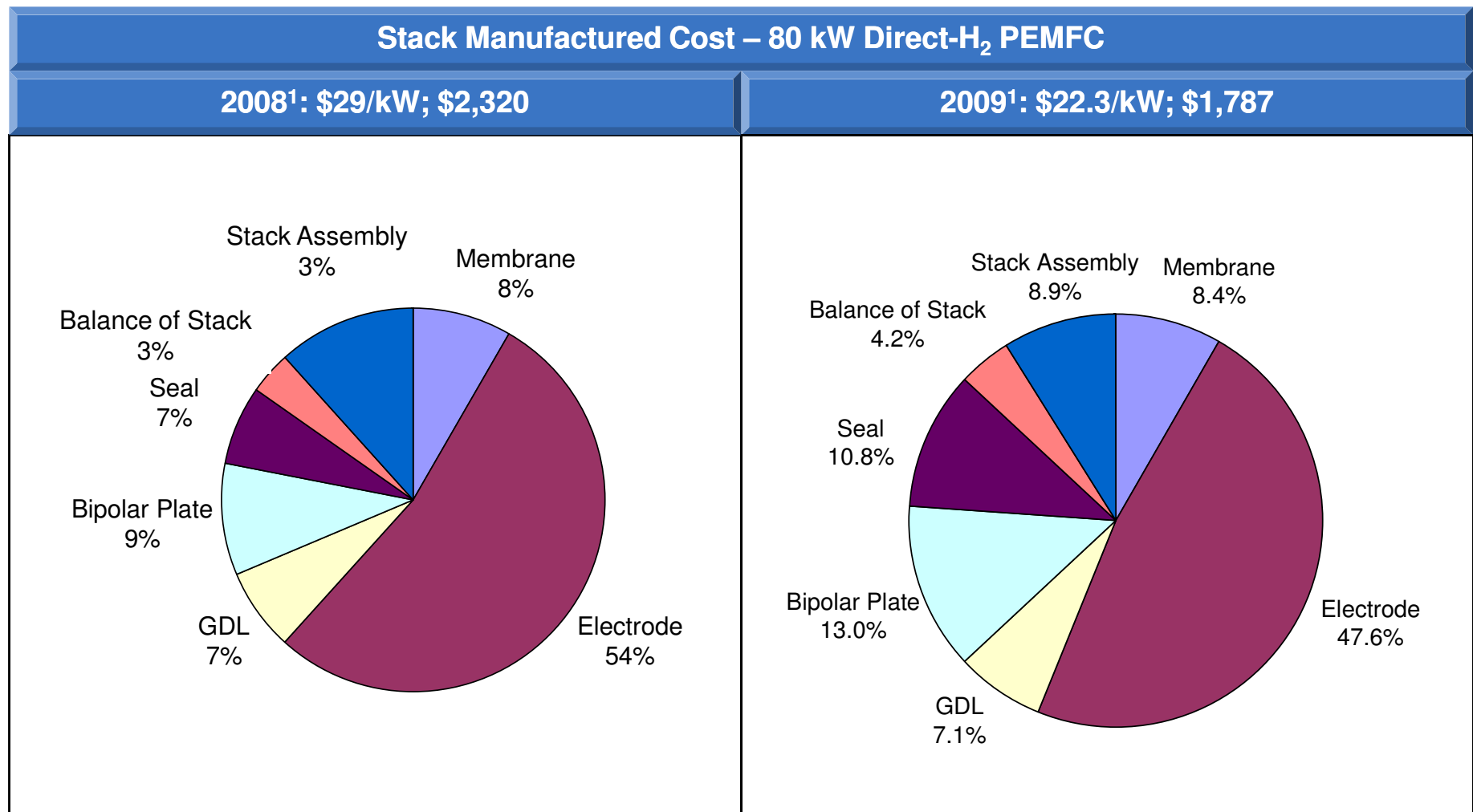
² Other costs include utilities, maintenance, and building



In 2008, the MEA and seal cost was \$140/m² due to higher material costs for the membrane (30 µm), electrodes (Pt loading = 0.25 mg/cm²) and GDL (275 µm).

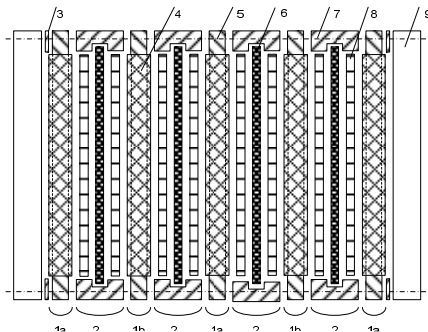
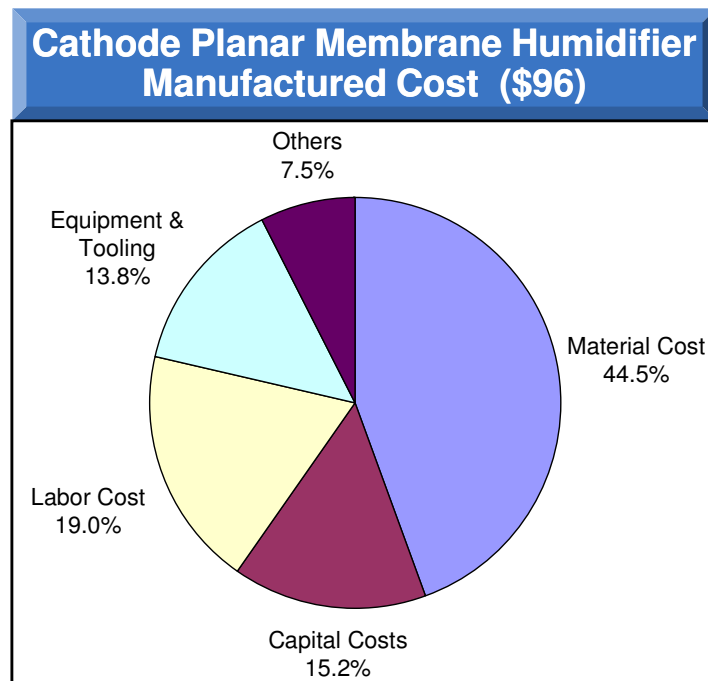
Progress 2009 Stack Cost Breakout

The electrodes represent approximately 48% of the ~\$22/kW fuel cell stack manufactured cost in 2009.



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

We developed bottom-up manufacturing costs for the cathode and anode planar MH based on ANL specifications¹ and other patents².



Cathode Planar Membrane Humidifier Manufactured Cost (\$)			
Process	#	Material	Process
Die Cut GDL	1	2.49	2.02
Die Cut Membrane	2	7.03	2.14
Hot Press Lamination	3	0.01	6.06
Injection Molding Frame Seal	4	0.00	4.20
Laser Cut Nickel Foam	5	15.44	17.16
Injection Molding Foam Frame	6	4.39	4.34
Injection Molding End Plate Gasket	7	0.11	0.45
Die Casting End Plate	8	9.50	1.32
Component Assembly	9	0.00	6.90
QC & Testing	10	0.00	6.80
Packaging	11	0.00	2.03
Fastener Cost	-	3.91	0.00
Total	-	96	

¹ R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

² U.S. Patents 6,737,183; 6,835,477; 6,864,005; 7,078,117

The water management system OEM cost^{1,2} is projected to be \$170.

Water Management System Cost (\$)			
Component	Factory Cost ¹	OEM Cost ^{1,2}	Comments
Cathode Planar Membrane Humidifier	96	111	Bottom-up costing
Anode Planar Membrane Humidifier	52	59	Bottom-up costing
Total	148	170	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

The cathode and anode planar membrane humidifier costs are both estimated using bottom-up costing tools.



The thermal management system OEM cost^{1,2} is projected to be \$413.

Thermal Management System Cost (\$)			
Component	Factory Cost ¹	OEM Cost ^{1,2}	Comments
HT Radiator	83	95	Bottom-up costing
LT Radiator	12.6	14.5	Bottom-up factory cost = \$56; Scaling by LTR heat duty, $2.9/12.9 \times 56 = \$12.6$
Air Precooler	-	43.2	Bell Intercooler \$108/unit Assuming 60% discount
HT/LT Radiator Fan	-	75	McMaster-Carr 5990K48, Base-mount single-phase AC motor, 0.75 HP, 3450 rpm, \$152/unit Assuming 60% discount, motor costs \$60/unit Aluminum fan costs ~\$15/unit
- Motor	-	- 60	
- Fan	-	- 15	
HT Coolant Pump	-	150	McMaster-Carr 5990K53, Base-mount single-phase AC motor, 1.5 HP, 3450 rpm, \$238/unit Assuming 60% discount, motor costs \$95/unit Aluminum pump costs ~\$55/unit
- Motor	-	- 95	
- Pump	-	- 55	
LT/Air Precooler Coolant Pump	-	30	AWECO pump, high-volume quote
Other	-	5	Two temperature sensors
Total	399	413	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

The air precooler, radiator fan, coolant pumps, and their motors are assumed to be purchased components; hence their price includes a markup.



The fuel management system OEM cost^{1,2} is projected to be \$425.

Fuel Management System Cost (\$)			
Component	Factory Cost ¹	OEM Cost ^{1,2}	Comments
H ₂ Blower	219.5	252	Bottom-up costing using DFMA
H ₂ Ejectors	-	40	2 ejectors assumed @ \$20/unit
H ₂ Demister	-	61	Parker Hannifin MN1S-6CN, 28 SCFM, ΔP=1.25 psid, rated for H ₂ to 175 F, \$152.50/unit Assuming 60% discount, H ₂ demister costs ~\$61/unit (Note: Parker Hannifin MN4S-6CN, rated for H ₂ to 200+ F, ΔP=0.35 psid, \$600/unit)
Solenoid Valves	-	46	2 solenoid flow control valves w/ built-in ports, McMaster-Carr 61245K1, \$57.96/unit, Assuming 60% discount, solenoid valves cost ~\$23/unit
Purge Valve	13	15	DFMA bottom-up costing; DOE Chemical Hydride Storage presentation, Sept. 2005
Check valve	9	10	DFMA bottom-up costing; DOE Chemical Hydride Storage presentation, Sept. 2005
Total	389	425	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

The H₂ ejectors, H₂ demister, and solenoid valves are assumed to be purchased components; hence their price includes a markup.



The air management system OEM cost^{1,2} is projected to be \$982.

Air Management System Cost (\$)			
Component	Factory Cost ¹	OEM Cost ^{1,2}	Comments
CEM (Compressor, Expander, Motor, Motor Controller)	687	790	Bottom-up costing using DFMA; motor controller input power updated to 9.3 kWe
Air demister	-	156	Parker Hannifin HN4S-10CG, 226 SCFM, $\Delta P=2$ psid, 1-1/4" NPT, 95% coalescing efficiency, \$390.60/unit, Assuming 60% discount, demister costs ~\$156/unit (Note: Parker Hannifin HN4L-8CG, 98.5% coalescing eff., $\Delta P=2$ psid, \$534/unit; Parker Hannifin HN5S-7CVPG, 99.5% coalescing eff., $\Delta P=0.5$ psid, \$680/unit; Parker Hannifin HN6S-7CVPG, 99.5% coalescing eff., $\Delta P=0.35$ psid, \$805/unit; Parker Hannifin HN8S-MEG, 99.95% coalescing eff., $\Delta P=0.35$ psid, \$1,235/unit; Parker Hannifin FF4-1201-6QU, 99.97% coalescing eff., $\Delta P=0.35$ psid, \$3,689/unit)
Air/H ₂ mixer	-	27	Gas mixer, McMaster-Carr 3322K18, 1" pipe, \$68.42, Assuming 60% discount, air/H ₂ mixer costs ~\$27/unit
Flow orifice	-	5	Acetal instant tube-fitting orifice, McMaster-Carr 6349T17, 1/2" tube, \$11.29, Assuming 60% discount, flow orifice costs ~\$4.5/unit
Air filter	-	4	
Total	879	982	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

The air demister, air/H₂ mixer, flow orifice, and air filter are assumed to be purchased components; hence their price includes a markup.



Progress 2009 PEMFC System *BOP Cost*

The high-volume OEM cost^{1,2} for the 2009 BOP subsystems is projected to be \$1,991.

BOP Subsystem	Component	Technology / Cost Basis	Factory Cost ¹ , \$	OEM Cost ^{1,2} , \$
Water Management	Cathode planar membrane humidifier (for air)	ANL	96	111
	Anode planar membrane humidifier (for H ₂)	ANL	52	59
Thermal Management	HT automotive tube-fin radiator	Modine	83	95
	LT automotive tube-fin radiator	Modine	13	15
	Air precooler	Bell Intercooler	-	43
	HT/LT radiator fan	McMaster-Carr	-	75
	HT coolant pump	McMaster-Carr	-	150
	LT/Air precooler coolant pump	Aweco	-	30
	Other (2 Temperature sensors)	-	-	5
Fuel Management	H ₂ blower	Parker Hannifin	219	252
	H ₂ ejectors	-	-	40
	H ₂ demister	Parker Hannifin	-	61
	Solenoid valves	McMaster-Carr	-	46
	Purge valve	DFMA	13	15
	Check valve	DFMA	9	10
Air Management	Compressor Expander Motor (CEM)	Honeywell	687	790
	Air demister	Parker Hannifin	-	156
	Air/H ₂ mixer	McMaster-Carr	-	27
	Flow orifice	McMaster-Carr	-	5
	Air filter	-	-	4
TOTAL		-	1,815	1,991



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

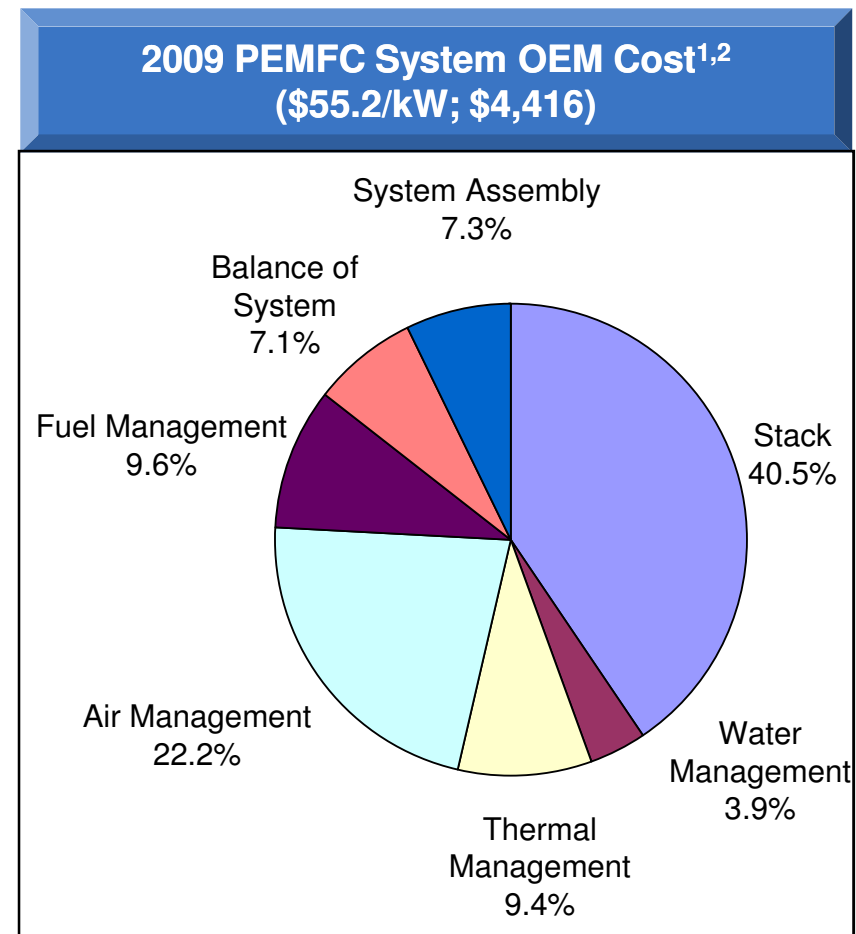
Progress 2009 PEMFC System System Cost Breakout

The 2009 PEMFC stack cost is lower than the DOE 2010 target of \$25/kW, while the system cost is higher than the DOE 2010 target of \$45/kW.

PEMFC System Cost ¹ (\$/kW)	2008 OEM Cost ^{1,2}	2009 OEM Cost ^{1,2}
Stack	29.0	22.3
Water Management	3.3	2.1
Thermal Management	2.8	5.2
Fuel Management	3.8	5.3
Air Management	8.9	12.3
Balance of System	3.1	4.0
System Assembly	5.5	4.0
Total	57.0	55.2

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

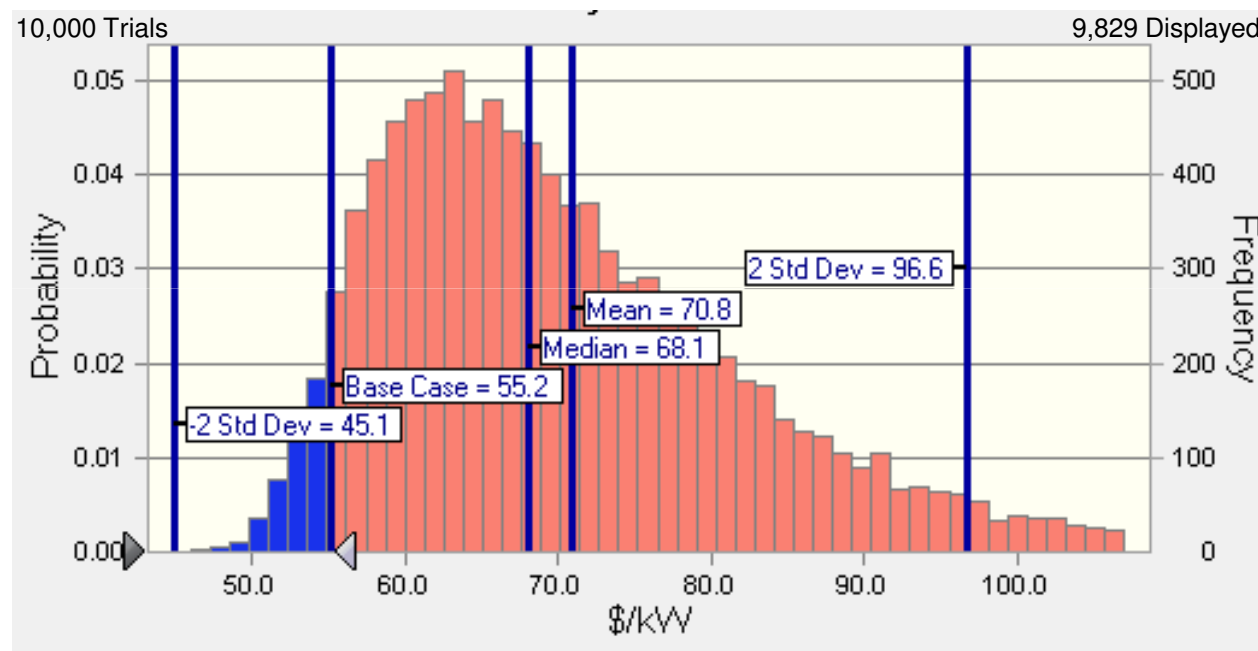


BOP, balance of system and system assembly costs together represent ~60% of the PEMFC system cost in 2009, compared to ~38% in 2005.



Monte Carlo analysis shows that the high-volume 2009 PEMFC system OEM cost¹ ranges between \$45/kW and \$97/kW ($\pm 2\sigma$), with a mean cost of \$71/kW.

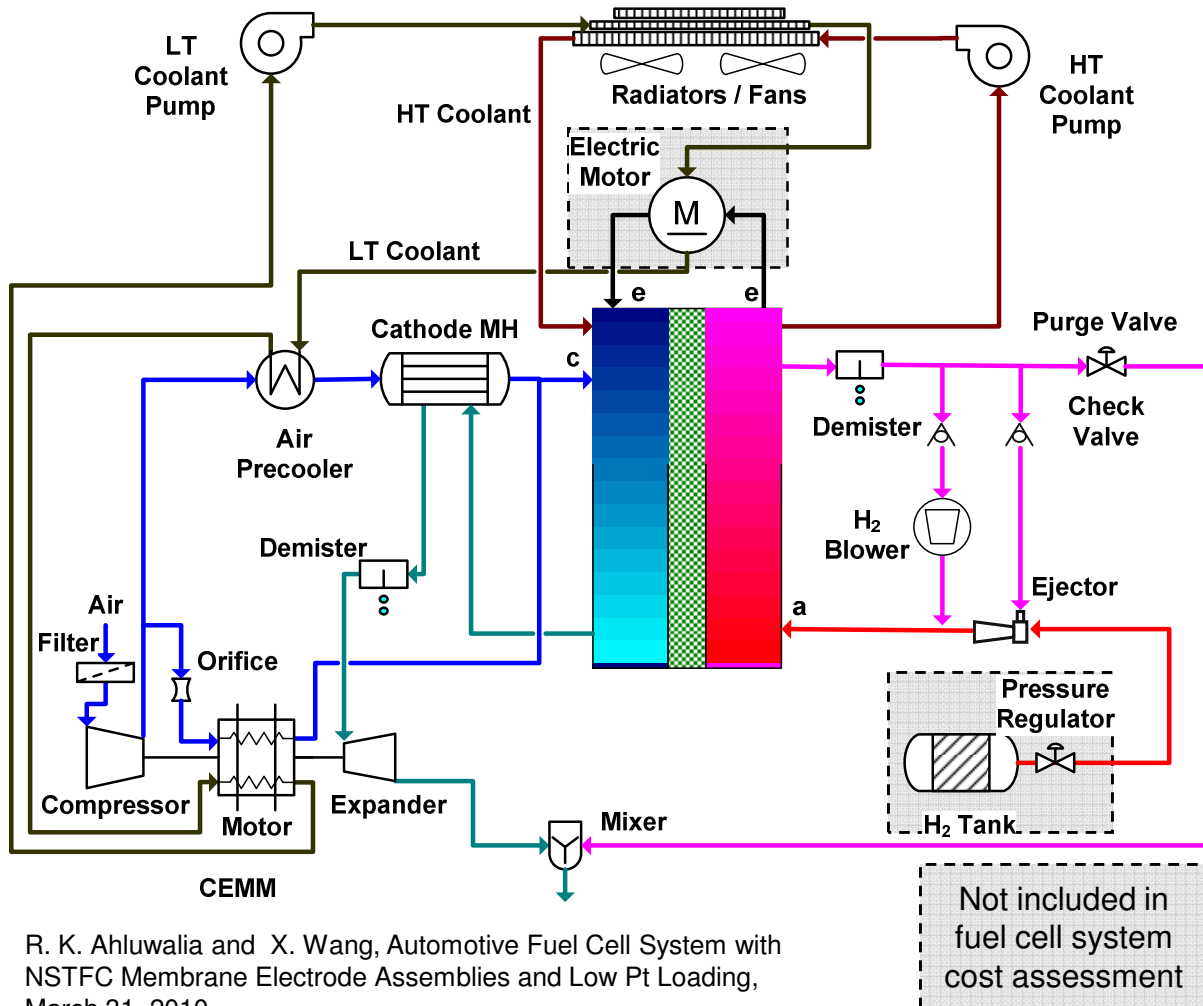
2009 PEMFC System OEM Cost¹ (\$/kW)



Cost ¹	\$/kW
Mean	71
Median	68
Std. Dev.	13
TIAX Baseline	55

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW). Assumes a % markup to automotive OEM for BOP components.

ANL 2010 PEMFC System Configuration



Key features

Stack

- 3M NSTFC MEA
- 20 μm reinforced membrane
- 0.05 (a)/0.1 (c) mg/cm^2 Pt
- Metal bipolar plates
- Non-woven carbon paper GDL

Air Management

- CEM module
- Air-cooled motor/Air-foil bearing

Water Management

- Cathode MH with pre-cooler

Thermal Management

- Advanced 40-fpi microchannel fins

Fuel Management

- Parallel ejector-pump hybrid

R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, March 31, 2010

Not included in
fuel cell system
cost assessment



NSTFC = Nano-Structured Thin Film Catalyst
CEM = Compressor Expander Motor
MH = Membrane Humidifier

MEA = Membrane Electrode Assembly
ANL = Argonne National Laboratory

To be consistent with ANL's stack performance model, we made the following material assumptions for the 2010 cost projection.

Component	Parameter	Selection
Membrane	Material	20 μm 3M PFSA
	Supported	Mechanically reinforced
Electrodes (Cathode and Anode)	Catalyst	Ternary PtCo_xMn_y alloy
	Type	Nano-Structured Thin Film
	Support	PR-149 Organic whiskers
Gas Diffusion Layer (GDL)	Material	225 μm non-woven carbon paper¹
	Porosity	80%
Bipolar Plate	Type ³	Metal w/ Nitridation surface treatment²
Seal	Material	Viton®

¹ Ref: Ballard Material Products GDL with PTFE+MPL, AvCarb® GDS3250 @ 50 kPa

² Ref: ORNL Fe-20Cr-4V alloy with nitridation surface treatment

³ We will evaluate Au-Nanoclad SS316 plates as an alternate scenario for metal bipolar plates in 2010

We used a Pt price of \$1,100/tr.oz. for the baseline analysis and captured the impact of variation in Pt price through sensitivity analyses.



PFSA = Perfluorosulfonic acid

PR = Perylene Red

The **preliminary** high-volume cost of the 2010 PEMFC stack for six scenarios^{1, 2, 3} is estimated to range between \$17/kW and \$33/kW.

Key Cost Assumptions		2010 Stack Scenarios ^{1, 2, 3}					
		S1-1	S1-2	S1-3	S2-1	S2-2	S2-3
System net power	kW _e	80					
Stack gross power ³	kW _e	90	91	92	86	87	88
Cell voltage (rated power) ³	V	0.721	0.650	0.590	0.685	0.622	0.563
Stack gross power density ³	mW/cm ²	573	1059	1411	561	930	1201
Pt loading (total) ³	mg/cm ²	0.15					
Stack Pt content	g/kW _{gross}	0.26	0.14	0.11	0.27	0.16	0.12
System Pt content	g/kW _{net}	0.29	0.16	0.12	0.29	0.18	0.14
Stack efficiency (rated power) ³	% LHV	57	52	47	54	49	45
System efficiency (rated power) ³	% LHV	50	45	40	50	45	40
System voltage (rated power)	V	300					
System active area	m ²	15.7	8.6	6.5	15.3	9.4	7.3
Stack cost⁴	\$/kW_{net}	33.0	20.7	17.4	32.4	22.3	19.0

¹ All scenarios assume a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μm reinforced PFSA membrane.

² S1: 2.5 atm, 85 °C; S2: 1.5 atm, 75 °C

³ Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

⁴ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

We developed specifications for the 2010 PEMFC stack scenarios consistent with the performance predicted by ANL modeling^{1, 2, 3}.

TIAX Assumptions		2010 Stack Scenarios ^{1, 2, 3}					
		S1-1	S1-2	S1-3	S2-1	S2-2	S2-3
Number of stacks per system	#	1					
Number of cells per stack	#	417	462	509	438	483	533
Active area to Total area ⁴	%	75%					
Active area per cell	cm ²	377	186	128	349	195	137
Cell pitch	cells/inch (cells/cm)	19.7 (7.8)	19.7 (7.8)	19.7 (7.8)	19.7 (7.8)	19.7 (7.8)	19.7 (7.8)
System voltage (rated power)	V	300					

¹ All scenarios assume a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μ m reinforced PFSA membrane.

² S1: 2.5 atm, 85 °C; S2: 1.5 atm, 75 °C

³ Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

⁴ Active area to Total area ratio reduced from 85% in 2009 to 75% in 2010, based on feedback from OEMs and FCTT

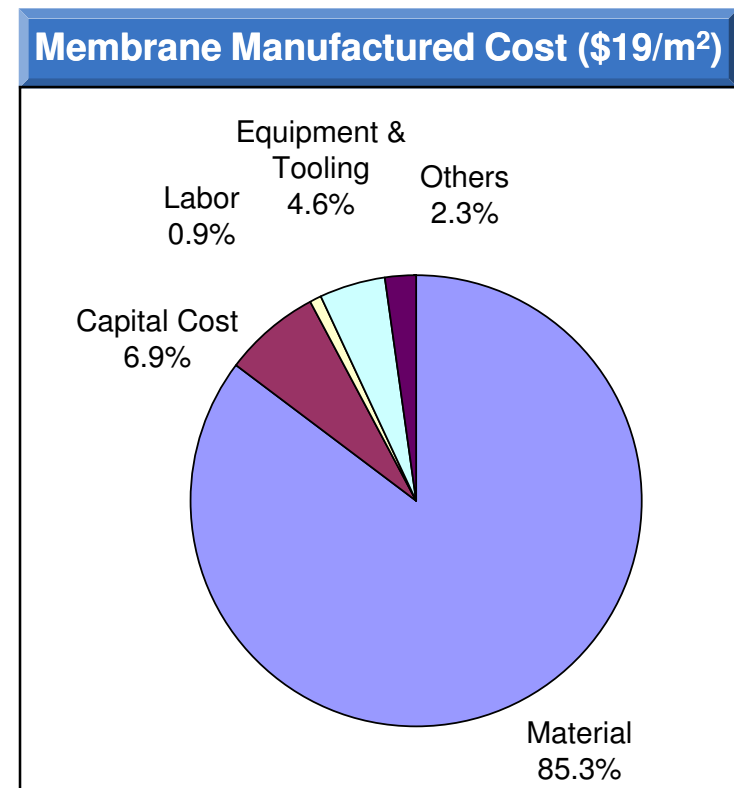
The reinforced 20 μm PFSA membrane is estimated to cost ~\$19/m² on an active area basis, with materials representing ~85% of the cost.

Membrane Manufactured Cost ¹				
Component	Material		Process	
	(\$/m ²)	(\$/kg)	(\$/m ²)	(\$/kg)
Film Handling	6.33	107.64	0.33	5.67
Coating	9.64	163.83	0.42	7.10
Drying & Cooling	0.00	0.00	1.87	31.84
Quality Control	0.00	0.00	0.03	0.57
Laminating	0.00	0.00	0.05	0.89
Packaging	0.03	0.43	0.03	0.44
Subtotal	15.99	2.74	2.74	46.52
Total	18.73 (\$/m²)			
	318.42 (\$/kg)			

¹ Manufactured cost on an active area basis or per kg of finished membrane basis (accounts for scrap and yield)

² 3M PFSA ionomer cost **preliminarily** increased by factor of 20% over 2009 Nafion baseline cost of \$80/lb due to higher cost risk for shorter side chain PFSA ionomer: to be verified by industry feedback in 2010

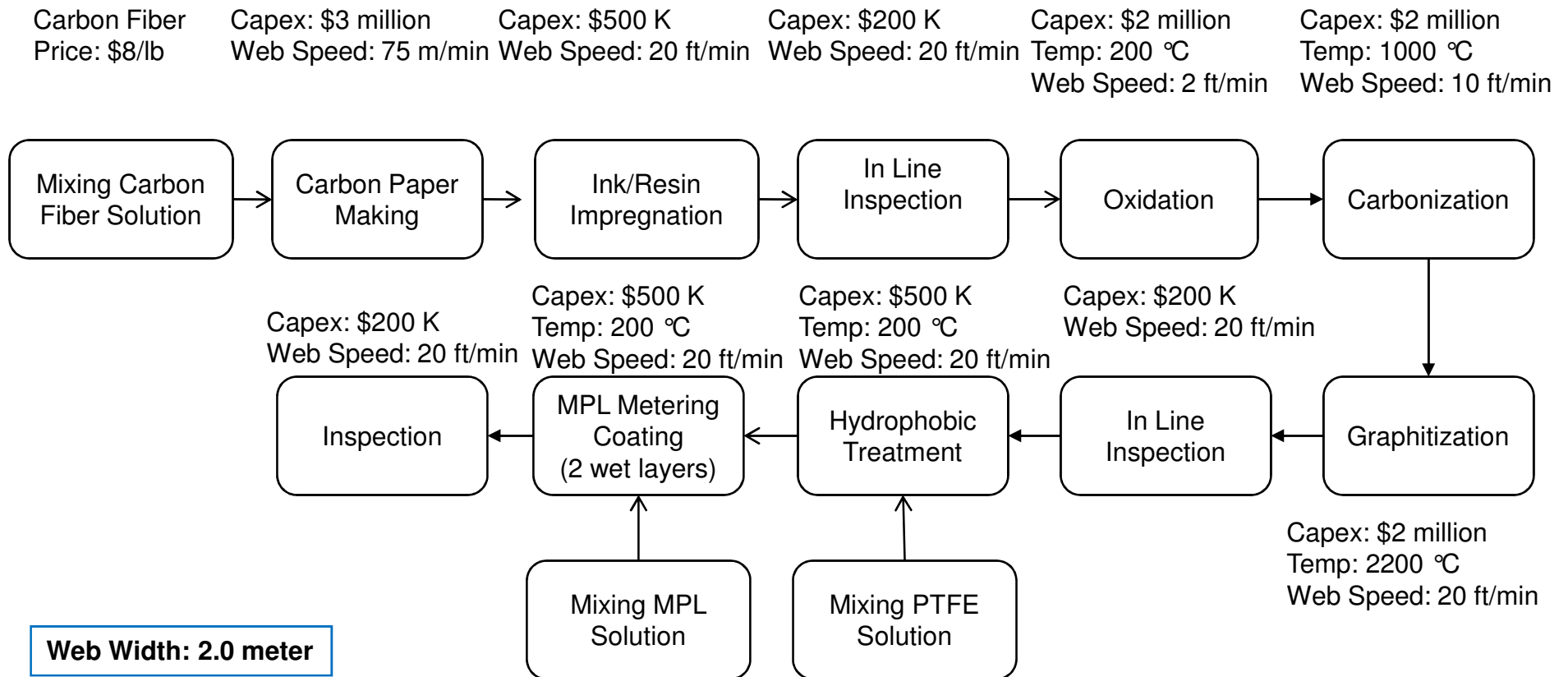
³ ePTFE cost **preliminarily** assumed to be \$5/m²: to be verified by industry feedback in 2010



The **preliminary** 2010 membrane cost estimate is higher due to increased ionomer² and ePTFE³ costs for the reinforced membrane.



In 2010, we costed a non-woven carbon paper GDL with PTFE+MPL.



The 2010 GDL cost is based on discussions with Ballard Material Products on their AvCarb® GDS3250, suitable for automotive applications.



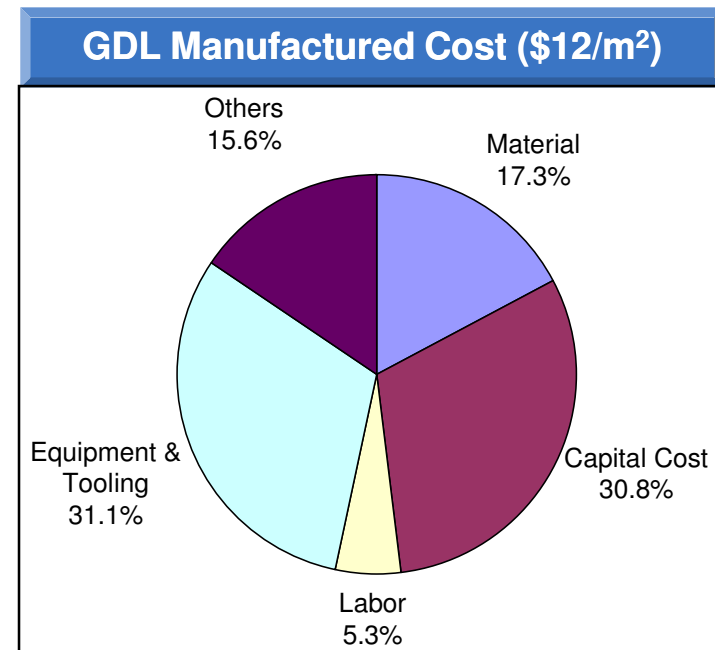
Multiple stations / lines would be required to meet the high volume production of ~19 million square meters of GDL per year)

The **preliminary** cost of the 2010 non-woven carbon paper GDL (for *both* anode and cathode), is ~\$12/m², on an active area basis.

Manufactured Cost ¹	GDL (\$/m ²)	GDL (Anode + Cathode) (\$/m ²)
Material	1.02	2.05
Capital Cost	1.83	3.66
Labor	0.31	0.63
Tooling	1.85	3.69
Other ²	0.92	1.84
Total	5.94	11.87

¹ Manufactured cost on an active area basis

² Other costs include utilities, maintenance, and building



The GDL costing is changed from “buy untreated woven carbon cloth” in 2009 to “fabricate non-woven carbon paper + PTFE + MPL” in 2010.



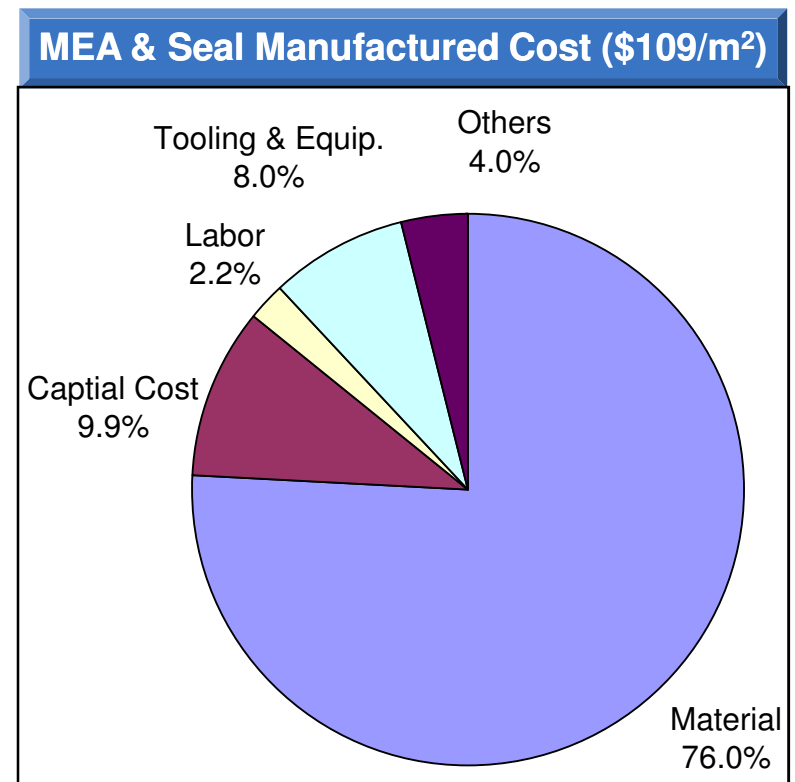
Using S2-2 as an example scenario, the 2010 MEA and seal together are estimated to cost ~\$109/m².

Manufactured Cost ¹	MEA (\$/m ²)	Frame Seal (\$/m ²)
<i>Material</i>	77.19	
- Membrane	- 15.99	
- Electrode	- 59.14	
- GDL	- 2.05	
		5.99
<i>Capital Cost</i>	9.09	1.75
<i>Labor</i>	1.15	1.27
<i>Tooling & Equipment</i>	7.32	1.50
<i>Other²</i>	3.51	0.71
Subtotal	98.26	11.22
Total	109.49	

¹ Manufactured cost on a per m² of active area basis

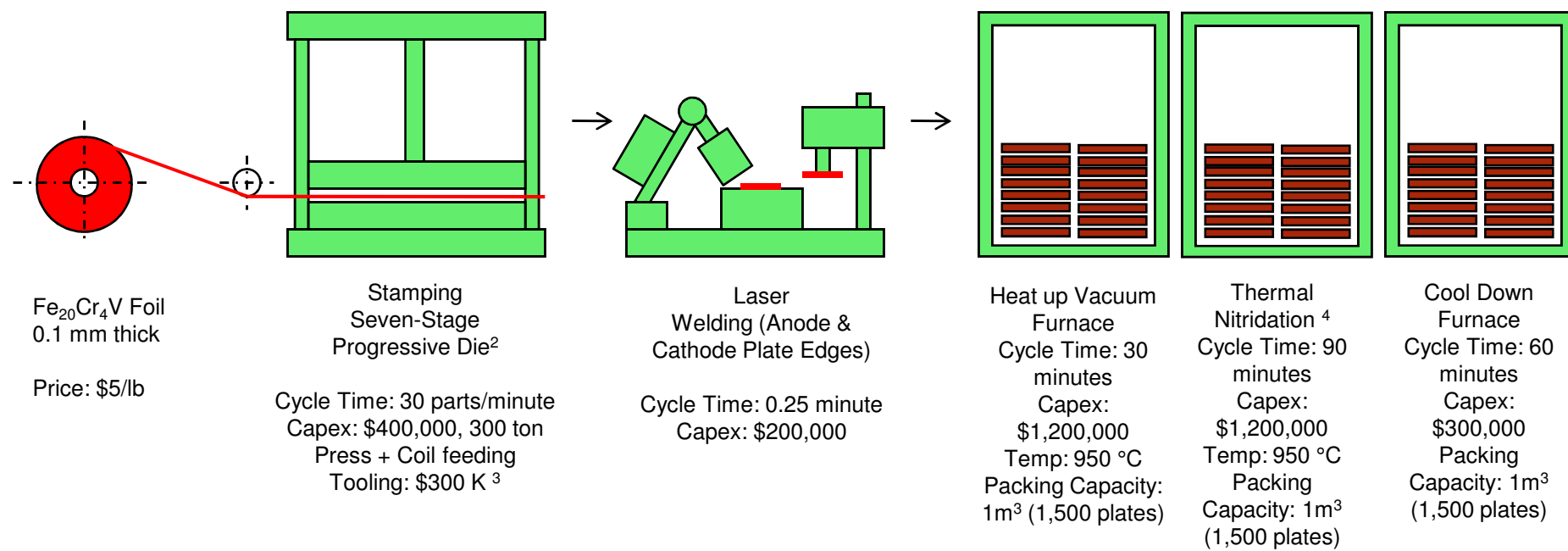
² Other costs include utilities, maintenance, and building

³ Active area to Total area ratio reduced from 85% in 2009 to 75% in 2010, based on feedback from OEMs and FCTT



The **preliminary** estimate for the 2010 MEA & seal cost is higher due to increased ionomer and ePTFE costs for the reinforced membrane, the reduction in active area ratio³ from 85% to 75%, reduction in MEA utilization from 100% to 95%, and refinement of GDL costing.

The metal bipolar plate cost is based on discussions with ORNL on their thermal nitriding process¹ for specific alloys, e.g. Fe-20Cr-4V.



- Stamping: The anode side plate and the cathode side plate are stamp pressed by a seven stage progressive die which forms the micro flow channels, punches the main flow channels, bolt holes, and trims the edges.
- Welding: The anode and cathode side plate edges are welded together using laser welding.
- Thermal Nitridation: The bipolar plate is heated for 1.5 hours at 950 °C degree in a vacuum nitridation furnace. It takes 0.5 hour to heat up and 1 hour to cool down.

1. Nitrided metallic bipolar plates, M.P. Brady, et al., ORNL, DOE Merit Review presentation, May 2009

2. US 20090081520 (Hitachi)

3. Discussion with Minster Press Inc., April 2010

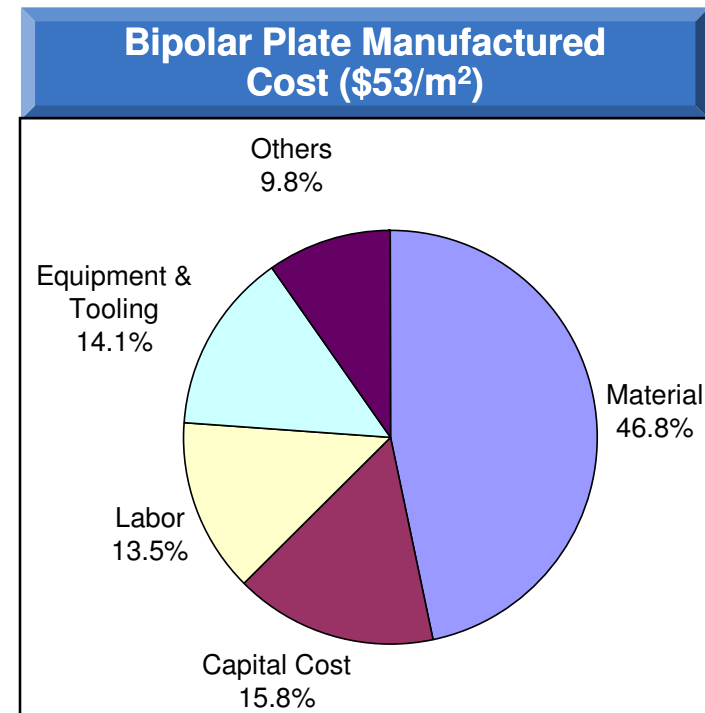
4. Preferential thermal nitridation to form pin-hole free Cr-nitrides to protect proton exchange membrane fuel cell metallic bipolar plates, M.P. Brady, et al., Scripta Materialia 50 (2004) 1017-1022

The **preliminary** cost of the nitrated Fe-20Cr-4V metal bipolar plates is estimated to be ~\$53/m² or ~\$6/kW in 2010.

Component	Bipolar Plate Manufactured Cost ¹ (\$/m ²)		Bipolar Plate Manufactured Cost ² (\$/kW)	
	Material	Process	Material	Process
Stamping	24.75	10.70	2.91	1.26
Laser Welding	0.00	7.05	0.00	0.83
Nitridation	0.00	10.40	0.00	1.22
Subtotal	24.75	28.14	2.91	3.31
Total	52.89		6.22	

¹ Manufactured cost on an active area basis

² Manufactured cost on a kW_{net} basis



The base metal foil thickness¹ is 0.1 mm and the overall bipolar plate thickness is 0.9 mm. We will also evaluate Au-Nanoclad SS316 bipolar plates in 2010.



Preliminary 2010 stack (S2-2) manufactured costs on an active area basis are higher than the 2009 stack costs, due to the reduction in active area ratio from 85% (in 2009) to 75% (in 2010).

Stack Manufactured Cost ¹ , \$/m ²	2009	2010 S2-2 ^{2, 3, 4}	Δ%	Comments
Membrane	11	19	+70%	3M PFSA ionomer (1.2*\$80/lb) & ePTFE (\$5/m ²) included in 2010
Electrodes	65	68	+4%	MEA utilization rate decreased from 100% in 2009 to 95% in 2010
GDL	10	12	+8%	
Seals	15	18	+22%	Active area decreased from 13.1 m ² in 2009 to 9.4 m ² in 2010
Bipolar plates	18	53	+194%	Nitrided metallic plate in 2010
Balance of Stack (Stack manifold, tie bolts, end plates, current collectors, electrical insulators)	6	5	-20%	1 stack per system in 2010 vs. 2 stacks per system in 2009
Stack Assembly ^{5, 6}	12	15	+25%	Active area decreased from 13.1 m ² in 2009 to 9.4 m ² in 2010
Total Stack⁷	136	189	+39%	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

³ Assumes a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μm reinforced PFSA membrane.

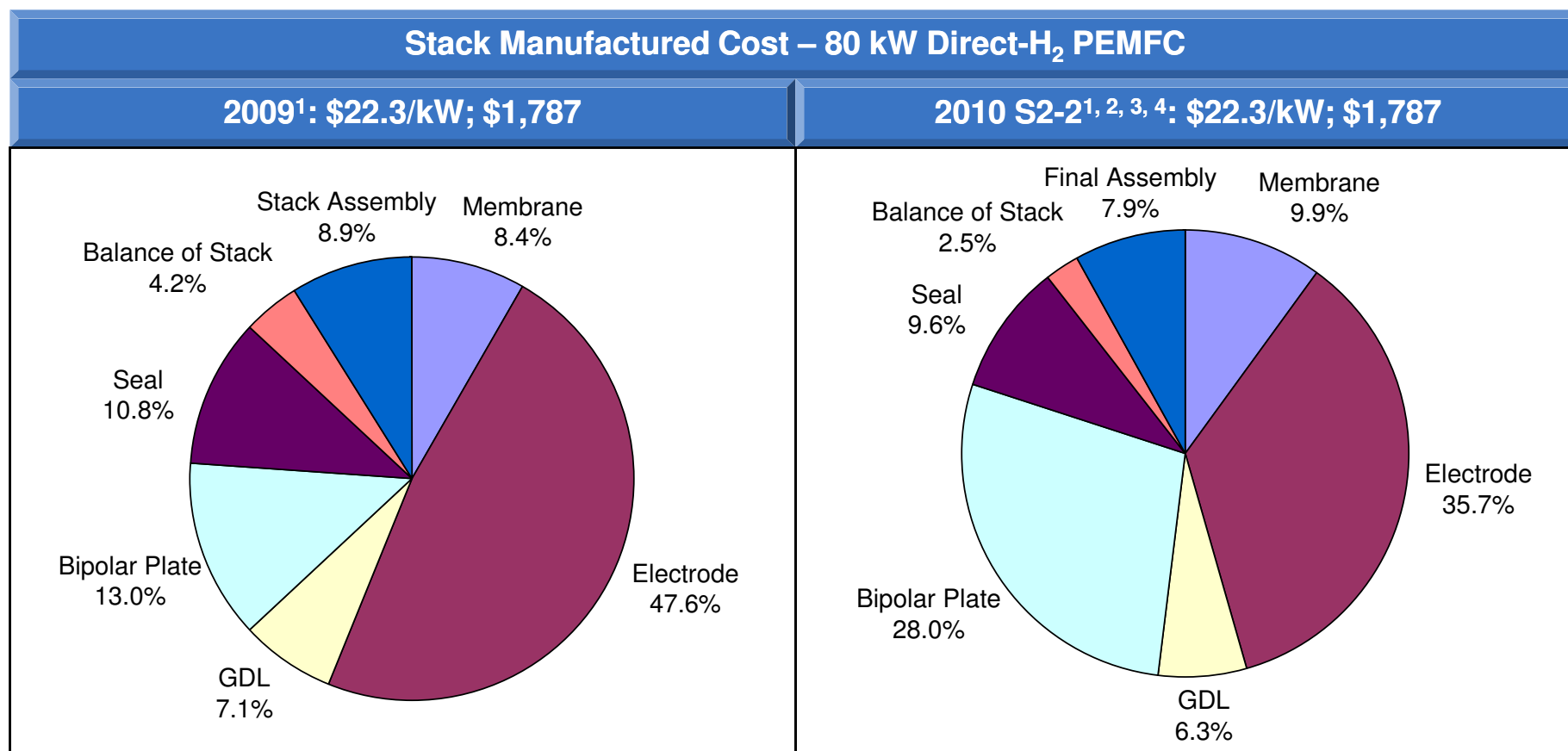
⁴ S2: stack inlet pressure @ rated power = 1.5 atm, stack temperature = 75 °C

⁵ Stack Assembly cost includes QC but not Stack Conditioning; QC includes visual inspection, and leak tests for fuel loop, air loop and coolant loop

⁶ Task to "Estimate High-Volume Costs of Stack Conditioning" is planned to be completed in 2010, pending funding authorization from DOE

⁷ Results may not appear to calculate due to rounding of the component cost results.

The **preliminary** cost estimate for the 2010 stack (S2-2) is ~\$22/kW, which is similar to the 2009 stack cost.



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

³ Assumes a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μ m reinforced PFSA membrane.

⁴ S2: stack inlet pressure @ rated power = 1.5 atm, stack temperature = 75 °C

Preliminary 2010 stack (S2-2) manufactured costs on a net kW basis are similar to the 2009 stack costs.

Stack Manufactured Cost ¹ , \$/kW	2009	2010 S2-2 ^{2, 3, 4}	Δ%	Comments	2010 DOE Target
Membrane	1.9	2.2	+18%	3M PFSA ionomer (1.2*\$80/lb) & ePTFE (\$5/m ²) included in 2010	10
Electrodes	10.6	8.0	-25%	Power density is higher for same Pt loading in 2010 ² ; 2010: 930 mW/cm ² , 2009: 701 mW/cm ²	
GDL	1.6	1.4	-12%		
Seals	2.4	2.1	-11%		
Bipolar plates	2.9	6.2	+115%	Nitrided metallic plate in 2010	5
Balance of Stack (Stack manifold, tie bolts, end plates, current collectors, electrical insulators)	0.9	0.6	-39%	Power density is higher for same Pt loading in 2010 ² ; 2010: 930 mW/cm ² , 2009: 701 mW/cm ²	
Stack Assembly ^{5, 6}	1.8	1.8	-11%		
Total Stack ⁷	22.3	22.3	0%		25

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

³ Assumes a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μm reinforced PFSA membrane.

⁴ S2: stack inlet pressure @ rated power = 1.5 atm, stack temperature = 75 °C

⁵ Stack Assembly cost includes QC but not Stack Conditioning; QC includes visual inspection, and leak tests for fuel loop, air loop and coolant loop

⁶ Task to "Estimate High-Volume Costs of Stack Conditioning" is planned to be completed in 2010, pending funding authorization from DOE

⁷ Results may not appear to calculate due to rounding of the component cost results.

The **preliminary** high-volume OEM cost of the 2010 PEMFC system for six scenarios^{1, 2, 3} is estimated to range between \$49/kW and \$65/kW.

PEMFC System Cost ¹ (\$/kW)	2009 OEM Cost ^{4, 5}	2010 Stack Scenarios ^{1, 2, 3}					
		S1-1	S1-2	S1-3	S2-1	S2-2	S2-3
Stack ⁴	22.3	33.0	20.7	17.4	32.4	22.3	19.0
Water Management ^{5, 6, 7}	2.1	1.4	1.4	1.4	1.4	1.4	1.4
Thermal Management ^{5, 7}	5.2	5.2	5.2	5.2	5.2	5.2	5.2
Fuel Management ^{5, 7}	5.3	5.3	5.3	5.3	5.3	5.3	5.3
Air Management ^{5, 7, 8}	12.3	12.2	12.4	12.9	9.9	10.4	10.6
Balance of System ^{5, 7}	4.0	4.0	4.0	4.0	4.0	4.0	4.0
System Assembly	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Total System^{4, 5, 6, 7}	52.4	65.0	52.9	50.0	62.2	52.4	49.4

¹ All scenarios assume a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 µm reinforced PFSA membrane.

² S1: 2.5 atm, 85 °C; S2: 1.5 atm, 75 °C

³ Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

⁴ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

⁵ Assumes 15% markup to the automotive OEM for BOP components

⁶ Water Management in 2010 **preliminarily** assumes cathode planar membrane humidifier and no anode humidifier

⁷ Using 2009 cost numbers for BOP subsystems' **preliminary** cost; all BOP costs pending ANL input, are planned to be updated in 2010

⁸ CEM motor controller cost varies based on **preliminary** modeling by ANL, of CEM parasitic power, for different scenarios

The key conclusions, accomplishments and next steps for our project are summarized below.

- Key conclusions and accomplishments:
 - The 2009 PEMFC stack cost¹ was estimated to range between \$19/kW and \$40/kW over six different scenarios.
 - The PEMFC stack and system costs^{1, 2} were estimated to be \$22/kW and \$55/kW respectively, for the 2009 baseline scenario.
 - BOP, balance-of-system and system assembly costs together represented ~60% of the projected PEMFC system cost, for the 2009 baseline scenario.
 - Monte Carlo analysis shows that the 2009 PEMFC system OEM cost^{1, 2} ranges between \$45/kW and \$97/kW ($\pm 2\sigma$), with a mean cost of \$71/kW.
 - We participated in an independent peer-review of our cost analysis, and submitted a comprehensive report to DOE on our 2008 PEMFC cost analysis
 - Preliminary estimates for the manufactured cost¹ of the 2010 PEMFC stack, ranged between \$17/kW and \$33/kW over six different scenarios.
 - Preliminary estimates for the OEM cost^{1, 2} of the 2010 PEMFC system, ranged between \$49/kW and \$65/kW over six different scenarios.
- Next steps:
 - Finalize baseline scenario for 2010 PEMFC system, and develop BOP cost estimates
 - Finalize reinforced membrane, non-woven GDL and metal bipolar plate (thermal nitrided and Au-Nanoclad) cost estimates for baseline scenario for 2010 PEMFC stack
 - Develop bottom-up cost projection for stack conditioning³
 - Perform single-variable and Monte Carlo sensitivity analyses on stack and system costs

¹ High-volume manufactured cost based on a 80 kW net power PEMFC net power system.

² High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW). Assumes a % markup to automotive OEM for BOP components.

³ Task to “Estimate High-Volume Costs of Stack Conditioning” is planned to be completed in 2010, pending funding authorization from DOE

Acknowledgement

We would like to thank the DOE for supporting this project over the past five years, and acknowledge valuable discussions with OEMs, FCTT, developers, national labs, and equipment manufacturers.

- Key discussions this year to date include:
 - Ballard Material Products
 - Ford Motor Co.
 - Oak Ridge National Laboratory
 - Argonne National Laboratory
 - Several equipment manufacturers
 - Independent Peer Review Panel

Thank You!



Supplemental Slides

Reviewers' Comments 2009 DOE AMR

Responses to Reviewers' Comments from 2009 DOE AMR

- “Trade-offs between operating conditions, system/component performance and components cost sensitivities should be studied.”
 - Six scenarios (with varying cell voltage, Pt loading, power density, system efficiency) were costed for the 2009 PEMFC system, and we have presented **preliminary** costs for six scenarios (with varying pressure, cell voltage, power density, system efficiency) for the *updated* 2010 PEMFC system configuration. The underlying stack architecture and system configuration remain the same, while stack and BOP component performance and specifications vary.
- “Not enough effort was devoted to non-stack/system component costs.”
 - At the time of the 2009 DOE AMR, we were only a couple months into our Option Year 2. We have presented detailed BOP cost updates for the ANL 2009 PEMFC system configuration (esp. see Supplemental Slides for BOM and process flow details).
- “The cost of membrane materials may be underestimated since high volume (for chemical industry) will not be achieved at 500,000 vehicles/year.”
 - We have **preliminarily** updated the cost of the 3M PFSA ionomer by a factor of 20% over 2009 Nafion baseline cost of \$80/lb due to higher cost risk for shorter side chain PFSA ionomer: to be verified by industry feedback in 2010.
- “Project team needs to clarify the role relative to DTI.”
 - The DTI and TIAX cost studies are two totally independent/objective evaluations, with certain key parameters/assumptions (e.g. Pt price, vertical integration of stack manufacturing, BOP markup) provided by DOE for sake of consistency and ease of comparison.
- “The cost of \$16/m² for the membrane seems a bit too high. Compare to cost projections from GM (Mathias et al., Fall 2005).”
 - The manufactured cost of the 2009 membrane (20 µm thick, 3M PFSA) was estimated to be \$11/m² @ production volume of ~6.6 million m²/year, which is similar to the *extrapolated* value of ~\$8-9/m² at that production volume in the GM projection from 2005 (25 µm thick, Nafion® PFSA membrane).
Note: **Preliminary** 2010 update is for a mechanically reinforced, 20 µm thick, 3M PFSA membrane.



Collaborations Review Meetings

We coordinated with DOE, ANL, developers, and stakeholders so far this year, with additional meetings to follow.

Audience/ Reviewer	Date	Location
Fuel Cell Tech Team Mtg.	May 08	Detroit MI
Several Work-in-Progress Mtgs. with DOE and ANL	June – Sep 08	Telecon
DOE Annual Merit Review	June 08	Arlington VA
DOE HFCIT Review	Sep 08	Washington DC
Fuel Cell Tech Team Review	Sep 08	Telecon
Several Work-in-Progress Mtgs. with the Independent Peer Review Panel	Dec 08 – Mar 09	Telecon
Several Work-in-Progress Mtgs. with DOE and ANL	Feb 09 – Sep 09	Telecon
DOE Annual Merit Review	May 09	Arlington VA
Fuel Cell Tech Team Review	Aug 09	Telecon
Several Telecons & Mtgs. with Ford, Ballard Material Products, ORNL, ANL, and others	Feb 10 – present	Telecon
DOE Annual Merit Review	June 10	Washington DC

ANL modeled a 3M PFSA membrane, with a Gore-Select® type of support, and total thickness of 20 microns.

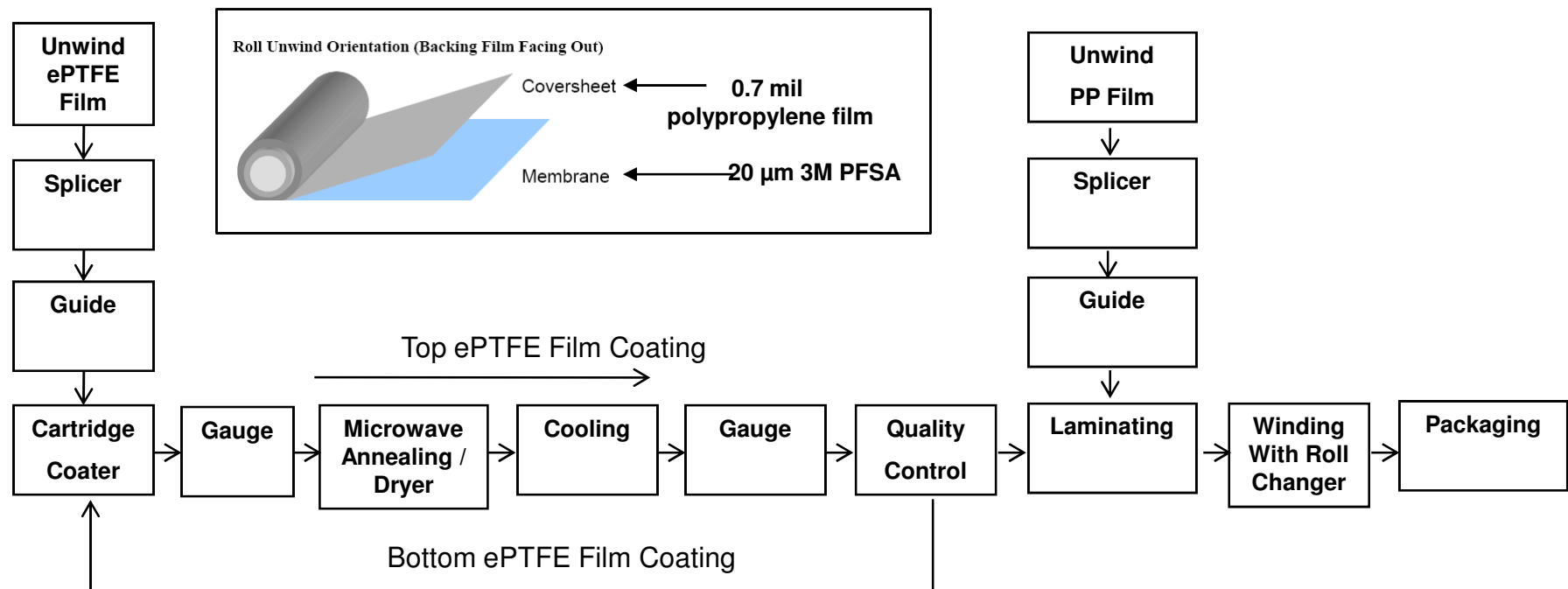
	ePTFE	3M PFSA ionomer Supported Membrane
Thickness (μm)	20	20
Porosity (%)	95%	-
Bulk Density (g/cm ³)	0.098	1.97

- Impregnation of ePTFE layer with liquid ionomer solution is not suitable for a high-volume manufacturing process because both the ePTFE and ionomer film are hydrophobic. Impregnation times can be unacceptably long and repeated impregnations are needed.
 - US 6156451 (Dupont)
 - S. Ahn, Y. Lee, H. Ha, S. Hong, I. Oh, Properties of the reinforced composite membranes formed by melt-soluble ion-conducting polymer resins for PEMFCs, *Electrochim. Acta* 50 (2004) 571–575.
 - T.Yu, H. Lin, K. Shen, L. Huang, Y. Chang, G. Jung, J. Huang, Nafion/PTFE composite membranes for fuel cell applications, *J. Polym. Res.* 11 (2004)
- A double-side dispersion coating process is used in our analysis
 - US 2008/0269409 (Dupont)

We assumed a double-side dispersion coating process for membrane fabrication.



We used US 2008/0269409 to adapt our existing 3M PFSA membrane fabrication process to an ePTFE-supported membrane process.



We assumed a double-side dispersion coating process for membrane fabrication.

In 2010, we costed a non-woven carbon paper GDL with PTFE+MPL.

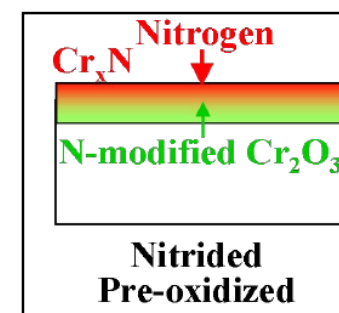
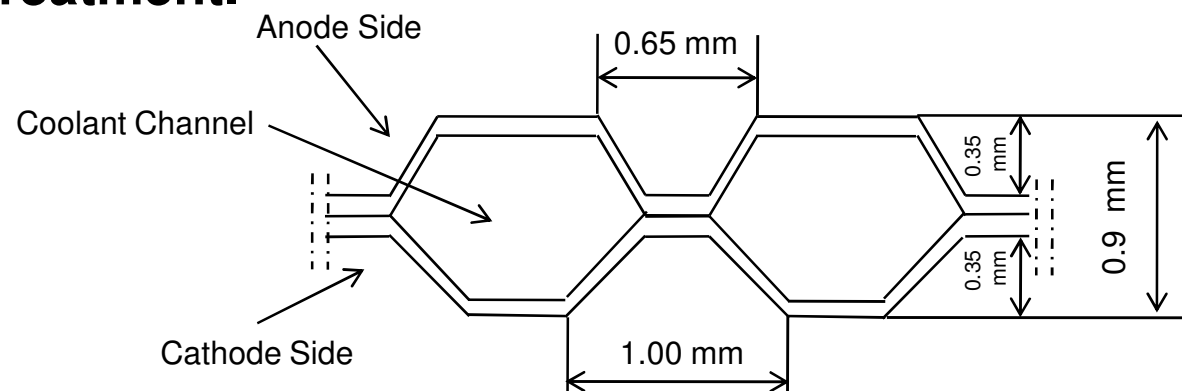
• Bill of Materials	• Process
2009 GDL: Woven carbon cloth MPL: 47% PTFE, 53% Carbon black 2010 GDL: We developed a separate BOM for bare GDL+ PTFE+MPL GDL: non-woven carbon fiber paper, 10 wt% PTFE MPL: 50% PTFE, 50% Carbon black	2009 GDL: Purchase untreated woven carbon cloth Coat hydrophobic PTFE and MPL together 2010 GDL: Fabricate non-woven carbon paper Hydrophobic treatment MPL coating

Material	Pressure (kPa)	Bare GDL	GDL with PTFE Treatment	GDL with PTFE Treatment + MPL
Thickness (μm)	50	185		225
Porosity (%)	250	90%	88%	80%
Areal Weight (g/m^2)		40	44	75
Materials		Carbon Fiber loading: $15 \text{ g}/\text{m}^2$ Ink/Resin loading: $25 \text{ g}/\text{m}^2$	10 wt% PTFE treatment PTFE loading: $4 \text{ g}/\text{m}^2$	PTFE loading: $15 \text{ g}/\text{m}^2$ Carbon black loading: $16 \text{ g}/\text{m}^2$
Comments		AvCarb® EP40 Assume that process starts with PAN-precursor commercial-grade carbon fiber Carbon fiber price: \$8/lb	PTFE Cost: \$9.41/lb	AvCarb® GDS3250 Carbon Black Cost: \$1.52/lb

In 2009 and previous years, we combined the GDL hydrophobic coating and MPL coating together and treated them as a single process step.



Fe-20Cr-4V was picked as the base metal alloy, with nitridation surface treatment.



Ref.1

Parameter	Specifications
Bipolar Plate Area (cm ²)	260
Base Material Thickness ³ (mm)	0.1
Base Material	Fe-20Cr-4V
Base Material Surface Treatment	Pre-oxidation + Nitridation
# of Tiles in a Bipolar Plate	2
Cooling Channels?	Yes
Joint Method	Laser Welding Edge

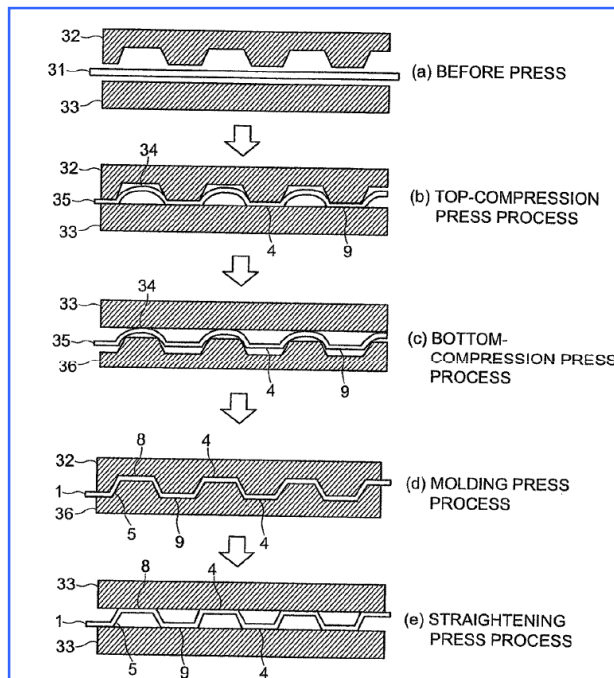
Parameter	Dimensions
Anode Side Channel Width ² (mm)	0.65
Anode Side Channel Depth ² (mm)	0.35
Anode Side Flow Channel Area as % of Active Area	50%
Cathode Side Channel Width ² (mm)	1.00
Cathode Side Channel Depth ² (mm)	0.35
Total Thickness (mm)	1.10
Cathode Side Flow Channel Area as % of Active Area	75%
Overall Active Area	75%
Cavity as % of Active Area	73%
Cavity as % of non Active Area	87%

The base metal foil thickness is 0.1 mm and the overall bipolar plate thickness is 0.9 mm.

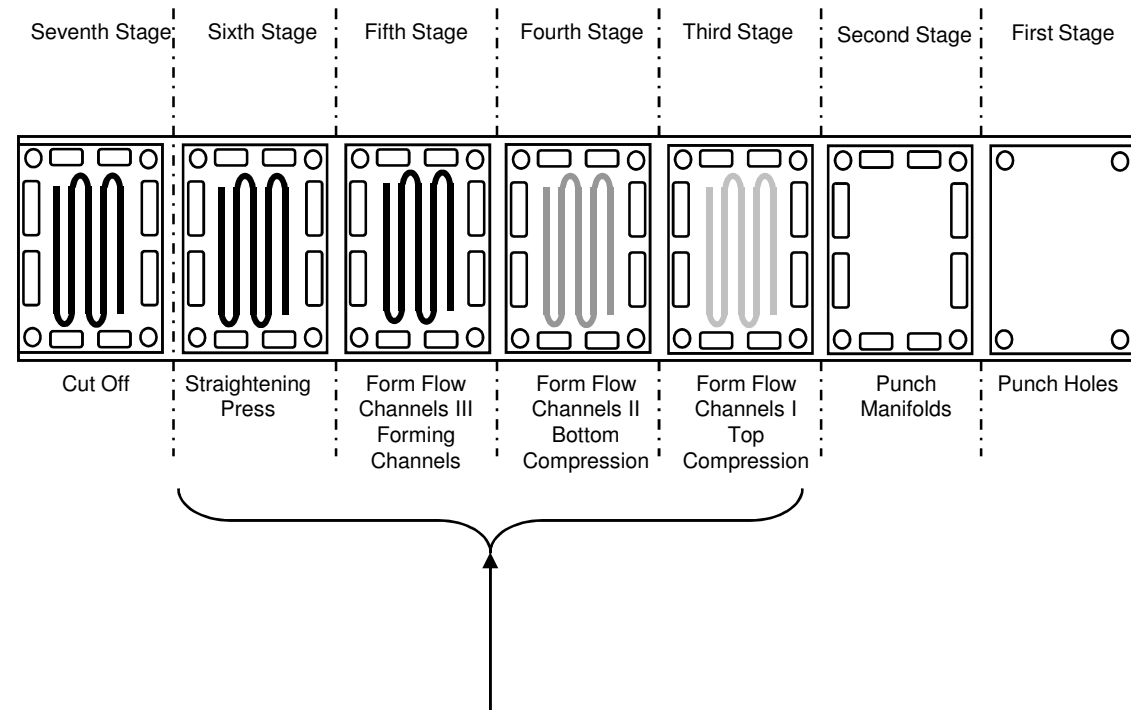


1. Nitrided metallic bipolar plates, M.P. Brady, et al., ORNL, DOE Merit Review presentation, May 2009
2. GM patents: US 20070082252; US 7,291,414; US 20090186253
3. Discussion with ORNL, April 2010

A seven-stage progressive die is assumed, in order to prevent cracks during the thin metal forming process. The tooling cost is ~\$300,000¹.



US Patent: 20090081520
(Hitachi)

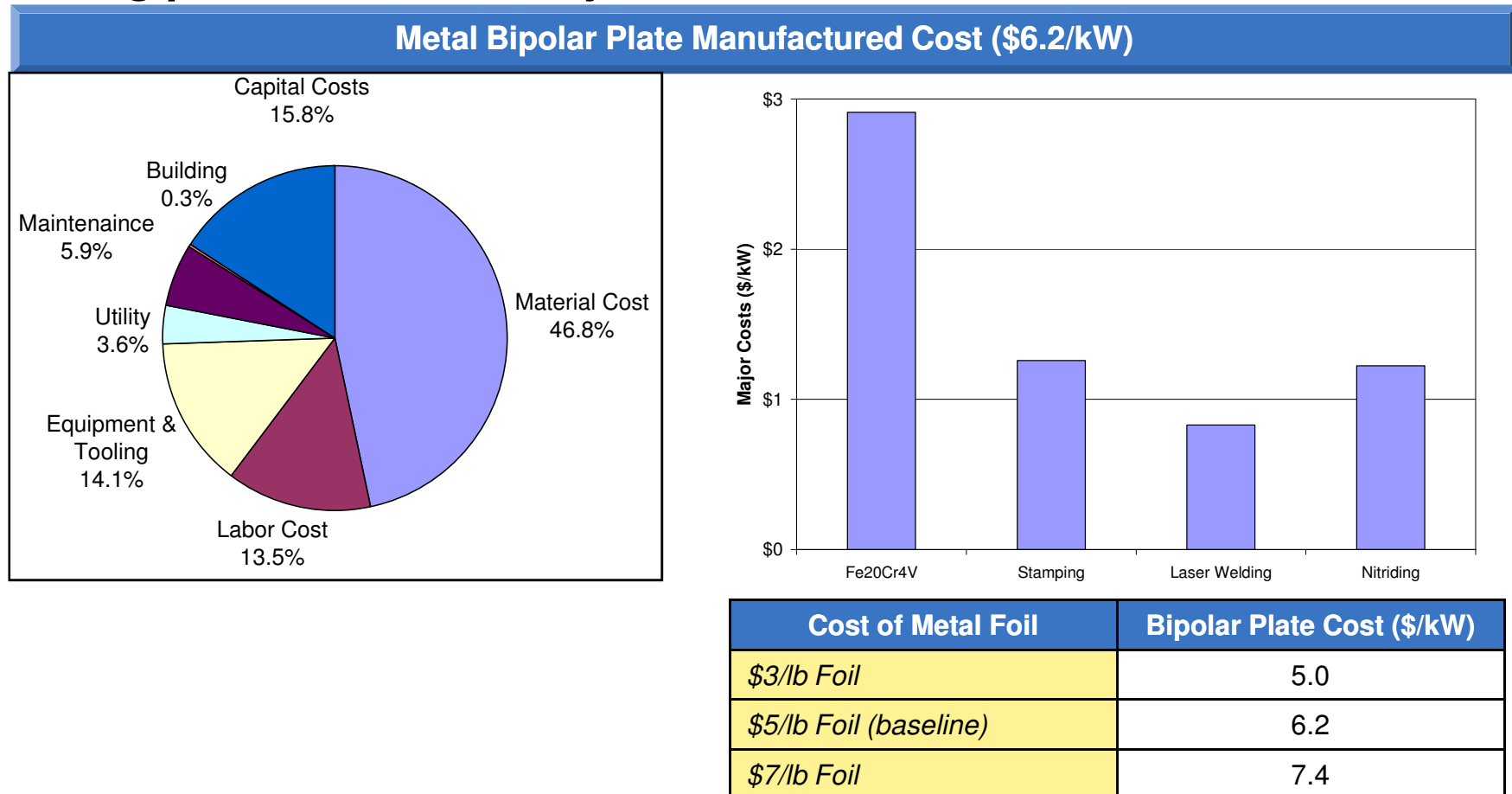


A 300 ton press with a coil feed line are assumed, with a production rate of 30 parts per minute¹.



1. Discussion with Minster Press Inc., April 2010

The **preliminary** cost of the 2010 nitrided metal bipolar plates is estimated to be ~\$6/kW. The substrate alloy, stamping process, and nitriding process are the major cost drivers.



A quartz lamp nitriding process will be considered as a path to cost reduction, due to much reduced cycle time of ~10 minutes.



Progress 2010 Stack S2-2 Metal Bipolar Plate

US 20070082252; US 7,291,414 (GM)

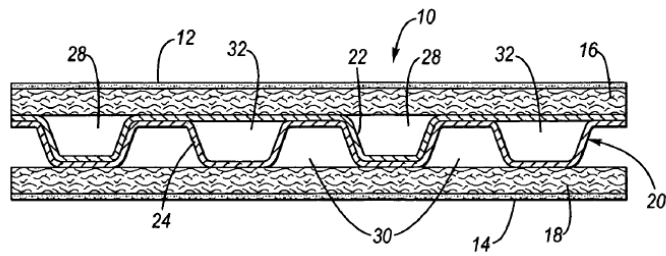


Fig. 1

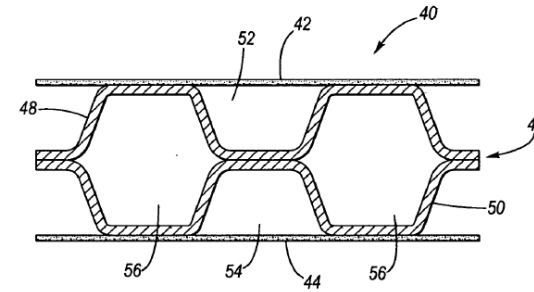


Fig. 2

TABLE I

Parameter	Nested ¹	Non-Nested ²	Nested ³
Cathode channel depth (mm)	0.34	0.35	0.34
Anode channel depth (mm)	—	0.31	—
Feed channel depth (mm)	0.17	—	0.17
Repeat distance (mm)	0.97	1.29	0.97
Anode ΔP (kPa)	13	13	30
Cathode ΔP (kPa)	30	30	85
Coolant ΔP (kPa)	57	22	106
Power density (kW/l)	6.0	4.8	6.3
Thermal mass (kJ/K)	20	27	19

¹Nested in active feed region, non-nested in inactive feed regions, and with no diffusion media in the inactive feed regions.

²Non-nested, and no inactive feed regions.

³Nested in active feed region, and non-nested in inactive feed regions, with diffusion media in the inactive feed regions.

[0038] Table I below provides a comparison of various parameters discussed above for a nested plate design according to the present invention having no diffusion media in the inactive feed regions, a non-nested plate design, and a nested plate design having diffusion media in the inactive feed regions. This data is from a fuel cell stack including a 360 cm² active area, 200 cells, 66 kW output power, 1.5 A/cm² current density and a low pressure. The nested designs are smaller than the non-nested designs, have a higher power density (higher kW/liter), and have an even greater reduction in thermal mass from 27 to 19-20 kJ/kilogram due to the reduced coolant volume. The nested plate design having diffusion media in the inactive feed regions produces very shallow feed channels in the inactive feed regions and leads to an unacceptably high pressure drop (85 kPa vs. 30 kPa on the cathode side).

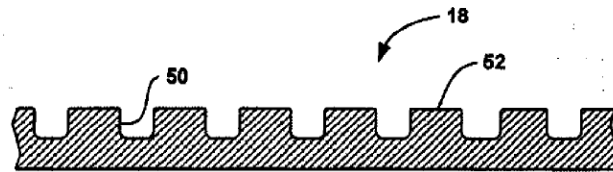
US 20090186253 (GM): 0.55 mm wide, 0.29 mm deep channels

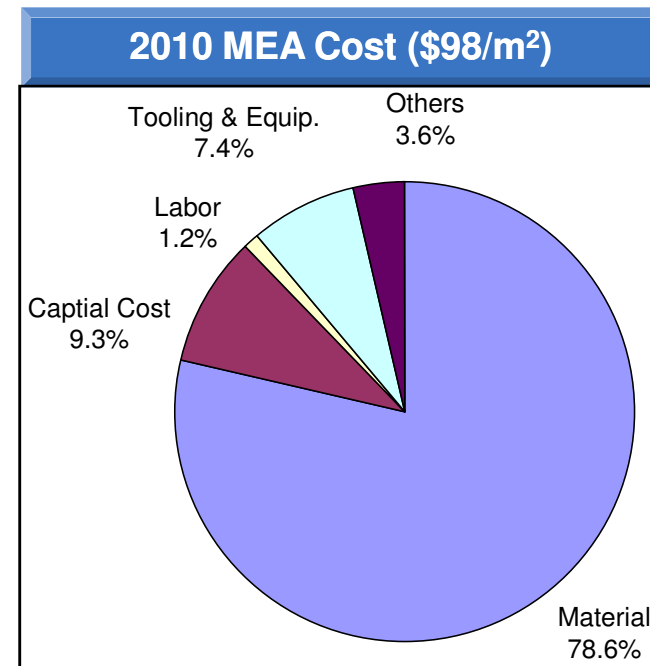
FIGURE 2
PRIOR ART

[0012] Current fuel cell stack designs typically focus on achieving high volumetric power density by reducing the active area of the fuel cell and increasing the current density. The key enabling design features of the bipolar plate 18 for this purpose include elimination of serpentine flow channels on the cathode side 12 to avoid accumulation of liquid water in the U-bends of the channels 50, and the reduction of the channel-to-channel pitch to maximize the utilization of the catalyst layer 22 under the lands 52 in the absence of a significant channel-to-channel pressure gradient. In this design, the cathode side bipolar plate 18 includes 108 nearly rectangular channels 50 with a width of 0.55 mm and a depth of 0.29 mm and a land width of 0.65 mm. These flow field plates provide operation above 600 mV at 1.5 A/cm². One example of such a flow field plate is disclosed in U.S. patent application Ser. No. 10/669,479, titled Flow Field Plate Arrangement For A Fuel Cell, filed Sep. 24, 2003.

Progress 2010 Stack S2-2 MEA Cost

Using S2-2 as an example scenario, we determined the cost breakout for the MEA; materials represent ~79% of the \$98/m² MEA cost in 2010.

Manufactured Cost	2009 MEA ¹ (\$/m ²)	2010 MEA ¹ (\$/m ²)
<i>Material</i>	76.70	77.19
- Membrane	- 9.77	- 15.99
- Electrode	- 58.69	- 59.14
- GDL	- 8.23	- 2.05
<i>Capital Cost</i>	6.18	9.09
<i>Labor</i>	3.85	1.15
<i>Tooling & Equipment</i>	4.21	7.32
<i>Other²</i>	2.03	3.51
Total	93	98



The **preliminary** estimate for the 2010 MEA cost is higher due to increased ionomer and ePTFE costs for the reinforced membrane, the reduction in active area ratio³ from 85% to 75%, reduction in MEA utilization from 100% to 95%, and refinement of GDL costing.



¹ m² of active area and kW of net power

² Other costs include utilities, maintenance, and building

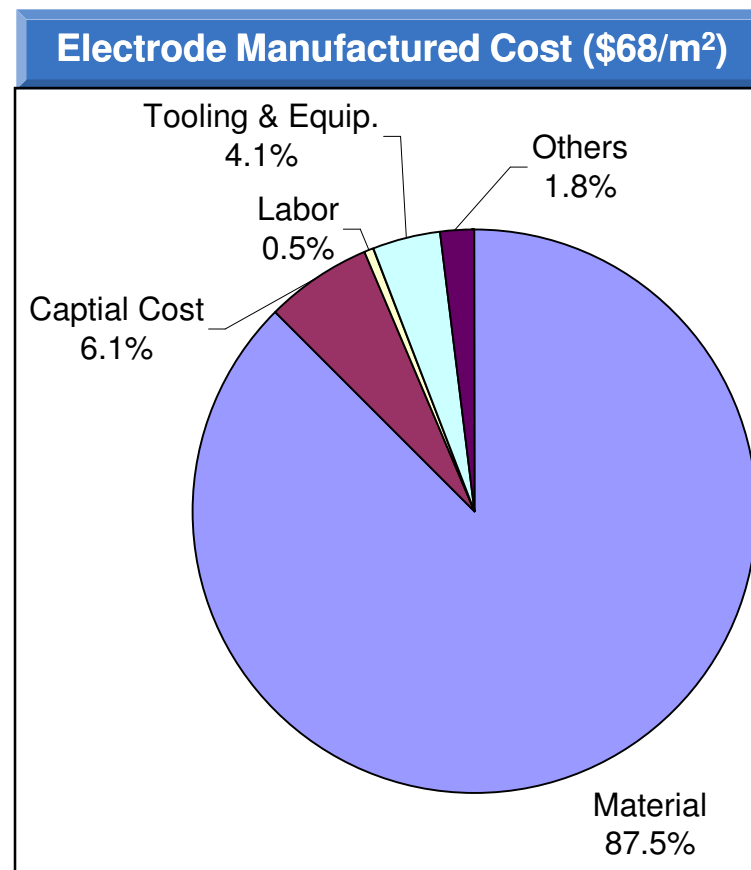
Progress 2010 Stack S2-2 Electrode Cost

Platinum price dominates the preliminary 2010 electrode cost estimate of \$68/m². We have assumed Pt price to be \$1,100/tr.oz. or \$35.4/g.

Manufactured Cost	Anode ¹ (\$/m ²)	Cathode ¹ (\$/m ²)	Total ¹ (\$/m ²)
Material	20.25	38.89	59.14
Capital Cost	1.58	2.56	4.14
Labor	0.16	0.19	0.35
Tooling	1.12	1.65	2.77
Other ²	0.50	0.72	1.22
Total	23.61	44.02	67.63

¹ m² of active area

² Other costs include utilities, maintenance, and building



Platinum at \$1,100/tr.oz. is close to the average price (\$1,096/tr.oz.) over the last year.



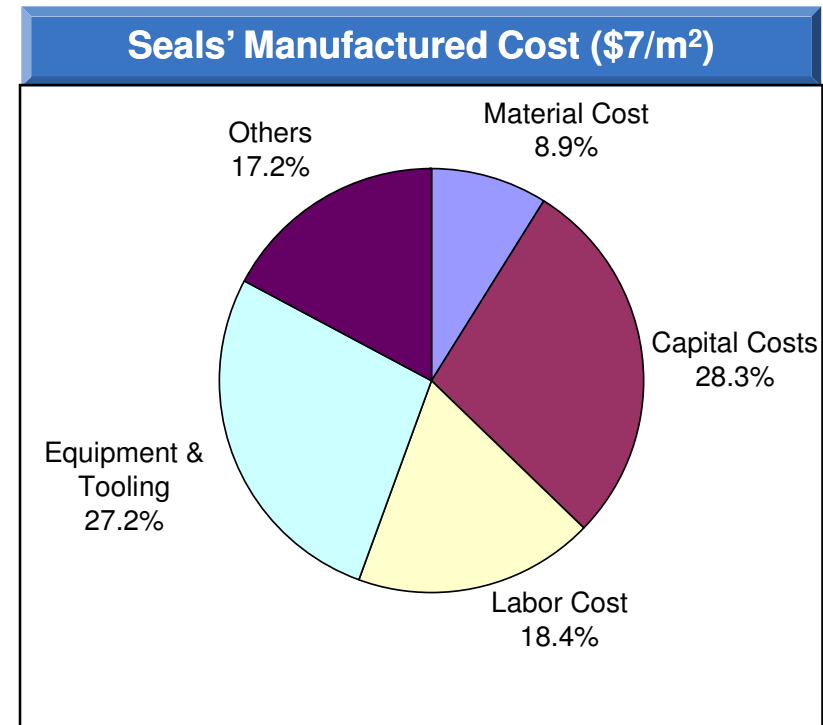
Progress 2010 Stack S2-2 Seal Cost

The **preliminary** cost of the 2010 seals is estimated to be ~\$7/m².

Manufactured Cost ¹	Seals (\$/m ²)
Material	0.63
Capital Cost	1.99
Labor	1.30
Tooling	1.92
Other ²	1.22
Total	7.05

¹ Manufactured cost on an active area basis

² Other costs include utilities, maintenance, and building



Transfer molding is used to fabricate the seals between the MEA and bipolar/cooling plate. The seal material is Viton[®] which costs ~\$20/lb.



Preliminary results of 2010 PEM fuel cell stack (S2-2) cost breakdown.

Stack Costs		Active Area Basis ¹				Total Fuel Cell Module Weight	Total Fuel Cell Module Mtl Cost (\$)	Total Fuel Cell Module Process Cost (\$)	Total Fuel Cell Module Cost (\$)	Total Fuel Cell Module Cost (\$/kW)
		Mtl Cost (\$/m ²)	Process Cost (\$/m ²)	Total Cost (\$/m ²)	Unit Cell Weight/Area (g/cm ²)					
MEA	Anode GDL	\$1.0	\$4.9	\$5.9	\$0.0	\$1.8	\$9.7	\$46.3	\$56.0	\$0.7
	Anode Active Layer	\$20.2	\$3.4	\$23.6	\$0.0	\$0.0	\$190.6	\$31.6	\$222.2	\$2.8
	Electrolyte	\$16.0	\$2.7	\$18.7	\$0.0	\$0.3	\$150.6	\$25.8	\$176.3	\$2.2
	Cathode Active Layer	\$38.9	\$5.1	\$44.0	\$0.0	\$0.0	\$366.1	\$48.3	\$414.4	\$5.2
	Cathode GDL	\$1.0	\$4.9	\$5.9	\$0.0	\$1.8	\$9.7	\$46.3	\$56.0	\$0.7
MEA Total		\$77.2	\$21.1	\$98.3	0.04	4	\$727	\$198	\$925	\$12
Bipolar Coolant Plate		\$24.8	\$28.1	\$52.9	\$0.1	\$20.1	\$233.0	\$264.9	\$497.9	\$6.2
Bipolar Interconnect ²		\$0.0	\$0.0	\$0.0	\$0.0	\$0.0	\$0.0	\$0.0	\$0.0	\$0.0
Gaskets						\$1.2	\$59.3	\$112.6	\$171.9	\$2.1
End Plates						\$0.7	\$2.9	\$1.2	\$4.1	\$0.1
Current Collector						\$0.4	\$1.0	\$0.5	\$1.6	\$0.0
Insulator						\$0.3	\$6.3	\$0.4	\$6.8	\$0.1
Outer Wrap						\$1.8	\$5.5	\$2.4	\$7.9	\$0.1
Tie Bolts						\$2.9	\$23.3	\$1.8	\$25.1	\$0.3
Final Assy								\$141.3	\$141.3	\$1.8
Total Unit Cell		\$101.9	\$49.2	\$151.2	0.11	31	\$1,058	\$724	\$1,781	\$22.3

¹ High-volume manufactured cost on an active area basis, for a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Based on stack and system modeling results by ANL for 2010 PEMFC system: R. K. Ahluwalia and X. Wang, March 31, 2010.

³ Assumes a Pt cost of \$1,100/tr.oz., NSTFC-based MEA, and 20 μ m reinforced PFSA membrane.

⁴ S2: stack inlet pressure @ rated power = 1.5 atm, stack temperature = 75 °C

⁵ Stack Assembly cost includes QC but not Stack Conditioning ; QC includes visual inspection, and leak tests for fuel loop, air loop and coolant loop

⁶ Task to "Estimate High-Volume Costs of Stack Conditioning" is planned to be completed in 2010, pending funding authorization from DOE

Progress 2009 Stack Performance Assumptions

Stack performance assumptions were updated by ANL based on their modeling of an NSTFC-based MEA and a 20 μm PFSA membrane.

Key Stack Performance Assumptions		2005 ¹	2007 ^{2,3}	2008 ⁴	2009 ⁵
Net power	kW_e	80	80	80	80
Gross power	kW_e	89.5	86.4	86.9	92.1
Gross power density	mW/cm^2	600	753	716	701
Cell voltage (rated power)	V	0.65	0.68	0.685	0.693
Pt loading (total)	mg/cm^2	0.75	0.30	0.25	0.15
Membrane thickness	μm	50	30	30	20
Stack temperature	$^{\circ}\text{C}$	80	90	90	90
Pressure (rated power)	atm	2.5	2.5	2.5	2.5
Stack eff. (rated power)	% LHV	52	54	54	55

¹ E.J. Carlson et al., Cost Analysis of PEM Fuel Cell Systems for Transportation, NREL/SR-560-39104, Sep 30, 2005

² R.K. Ahluwalia and X. Wang, Reference Fuel Cell System Configurations for 2007: Interim Results, ANL, Feb. 6, 2007

³ R.K. Ahluwalia, X. Wang and R. Kumar, Fuel Cell Systems Analysis, DOE Hydrogen Program Review, May 15-18, 2007

⁴ R. K. Ahluwalia, X. Wang and R. Kumar, Fuel Cell Systems Analysis, 2008 USDOE Hydrogen Program Review, Arlington, VA, June 9-13, 2008

⁵ R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

Key assumptions in 2009 represent ANL's inclusion of new performance data from 3M at the cell/short-stack level, and from Honeywell on the CEM parasitic power.



Progress 2009 PEMFC Stack \$/kW Cost

2009 stack costs on a per kW basis are lower than the 2008 stack costs primarily due to the lower Pt loading, thinner membrane, and reduced stack assembly time.

Stack Manufactured Cost ¹ , \$/kW	2005	2007	2008	2009	2010 DOE Target
Membrane	4	2	2	2	10
Electrodes	52	18	16	11	
GDL	3	2	2	2	
Seals	1	2	2	2	
Bipolar plates	3	3	3	3	5
Balance of Stack (Stack manifold, tie bolts, end plates, current collectors, electrical insulators)	1	1	1	1	
Stack Assembly ²	2	3	3	2	
Total³	67	31	29	22	25

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Stack Assembly cost in 2005 includes neither QC nor Stack Conditioning, while in 2007-2009, it includes QC but not Stack Conditioning.

³ Results may not appear to calculate due to rounding of the component cost results.

Progress 2009 PEMFC Stack $\$/m^2$ Cost

2009 stack costs on an active area basis are lower than the 2008 stack costs primarily due to the lower Pt loading, thinner membrane, and reduced stack assembly time.

Stack Manufactured Cost ¹ , $\$/m^2$	2005	2007	2008	2009
Membrane	23	16	16	11
Electrodes	279	120	102	65
GDL	18	13	13	10
Seals	6	13	13	15
Bipolar plates	17	18	18	18
Balance of Stack (Stack manifold, tie bolts, end plates, current collectors, electrical insulators)	6	6	6	6
Stack Assembly ²	10	23	23	12
Total³	361	210	191	136

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

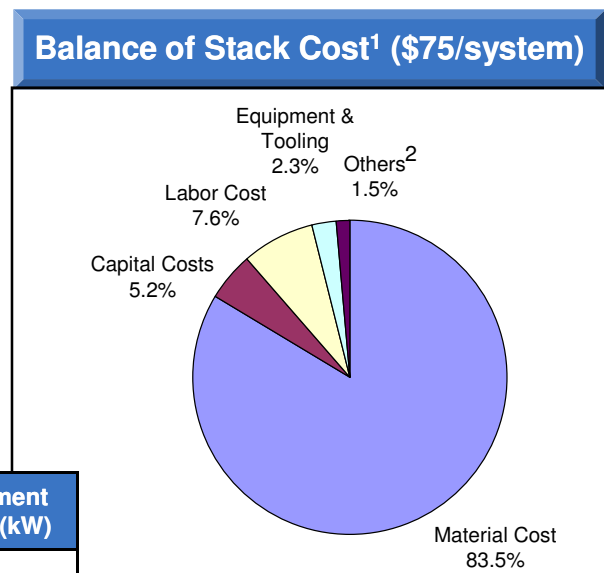
² Stack Assembly cost in 2005 includes neither QC nor Stack Conditioning, while in 2007-2009, it includes QC but not Stack Conditioning.

³ Results may not appear to calculate due to rounding of the component cost results.

Progress 2009 Balance of Stack Cost

Material costs represent ~84% of the Balance of Stack cost because the components have relatively simple, mature manufacturing processes.

Balance of Stack Cost ¹ (\$)	
Component	Cost (\$)
<i>Current Collectors</i>	3.7
<i>Insulators</i>	18.2
<i>End Plates</i>	10.2
<i>Tie Bolts</i>	21.4
<i>Stack Manifold / Outer Wrap</i>	21.2
Total	74.7



Process Name	Capex Per Station (\$)	# of Stations	Labor Per Station	Cycle Time (sec/unit)	Required Space (m ²)	Equipment Power (kW)
Die Cast Endplate	300,000	1	1	10	40	10
Die Cut Endplate Insulator	40,000	2	1	5	10	5
Cut T- Bolt	20,000	3	0.5	30	20	5
Wrap Manufacturing - Shear Stock	40,000	5	1	0.5	10	3
Wrap Manufacturing - Turret Punch	250,000	1	0.5	28	40	5
Wrap Manufacturing - Bend	105,000	1	1	65	160	5

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Other costs include utilities, maintenance, and building

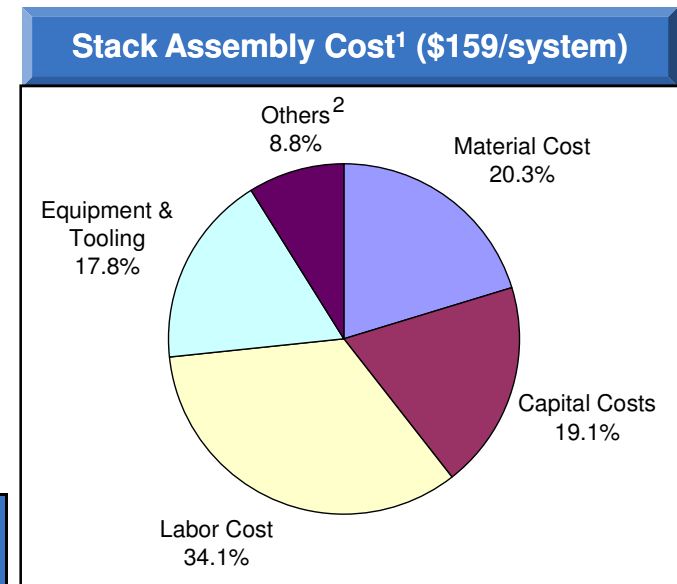


Progress 2009 Stack Assembly Cost

The assembly of the stack repeat units is assumed to be robotic, while the assembly of the balance of stack components is a manual process.

Stack Assembly Cost ¹ (\$)	
Component/Process	Cost (\$)
Repeat parts (robotic)	131.3
Non-repeat parts (manual)	5.2
Stack Quality Control ³	22.4
Total	158.9

Process Name	Capex Per Station (\$)	# of Stations	Labor Per Station	Cycle Time (sec/unit)	Required Space (m ²)	Equipment Power (kW)
Stack Assembly	400,000	83	0.2	1,135	20	10
Balance of Stack Assembly	20,000	44	0.2	600	20	5
Stack QC ³	300,000	66	0.2	900	20	5



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Other costs include utilities, maintenance, and building

³ Stack QC includes visual inspection, and leak tests for fuel loop, air loop and coolant loop

⁴ Task to "Estimate High-Volume Costs of Stack Conditioning" is planned to be completed in 2010, pending funding authorization from DOE

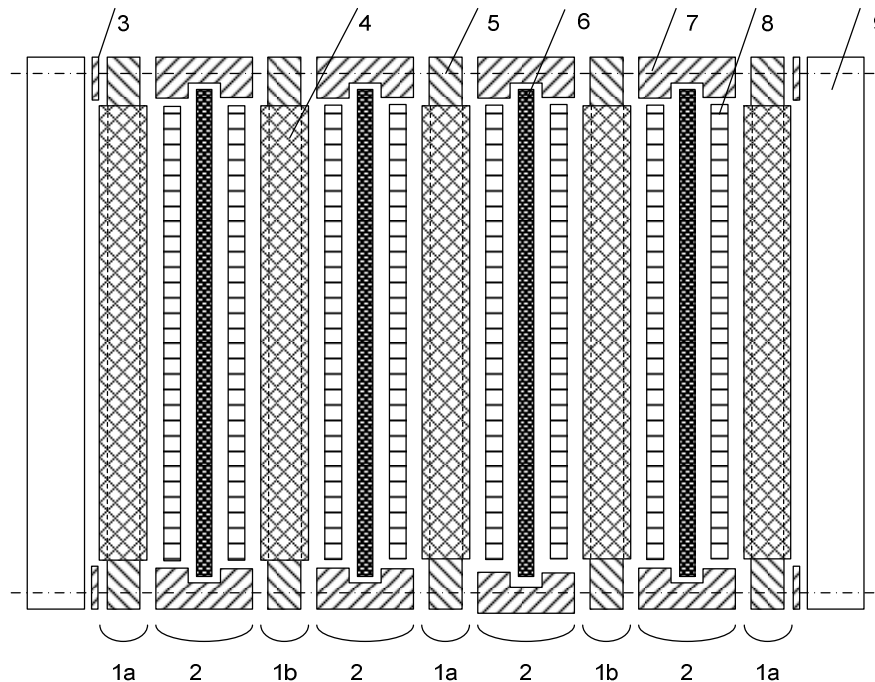
We estimate that 2 stacks and the BOS are assembled in ~1 hour. Stack assembly cost includes stack QC³, but not stack conditioning / burn-in costs⁴.



BOS = Balance of Stack

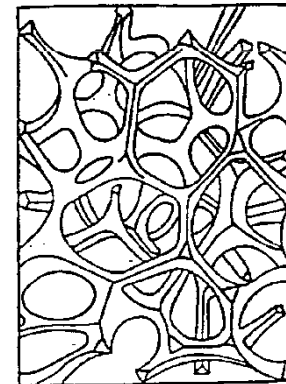
QC = Quality Control

We developed bottom-up manufacturing costs for the planar membrane humidifier based on ANL specifications¹ and other patents.



- 1a: Frame and foam unit to deliver air from fuel cell
- 1b: Frame and foam unit to deliver air to fuel cell
- 2: Gasket-GDL-Membrane unit
- 3: Endplate gasket
- 4: Metal/Carbon Foam
- 5: Frame
- 6: Membrane
- 7: Seal/Gasket
- 8: GDL
- 9: Endplate

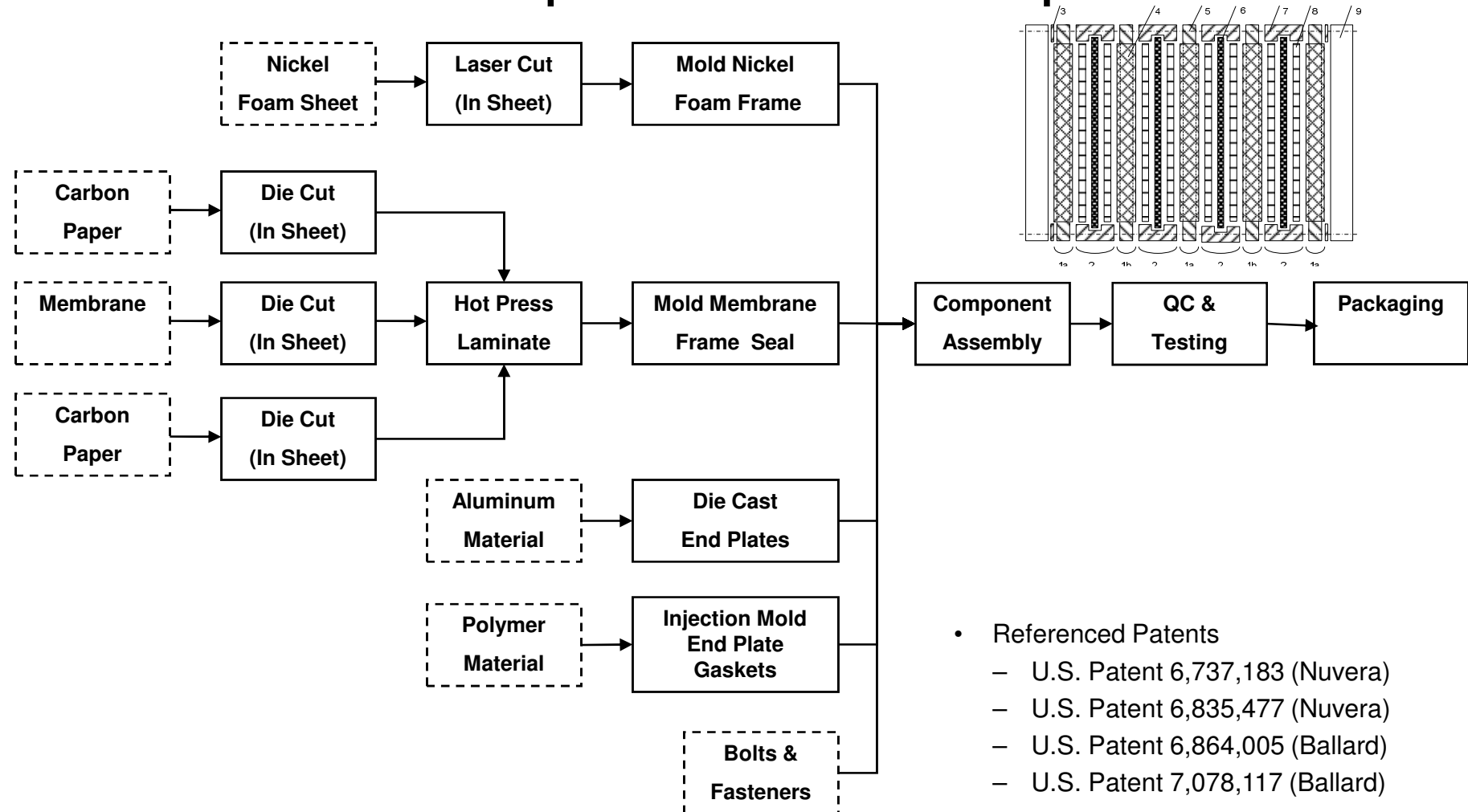
- Referenced Patents
 - U.S. Patent 6,737,183 (Nuvera)
 - U.S. Patent 6,835,477 (Nuvera)
 - U.S. Patent 6,864,005 (Ballard)
 - U.S. Patent 7,078,117 (Ballard)



Nickel foam (U.S. Patent 6,835,477)

¹ R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

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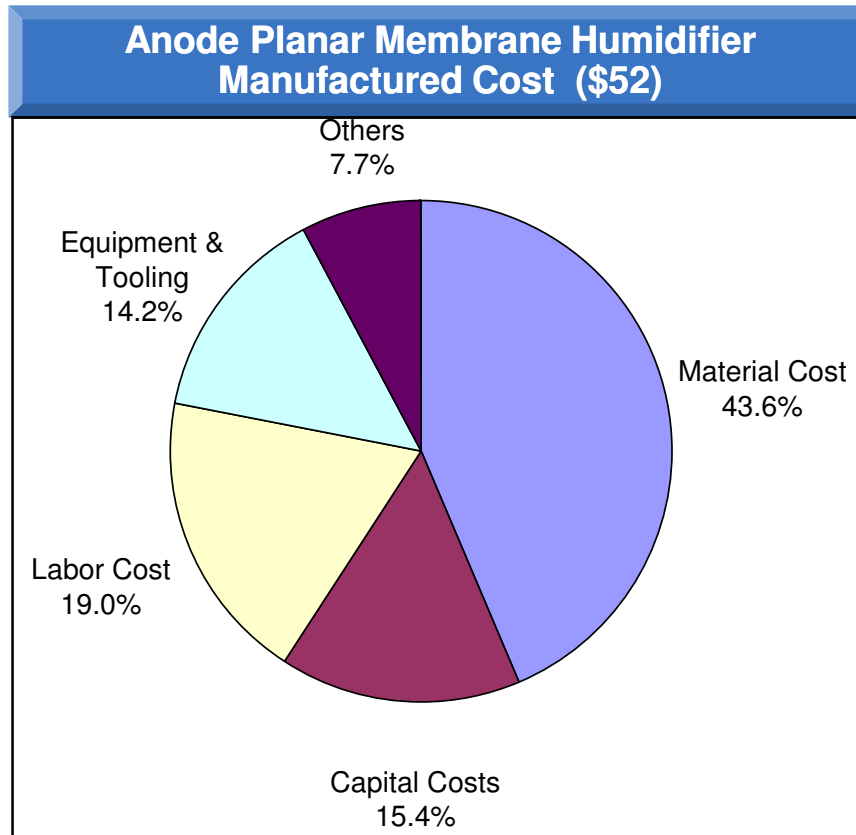
¹ R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

Bill of Materials for the cathode/anode planar membrane humidifiers

Cathode Planar Membrane Humidifier			
Component	#	Material	Size (mm)
Membrane	42	Nafion®	400 (length), 140 (width), 0.03 (thickness)
GDL	84	Woven carbon fiber	300 (length), 120 (width), 0.1 (thickness)
Nickel Foam	43	Nickel foam	300 (length), 120 (width), 1.5 (thickness)
Frame	43	HDPE	400 (length), 140 (width), 1.5 (thickness)
Membrane Gasket	42	Nitrile rubber	400 (length), 140 (width), 0.22 (thickness)
End Plate	2	Al	400 (length), 140 (width), 20 (thickness)
End Plate Gasket	2	Nitrile rubber	400 (length), 140 (width), 0.22 (thickness)
Bolt	4	Misc.	101 (length), 10 (OD)
Washer	4	Misc.	-
Nut	4	Misc.	-

Anode Planar Membrane Humidifier			
Component	#	Material	Size (mm)
Membrane	22	Nafion®	350 (length), 120 (width), 0.03 (Thickness)
GDL	44	Woven carbon fiber	250 (length), 100 (width), 0.1 (thickness)
Nickel Foam	23	Nickel foam	250 (length), 100 (width), 1.5 (thickness)
Frame	23	HDPE	350 (length), 120 (width), 1.5 (thickness)
Membrane Gasket	42	Nitrile rubber	350 (length), 120 (width), 0.22 (thickness)
End Plate	2	Al	350 (length), 120 (width), 20 (thickness)
End Plate Gasket	2	Nitrile rubber	350 (length), 120 (width), 0.22 (thickness)
Bolt	4	Misc.	68 (length), 10 (OD)
Washer	4	Misc.	-
Nut	4	Misc.	-

Material costs represent approximately 44% of the anode planar membrane humidifier manufactured cost of \$52.



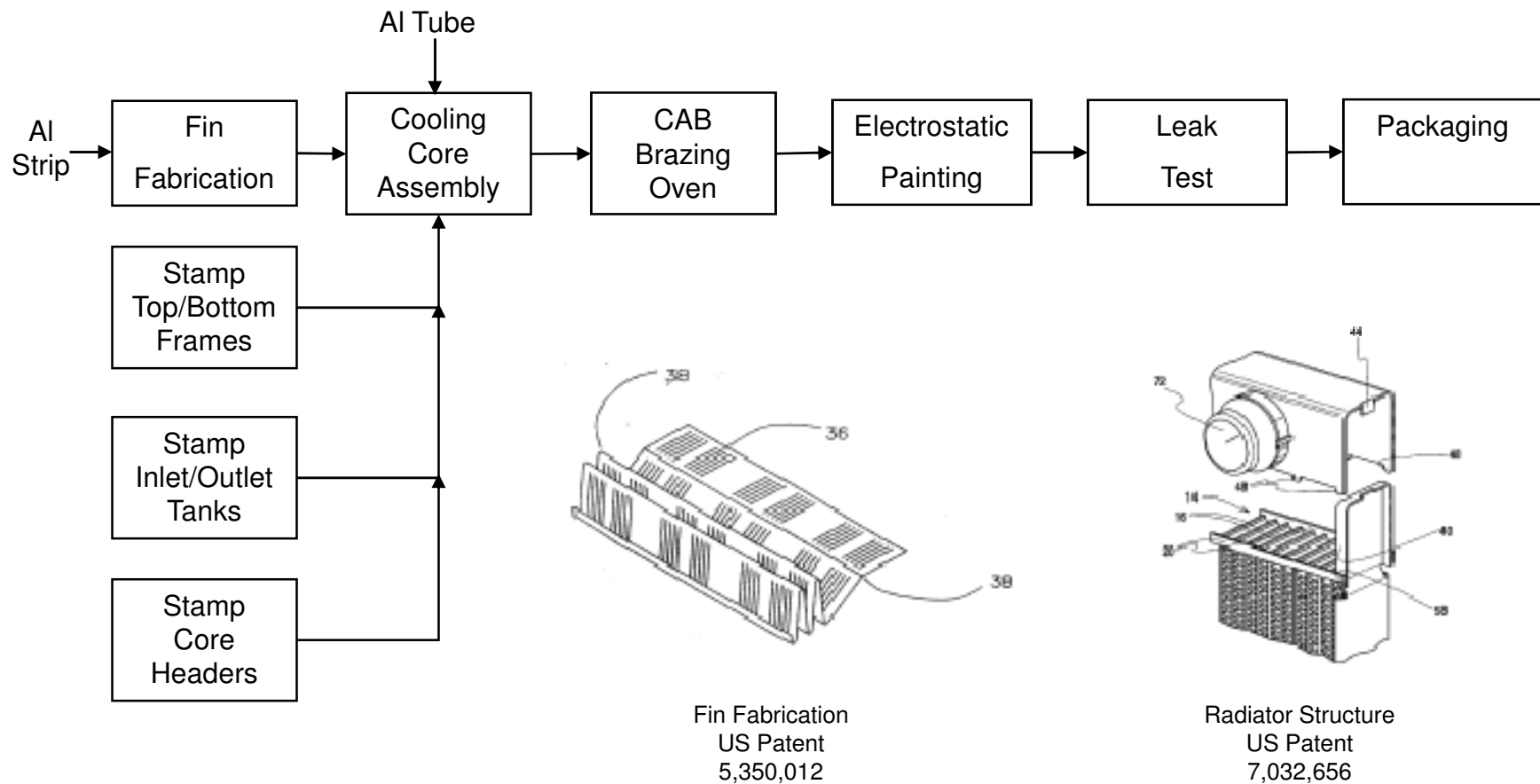
Anode Planar Membrane Humidifier Manufactured Cost (\$)			
Process	#	Material	Process
Die Cut GDL	1	0.91	1.05
Die Cut Membrane	2	3.68	1.12
Hot Press Lamination	3	0.00	3.18
Injection Molding Frame Seal	4	0.00	2.20
Laser Cut Nickel Foam	5	5.74	9.09
Injection Molding Foam Frame	6	2.35	2.47
Injection Molding End Plate Gasket	7	0.09	0.45
Die Casting End Plate	8	7.11	1.26
Component Assembly	9	0.00	3.62
QC & Testing	10	0.00	3.56
Packaging	11	0.00	1.06
Fastener Cost	-	2.63	0.00
Total	-	52	

The high-volume manufactured cost of the cathode planar membrane humidifier is estimated to be \$96.



Progress Radiator Process Flow

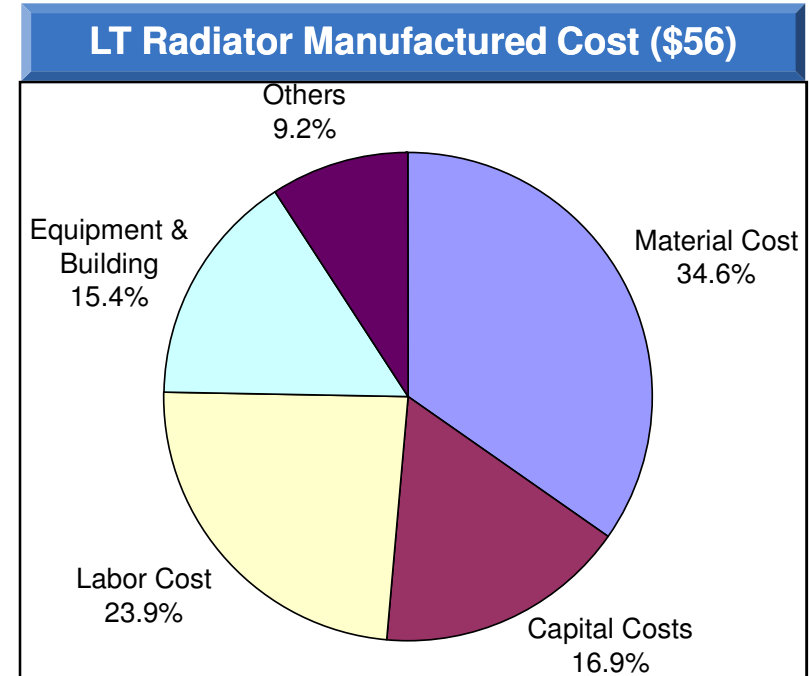
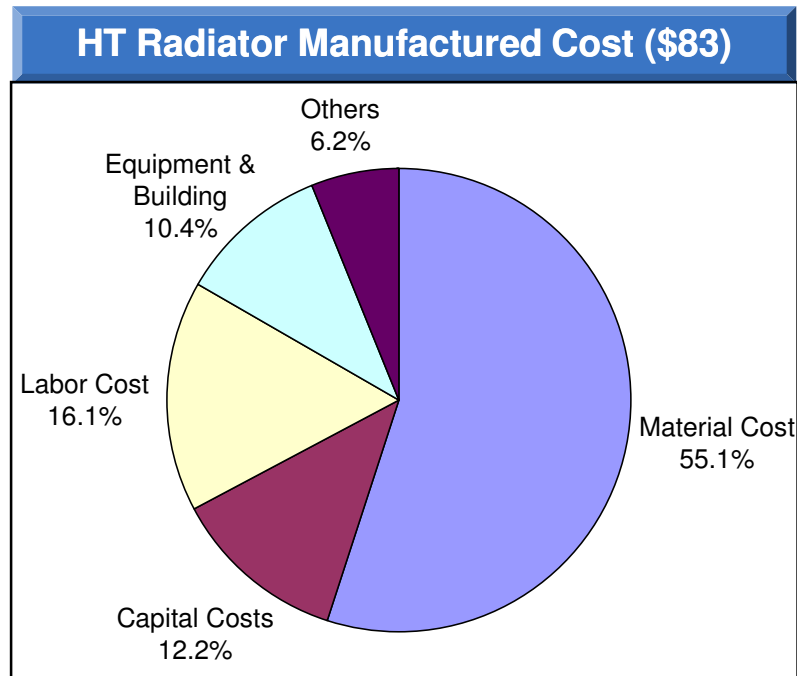
We developed a manufacturing process flow chart for the HT and LT radiators based on Modine patents and in-house experience.



We used a Modine all-aluminum automobile radiator structure as our baseline for developing a Bill of Materials for the HT/LT radiators.

High-Temperature (HT) Radiator					Low-Temperature (LT) Radiator				
#	Components	#	Mtl.	Size (L x W x H) (mm)	#	Components	#	Mtl.	Size (L x W x H) (mm)
1	Serpentine Louvered Fin	39208	Al 3003	59.70 x 4.44 x 0.10	1	Serpentine Louvered Fin	38381	Al 3003	17.00 x 4.04 x 0.08
2	Core Tube	61	Al 3003	700.00 x 59.70 x 2.80	2	Core Tube	64	Al 3003	700.00 x 17.00 x 2.80
3	Inlet Header, Solder Well Type	1	Al 3003	546.00 x 99.70 x 1.80	3	Inlet Header, Solder Well Type	1	Al 3003	523.80 x 57.00 x 1.80
5	Outlet Header, Solder Well Type	1	Al 3003	546.00 x 99.70 x 1.80	5	Outlet Header, Solder Well Type	1	Al 3003	523.80 x 57.00 x 1.80
8	Top Side Piece	1	Al 3003	720.00 x 99.70 x 1.80	8	Top Side Piece	1	Al 3003	720.00 x 57.00 x 1.80
9	Bottom Side Piece	1	Al 3003	720.00 x 99.70 x 1.80	9	Bottom Side Piece	1	Al 3003	720.00 x 57.00 x 1.80
10	Inlet Tank	1	Al 3003	446.00 x 140.00 x 1.80	10	Inlet Tank	1	Al 3003	423.80 x 140.00 x 1.80
11	Inlet Hose Connection	1	Al 3003	50.40	11	Inlet Hose Connection	1	Al 3003	50.40
12	Outlet Tank	1	Al 3003	446.00 x 140.00 x 1.80	12	Outlet Tank	1	Al 3003	423.80 x 140.00 x 1.80
13	Outlet Hose Connection	1	Al 3003	50.40	13	Outlet Hose Connection	1	Al 3003	50.40
14	Filler neck/Overflow Tub	1	Al 3003	25.40	14	Filler neck/Overflow Tub	1	Al 3003	25.40
15	Drain Fitting	1	Al 3003	25.40	15	Drain Fitting	1	Al 3003	25.40
16	Heater Return Line Connection	1	Al 3003	25.40	16	Heater Return Line Connection	1	Al 3003	25.40
17	Coolant Level Indicator Fitting	1	Al 3003	25.40	17	Coolant Level Indicator Fitting	1	Al 3003	25.40

The HT radiator manufactured cost is projected to be \$83, while the LT radiator manufactured cost is projected to be \$56.



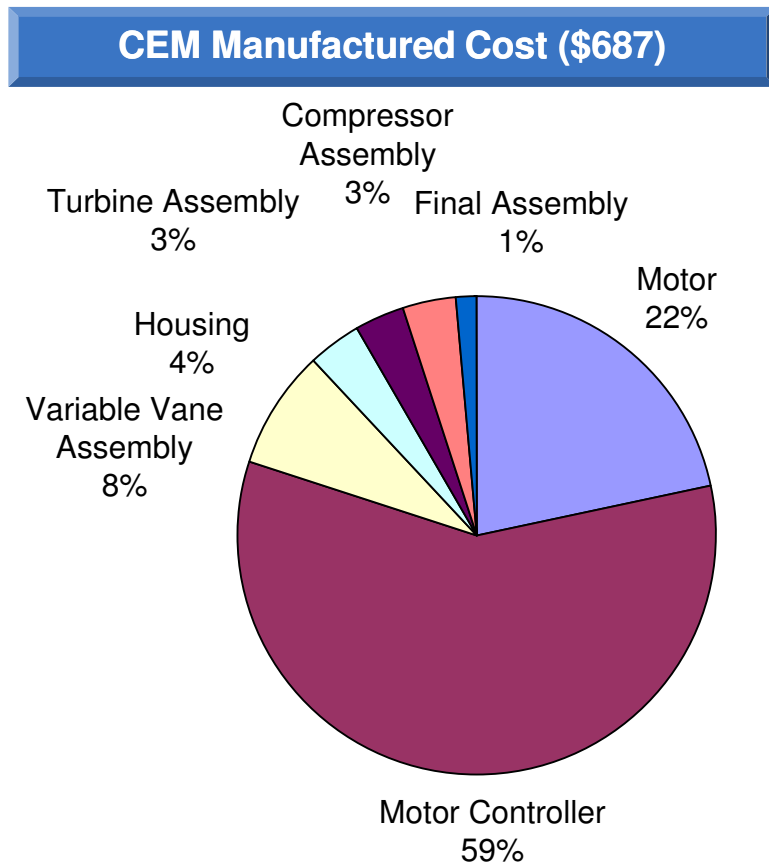
Since the electric drive motor accounts for 10 kW of the 12.9 kW heat duty of the LT radiator, we account for ~22.5% of the \$56/unit cost of the LTR within the scope of the Fuel Cell System cost.

The motor assembly and motor controller are projected to cost \$564, representing 82% of the CEM manufactured cost.

Motor Subsystems	Components	Manufactured Cost (\$)	Comments
Stator Assembly	Copper Coils	26	Assumed purchased part. The price is direct materials with a markup of 1.15. 1 kg copper coil (\$7/kg) and 3.6 kg laminated steel (\$4.4/kg) with a markup of 1.15.
	Steel Laminations		
Rotor Assembly	Shaft	11	DFMA machining package
	Magnets	49	0.55 kg NdFeB magnet with a cost of \$88/kg
	Journal Foil Bearing	21	Assumed purchased part at \$10 each
	Thrust Journal Bearings	21	Assumed purchased part at \$10 each
	Thrust Bearing Runner	8	DFMA machining package
	Thrust Bearing Holder	9	DFMA machining package
	Seals, collar, etc.	17	Assumed purchased parts
Motor Controller	9.3 kW_e Inverter with DSP controller	372	\$40/kW from "A Novel Bidirectional Power Controller for Regenerative Fuel Cells", Final Report for DE-FG36-04GO14329, J. Hartvigsen and S.K. Mazumder, Oct. 10, 2005
	Packaging, Wire harness, thermal management, etc	30	
Total Motor Cost (\$/unit)		564	

The 9.3 kW_e inverter is projected to dominate the motor controller cost.

The CEM manufactured cost of \$687, is the single largest cost contributor to the overall BOP cost.



CEM Cost (\$)		
Component	Factory Cost ¹	OEM Cost ^{1,2}
Motor	162	790
Motor Controller ³	402	
Variable Vane Assembly	50	
Housing	28	
Turbine Assembly	24	
Compressor Assembly	21	
Total:	687	

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components

³ \$40/kW from "A Novel Bidirectional Power Controller for Regenerative Fuel Cells", Final Report for DE-FG36-04GO14329, J. Hartvigsen and S.K. Mazumder, Oct. 10, 2005

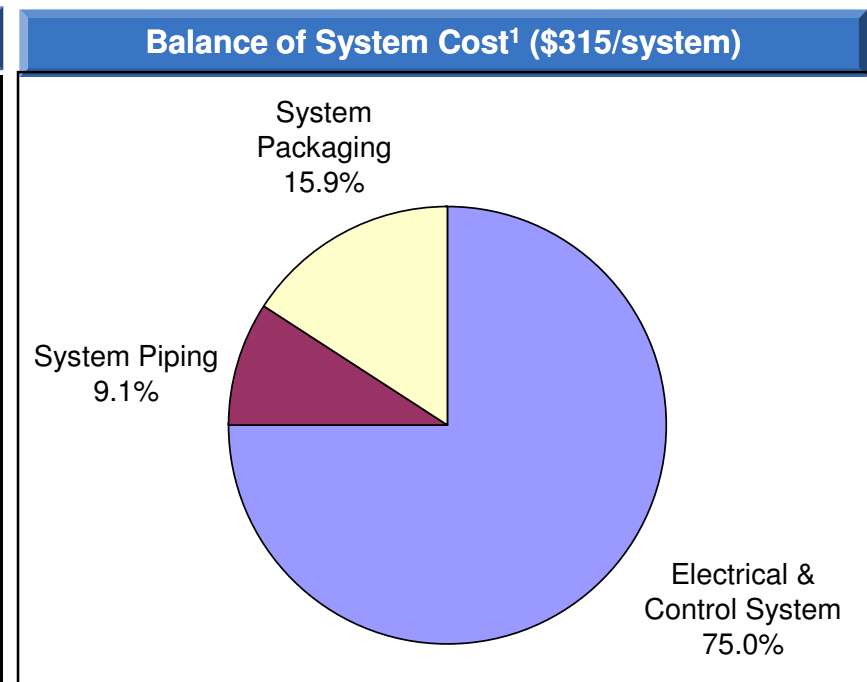
The motor assembly and motor controller (9.3 kW_e) are projected to cost \$564, representing 82% of the CEM manufactured cost.



Progress 2009 PEMFC System *Balance of System Cost*

The balance of system includes the electrical & controls system, system piping, and system packaging.

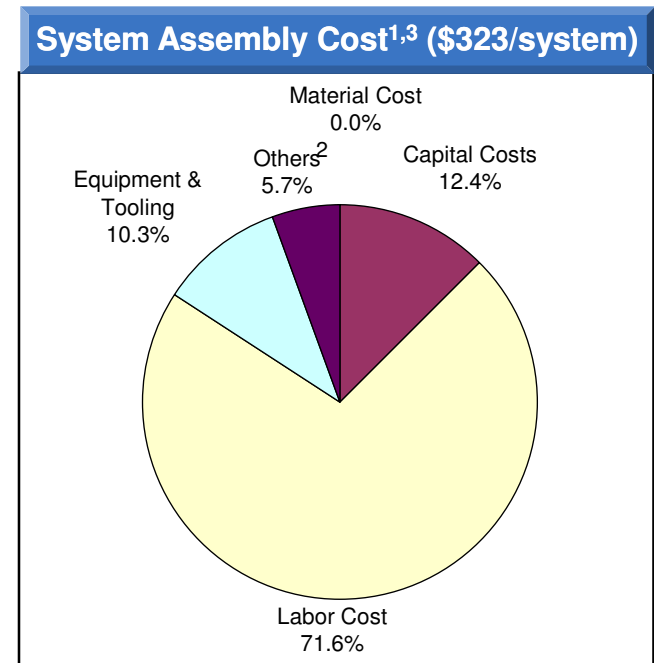
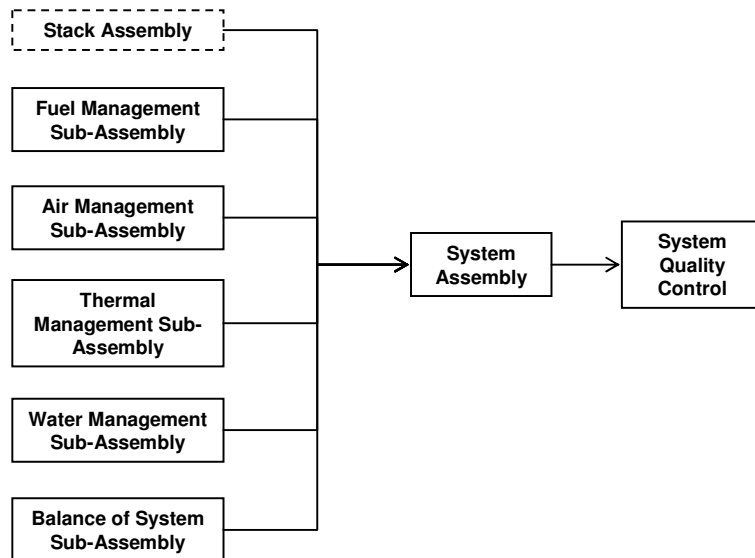
Balance of System Cost ¹ (\$)		
Balance of System	#	\$315.38
Startup Power	0	
Startup Battery	0	
Switching Regulator for recharging (on MB)	0	
Electrical & Controls System	1	\$236.58
Main Control Board	1	\$6.00
Control Power Regulator	1	\$6.00
Control Power Circuit Breaker	1	\$2.00
Distributed Processors	3	\$6.00
On/off Power FET to control solenoid valves	3	\$3.00
Pre Cooler Fan Motor Relay	1	\$2.00
Sensor Signal Conditioning	1	\$10.00
Memory chip for history	1	\$10.00
Main Wiring Harness		
RTD Sensor Wiring	12	\$7.02
Other Sensor Wiring	24	\$14.05
On/Off Valve Wiring	4	\$3.51
Motor Control Wiring	24	\$14.05
Connectors	18	\$6.58
Power Wiring	8	\$19.20
Safety Contactor	1	\$30.00
Sensors		
Humidity	1	\$8.36
Flow Rate	1	\$10.00
Differential Pressure	2	\$18.80
Temperature	2	\$5.00
H ₂ sensor for anode exhaust	1	\$45.00
Prestack CO sensor	1	\$10.00
System Piping		\$28.80
Piping		\$4.80
Fittings (Ts/ends)		\$24.00
System Packaging	1	\$50.00



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

A complete 80 kW_{net} PEMFC system (including two stacks, balance-of-stack, BOP subsystems, balance-of-system, stack QC, and system QC) is estimated to be assembled in ~ 5 hours.

Process Name	Capex Per Station (\$)	# of Stations	Labor Per Station	Cycle Time (min/unit)	Required Space (m ²)	Equipment Power (kW)
System Assembly ³	200,000	462	1	213	20	10
System QC ⁴	300,000	33	2	15	20	10



¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Other costs include utilities, maintenance, and building

³ System Assembly category includes BOP subsystem assembly, balance-of-system assembly, and final system assembly

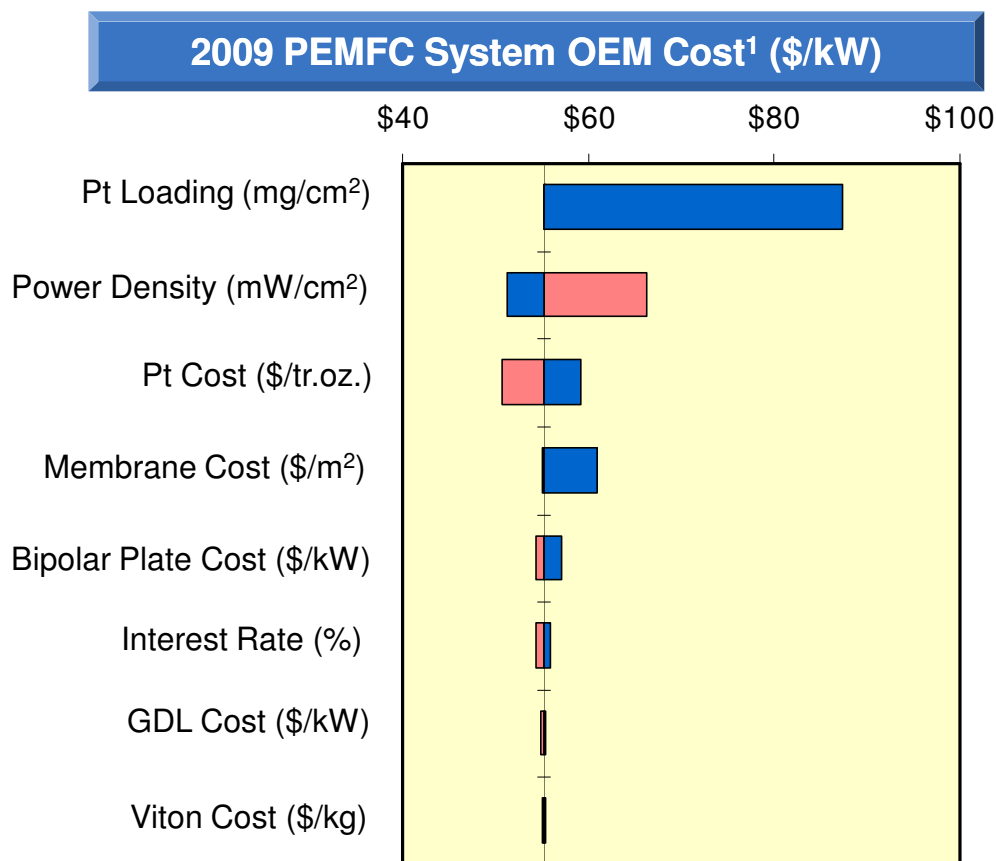
⁴ System QC includes visual inspection, leakage tests, and power-on/voltage test

System Quality Control⁴ cost is included, while system conditioning / break-in is not included.

We performed single- and multi-variable sensitivity analyses to examine the impact of major stack and BOP parameters on PEMFC system cost.

- Single variable stack sensitivity analysis
 - Varied one parameter at a time, holding all others constant
 - Varied overall manufacturing assumptions, economic assumptions, key stack performance parameters, and direct material cost, capital expenses and process cycle time for individual stack components
 - Assumed stack rated power, operating pressure, temperature, humidity requirements and cell voltage remained invariant
- Single variable BOP sensitivity analysis
 - Varied one parameter at a time, holding all others constant
 - Varied overall manufacturing assumptions, economic assumptions, and direct material cost, capital expenses and process cycle time for individual BOP components
 - Assumed stack rated power, operating pressure, temperature, humidity requirements and cell voltage remained invariant
- Multi-variable (Monte Carlo) system sensitivity analysis
 - Varied all stack and BOP parameters simultaneously, using triangular PDF
 - Performed Monte Carlo analysis on individual stack and BOP components, the results of which were then fed into a system-wide Monte Carlo analysis

Pt loading, power density, and Pt cost are the top three drivers of the PEMFC system cost¹.



#	Variables	Min	Max	Base	Comments
1	Pt Loading (mg/cm ²)	0.15	0.75	0.15	Minimum: 2009 status; Maximum: TIAX 2005 report ²
2	Power Density (mW/cm ²)	350	1000	701	Minimum: industry feedback; Maximum: DOE 2015 target ³ .
3	Pt Cost (\$/tr.oz.)	450	1675	1100	Minimum: ~ 108-year min. in 2007 \$ ⁴ ; Maximum: 12-month maximum LME price ⁵
4	Membrane Cost (\$/m ²)	10	50	11.4	Minimum: GM ⁶ study; Maximum: DuPont ⁷ projection from 2002
5	Bipolar Plate Cost (\$/kW)	1.8	5.0	2.9	Minimum: Based on component single variable sensitivity analysis; Maximum: DOE 2010 target ³
6	Interest Rate (%)	8%	20%	15%	Based on industry feedback
7	GDL Cost (\$/kW)	1.3	1.9	1.6	Minimum: 80% of the baseline; Maximum: 120% of the baseline
8	Viton Cost (\$/kg)	39	58	48	Based on industry feedback

1. High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW). Assumes a % markup to automotive OEM for BOP components.

2. Carlson, E.J. et al., "Cost Analysis of PEM Fuel Cell Systems for Transportation", Sep 30, 2005, NREL/SR-560-39104

3. http://www1.eere.energy.gov/hydrogenandfuelcells/mypp/pdfs/fuel_cells.pdf

4. www.platinum.matthey.com

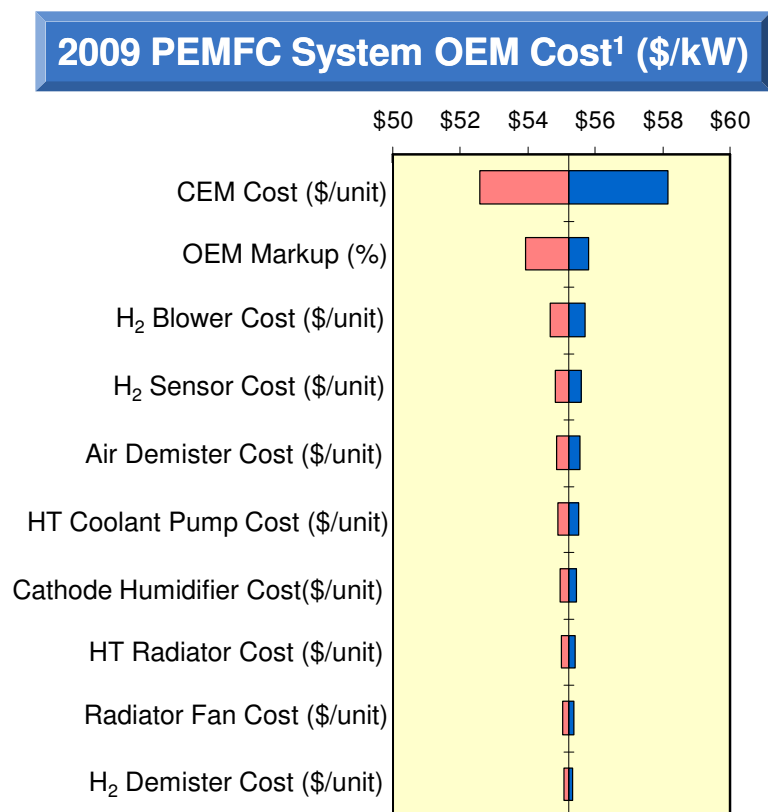
5. www.metalprices.com

6. Mathias, M., "Can available membranes and catalysts meet automotive polymer electrolyte fuel cell requirements?", Am. Chem. Soc. Preprints, Div. Fuel Chem., 49(2), 471, 2004

7. Curtin, D.E., "High volume, low cost manufacturing process for Nafion membranes", 2002 Fuel Cell Seminar, Palm Springs, Nov 2002



Among the BOP components, the CEM has the greatest impact on the PEMFC system cost¹.



#	Variables	Min	Max	Base	Comments
1	CEM Cost (\$/unit)	472	925	687	Based on component single variable sensitivity analysis
2	OEM Markup (%)	5%	20%	15%	Based on industry feedback
3	H ₂ Blower Cost (\$/unit)	177	259	219	Based on component single variable sensitivity analysis
4	H ₂ Sensor Cost (\$/unit)	10	80	45	UTRC Final Report ²
5	Air Demister Cost (\$/unit)	125	187	156	Min. & Max: ±20% of the base
6	HT Coolant Pump Cost (\$/unit)	120	180	150	Min. & Max: ±20% of the base
7	Cathode Humidifier Cost (\$/unit)	77	116	96	Min. & Max: ±20% of the base
8	HT Radiator Cost (\$/unit)	66	99	83	Min. & Max: ±20% of the base
9	HT/LT Radiator Fan Cost (\$/unit)	60	90	75	Min. & Max: ±20% of the base
10	H ₂ Demister Cost (\$/unit)	49	73	61	Min. & Max: ±20% of the base
11	Anode Humidifier Cost (\$/unit)	41	62	52	Min. & Max: ±20% of the base
12	System Packaging Cost (\$/unit)	40	60	50	Min. & Max: ±20% of the base
13	Fuel Solenoid Valve Cost (\$/unit)	37	56	46	Min. & Max: ±20% of the base
14	Air Precooler Cost (\$/unit)	35	52	43	Min. & Max: ±20% of the base
15	LT Coolant Pump Cost (\$/unit)	24	36	30	Min. & Max: ±20% of the base
16	Power System Safety Contactor Cost (\$/unit)	24	36	30	Min. & Max: ±20% of the base
17	Air/H ₂ Mixer Cost (\$/unit)	22	33	27	Min. & Max: ±20% of the base
18	H ₂ Purge Valve Cost (\$/unit)	10	16	13	Min. & Max: ±20% of the base
19	H ₂ Check Valve Cost (\$/unit)	7	11	9	Min. & Max: ±20% of the base

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW). Assumes a % markup to automotive OEM for BOP components.

² Knight, B., Clark, T. et al., "Development of Sensors for Automotive PEM-based Fuel Cells", DE-FC04-02AL67616, Dec. 2005

Progress 2009 PEMFC System *Volume and Weight*

The power density and specific power of the 2009 stack and system do not meet the DOE 2010 targets.

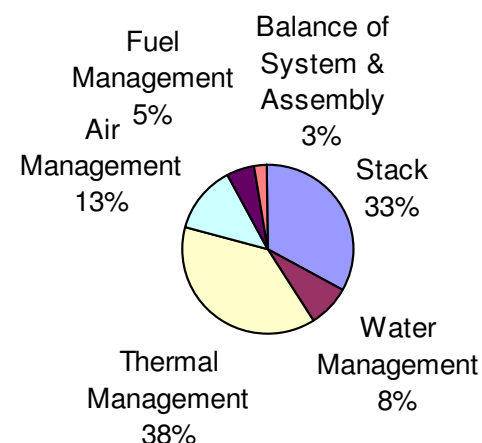
PEMFC Subsystem	Volume ¹ (L)	Weight (kg)	DOE 2010 Target
Stack	42	45	
Membrane	0.3	0.4	
Electrodes	0.0	0.0	
GDL	4.8	4.8	
Seals	0.9	1.8	
Bipolar plates	31.0	26.2	
Balance of Stack	4.5	11.9	
Power Density ^{1,2} (W _e /L)	1,905		2,000
Specific Power ² (W _e /kg)	1,778		2,000
Balance of Plant	84	96	
Water Management	10	8	
Thermal Management	48	31	
Fuel Management	6	10	
Air Management	17	19	
Balance of System & System Assembly	3	27	
Total System	126	141	
Power Density ^{1,2} (W _e /L)	635		650
Specific Power ² (W _e /kg)	567		650

¹ Does not include packing factor, which would lower volumetric power density

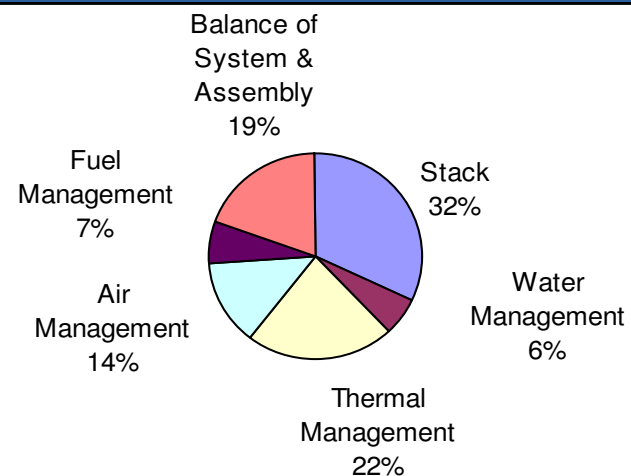
² Based on stack net power output of 80 kW, and **not** on the gross power output



2009 PEMFC System Volume (126 L)



2009 PEMFC System Weight (141 kg)



Approach Overall Cost Assessment

Manufacturing cost estimation involves technology assessment, cost modeling, and industry input to vet assumptions and results.

Technology Assessment

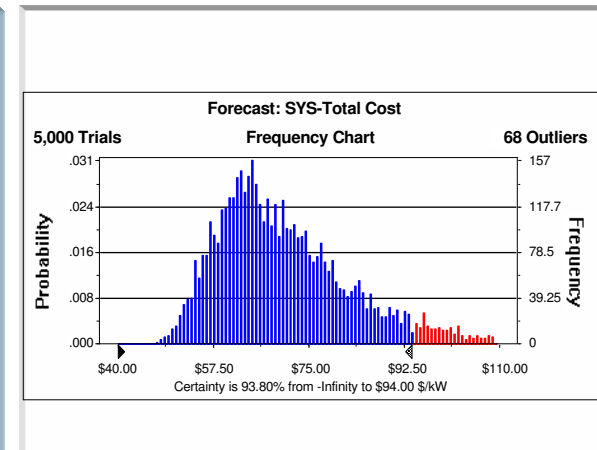
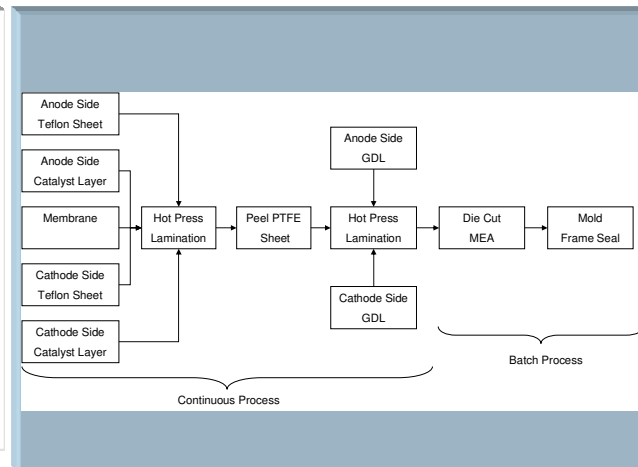
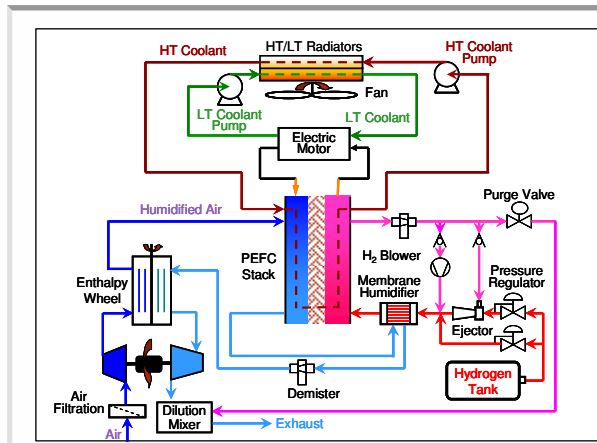
- Perform Literature Search
- Outline Assumptions
- Develop System Requirements and Component Specifications
- Obtain Developer Input

Cost Model and Estimates

- Develop Bulk Cost Assumptions
- Develop BOM
- Specify Manufacturing Processes and Equipment
- Determine Material and Process Costs

Overall Model Refinement

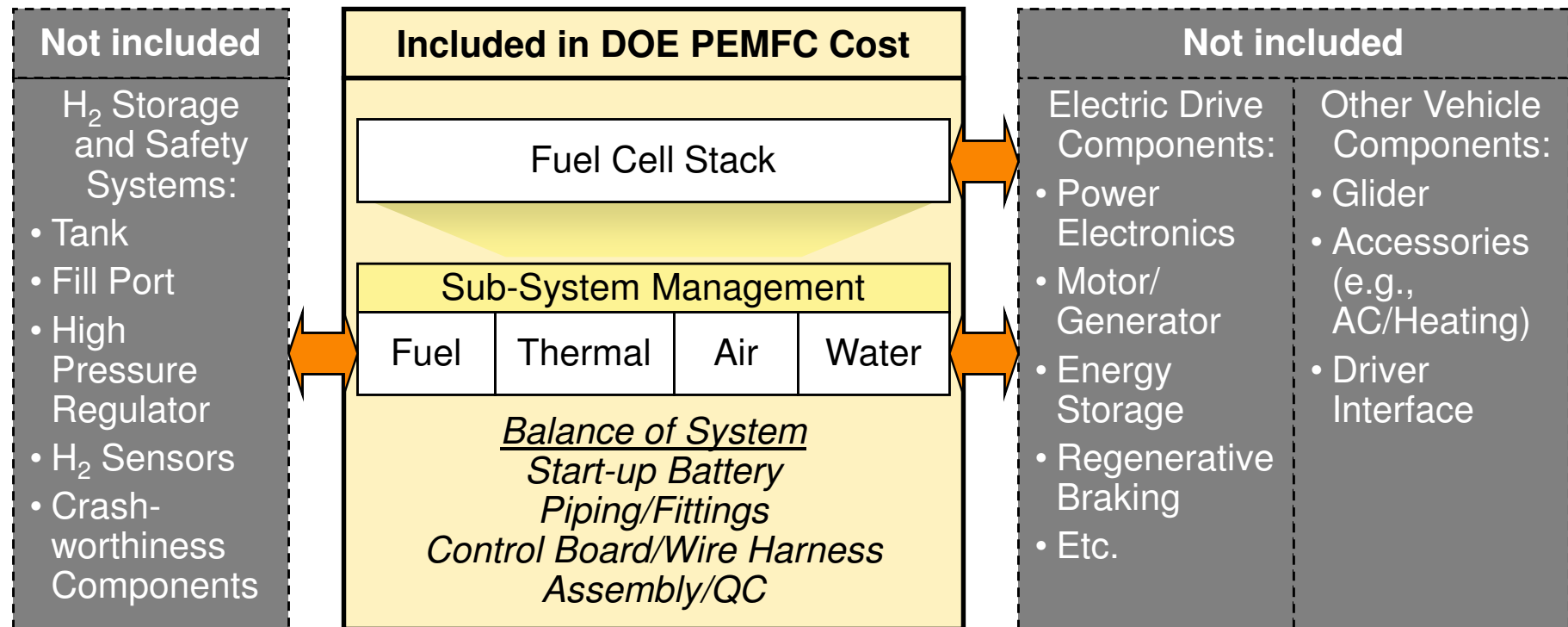
- Obtain Developer and Industry Feedback
- Revise Assumptions and Model Inputs
- Perform Sensitivity Analyses



BOM = Bill of Materials

Approach Scope

Our cost assessment includes the fuel cell stack and related BOP subsystems, but does not include electric drive or other necessary powertrain components.



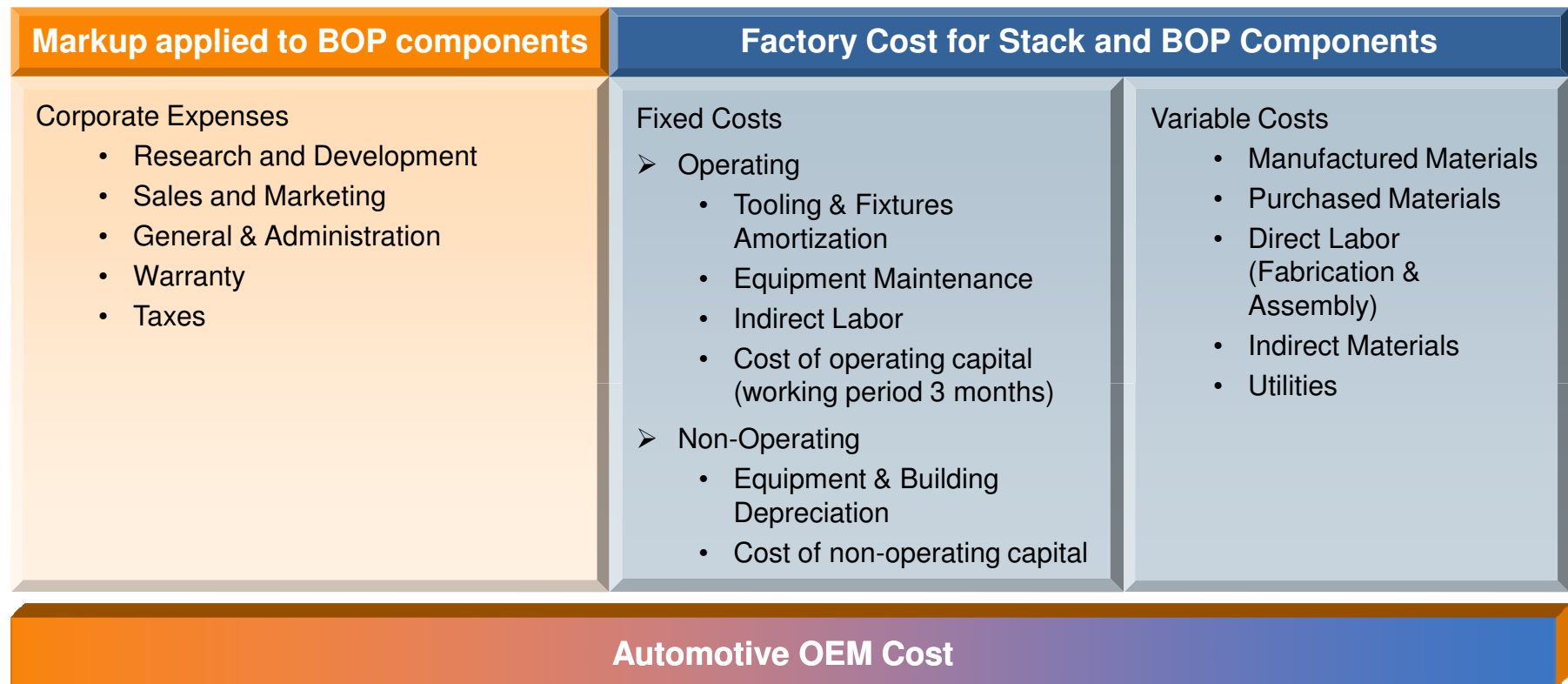
Quality Control (QC) includes leak and voltage tests, but does not include stack conditioning¹.



¹ Task to "Estimate High-Volume Costs of Stack Conditioning" is planned to be completed in 2010, pending funding authorization from DOE

Approach Cost Definition

We estimate an automotive OEM cost, applying no markup on stack components, and assuming a 15% markup on BOP components.



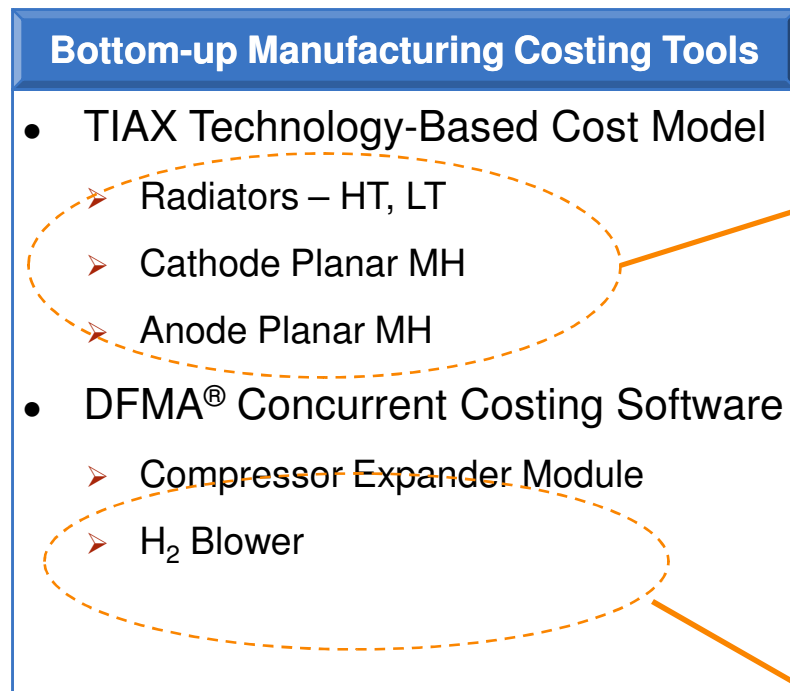
- We assume a vertically integrated process for the manufacture of the stack by the automotive OEM, so no mark-up is included on the major stack components
- Raw materials are assumed to be purchased, and therefore implicitly include supplier markup
- We assume 100% debt financed with an annual interest rate of 15%, 10-year equipment life, and 25-year building life.



OEM = Original Equipment Manufacturer (i.e., car company)

Approach Bottom-up BOP Costing Tools

We used two different bottom-up costing tools to estimate the high-volume cost of the major BOP components¹.



TIAX Technology-Based Cost Model

- Defines process scenarios according to the production volume
- Easily defines both continuous as well as batch processes
- Breaks down cost into various categories, such as material, labor, utility, capital, etc.
- Assumes dedicated process line – yields higher cost at low production volumes

DFMA[®] Concurrent Costing

- Has a wide range of built-in manufacturing databases for traditional batch processes, such as casting, machining, injection molding, etc.
- Initially developed for the automotive industry; not well suited for processes used in manufacture of PEMFC stacks
- Does not assume dedicated process line – yields lower cost at low production volumes

¹ We scaled quotes/catalog-based estimates for BOP components such as air precooler, needle metering valve, coolant pumps, radiator fans, H₂ ejectors, valves/regulators and piping/fittings.



Progress 2009 Stack Material Assumptions

To be consistent with ANL's stack performance model, we made the following material assumptions for the 2009 cost projection.

Component	Parameter	Selection
Membrane	Material	20 μm PFSA
	Supported	No mechanical reinforcement; assumed to be chemically stabilized
Electrodes (Cathode and Anode)	Catalyst	Ternary PtCo_xMn_y alloy
	Type	Nano-Structured Thin Film
	Support	PR-149 Organic whiskers
Gas Diffusion Layer (GDL)	Material	180 μm Woven carbon fiber
	Porosity	70%
Bipolar Plate	Type	Expanded graphite foil
Seal	Material	Viton®

We used a Pt price of \$1,100/tr.oz. for the baseline analysis and captured the impact of variation in Pt price through sensitivity analyses.



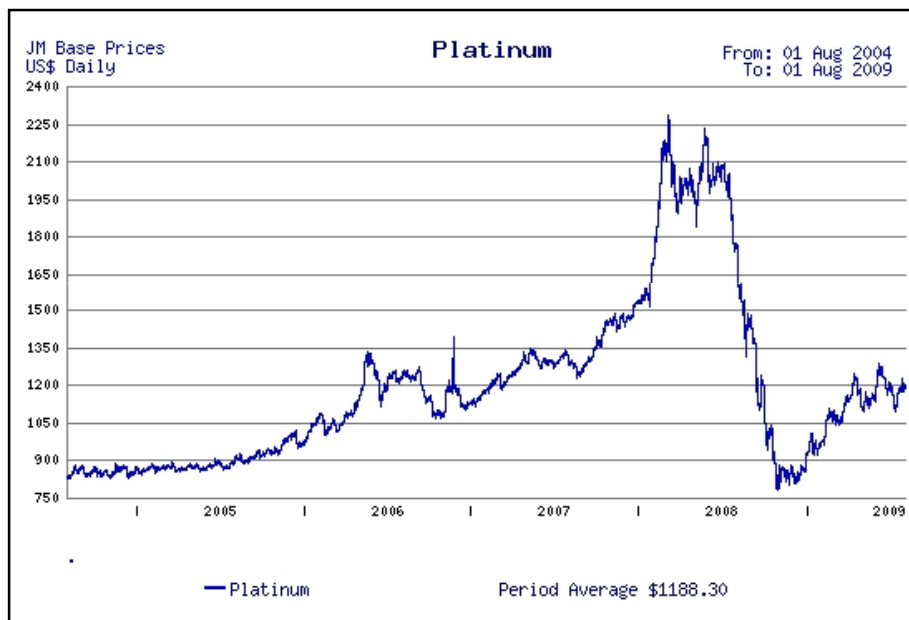
PFSA = Perfluorosulfonic acid

PR = Perylene Red

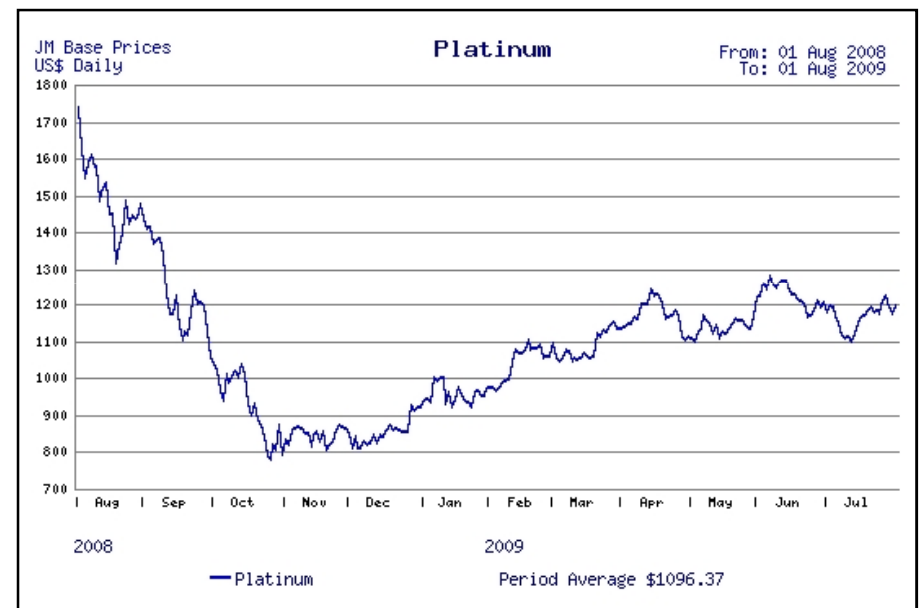
Progress Historic Pt Price

Platinum at \$1,100/tr.oz. is close to the average price (\$1,096/tr.oz.) over the 12 month period from Aug. 2008 to Aug. 2009.

Last Five Years' Platinum Price



Last Twelve Months' Platinum Price



The Pt price averaged over the last five years is ~\$1,188/tr.oz.



Raw materials for stack and BOP components are assumed to be purchased, and therefore implicitly include supplier markup.

PEMFC Sub-system	Raw Materials / Purchased Components
Stack	
Membrane	PFSA ionomer, isopropanol, silicone-treated PET film, polypropylene film, water
Electrodes	Pt, Co, Mn, perylene red (PR-149) dye, aluminum-coated film substrate, Teflon sheet
GDL	Woven carbon fiber, PTFE, carbon powder, water
Seal	Viton®
Bipolar Plates	Expanded graphite flake, vinyl ester, carbon fiber, poly dimethylsiloxane (SAG), methyl ethyl ketone peroxide, cobalt naphthenate
Balance of Stack	Stack manifold, tie bolts, end plates, current collectors, electrical insulators
Balance of Plant	
Water Management	Nickel foam, Nafion®, nitrile rubber, aluminum, HDPE, woven carbon fiber
Thermal Management	Aluminum coil, aluminum tubing, radiator fan, coolant pumps, air precooler, temperature sensors
Air Management	NdFeB magnet, steel bar stock, Teflon® insulation, copper coils, steel laminations, bearings, seals, motor controller, wire harness, air demister, air/H ₂ mixer, flow orifice, air filter
Fuel Management	SS316 bar, SS316 sheet, seals, H ₂ blower motor, H ₂ ejectors, H ₂ demister, solenoid valves, purge valve, check valve

Progress 2009 PEMFC Stack Cost Breakdown

Detailed results of 2009 PEM fuel cell stack cost breakdown.

2009 PEMFC Stack Costs ²		Active Area Basis ¹				Stack Module Weight (kg)	Stack Module Material Cost ² (\$)	Stack Module Process Cost ² (\$)	Stack Module Cost ² (\$)	Stack Module Cost ² (\$/kW)
		Material Cost ¹ (\$/m ²)	Process Cost ¹ (\$/m ²)	Total Cost ¹ (\$/m ²)	Unit Cell Weight/Area (g/cm ²)					
MEA	Anode GDL	\$4.12	\$0.72	\$4.84	0.02	2.37	\$54.21	\$9.50	\$63.71	\$0.80
	Anode Active Layer	\$19.28	\$3.15	\$22.43	0.00	0.01	\$253.95	\$41.52	\$295.47	\$3.69
	Electrolyte	\$9.77	\$1.67	\$11.44	0.00	0.40	\$128.74	\$21.96	\$150.70	\$1.88
	Cathode Active Layer	\$36.97	\$5.14	\$42.11	0.00	0.00	\$486.97	\$67.67	\$554.64	\$6.93
	Cathode GDL	\$4.12	\$0.72	\$4.84	0.02	2.37	\$54.21	\$9.50	\$63.71	\$0.80
MEA Total		\$74.26	\$11.40	\$85.66	0.04	5.16	\$978.08	\$150.15	\$1,128.23	\$14.10
Bipolar Coolant Plate		\$10.25	\$7.35	\$17.60	0.10	26.17	\$135.00	\$96.83	\$231.83	\$2.90
Seals						1.81	\$79.09	\$114.55	\$193.64	\$2.42
End Plates						1.97	\$3.91	\$6.33	\$10.24	\$0.13
Current Collectors						1.23	\$1.40	\$2.26	\$3.67	\$0.05
Insulators						0.80	\$8.62	\$9.56	\$18.18	\$0.23
Stack Manifold/Outer Wrap						5.40	\$8.13	\$13.09	\$21.22	\$0.27
Tie Bolts						2.49	\$19.68	\$1.72	\$21.40	\$0.27
Stack Assembly								\$158.87	\$158.87	\$1.99
Total Unit Cell		\$84.51	\$18.75	\$103.26	0.21	45.02	\$1,233.93	\$553.35	\$1,787.27	\$22.34

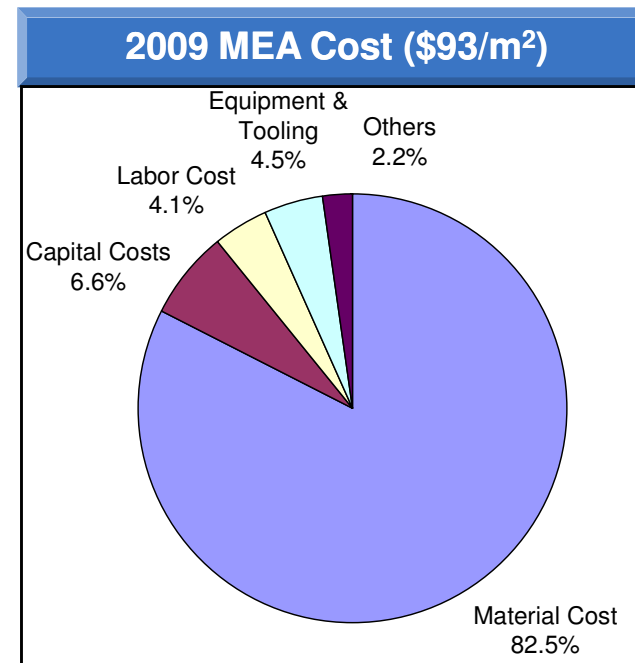
¹ Manufactured cost on an active area basis

² High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

Progress 2009 Stack - Material Costs

Material costs dominate the manufactured cost of the stack components. For example, materials make up ~83% of the MEA cost in 2009.

Manufactured Cost	2008 MEA ¹ (\$/m ²)	2009 MEA ¹ (\$/m ²)
<i>Material</i>	117.71	76.70
- Membrane	- 13.83	- 9.77
- Electrode	- 91.90	- 58.69
- GDL	- 11.98	- 8.23
<i>Capital Cost</i>	6.57	6.18
<i>Labor</i>	1.02	3.85
<i>Tooling & Equipment</i>	3.73	4.21
<i>Other²</i>	1.71	2.03
Total	131	93



In 2009, the MEA cost was lower due to lower material costs for the membrane (20 μm), electrodes (Pt loading = 0.15 mg/cm²) and GDL (180 μm).

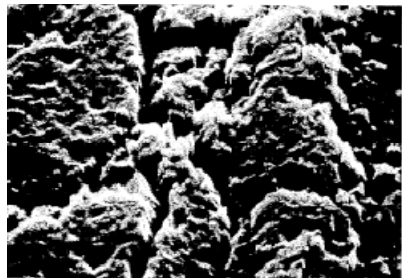
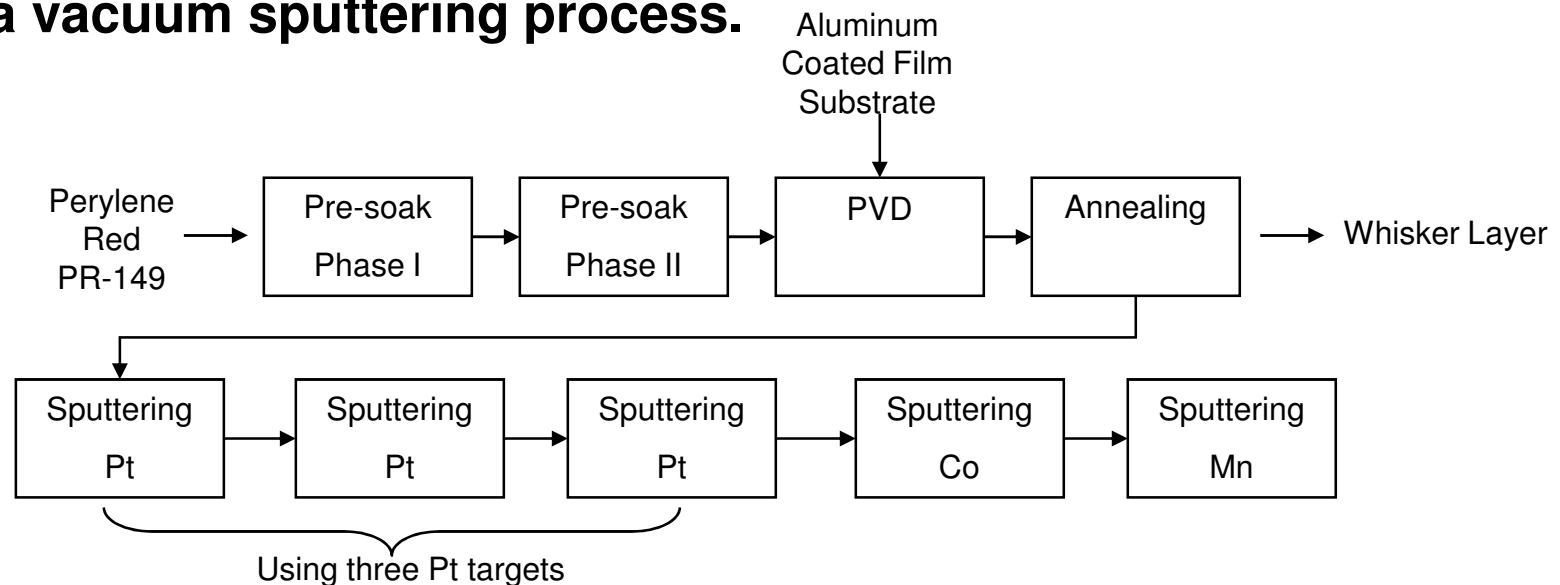


¹ m² of active area and kW of net power

² Other costs include utilities, maintenance, and building

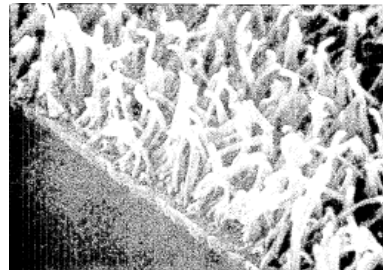
Progress Electrode Manufacturing Processes

Organic whisker support was fabricated by physical vapor deposition (PVD) with vacuum annealing process. Catalysts were coated to this layer via vacuum sputtering process.



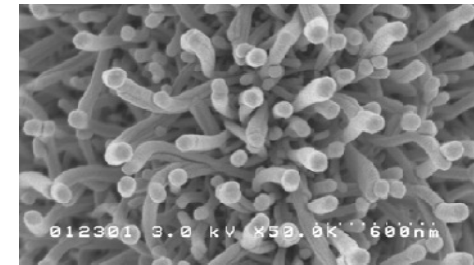
US Patent 4,812,352

PVD coated thin film before annealing



US Patent 4,812,352

PVD coated thin film after annealing

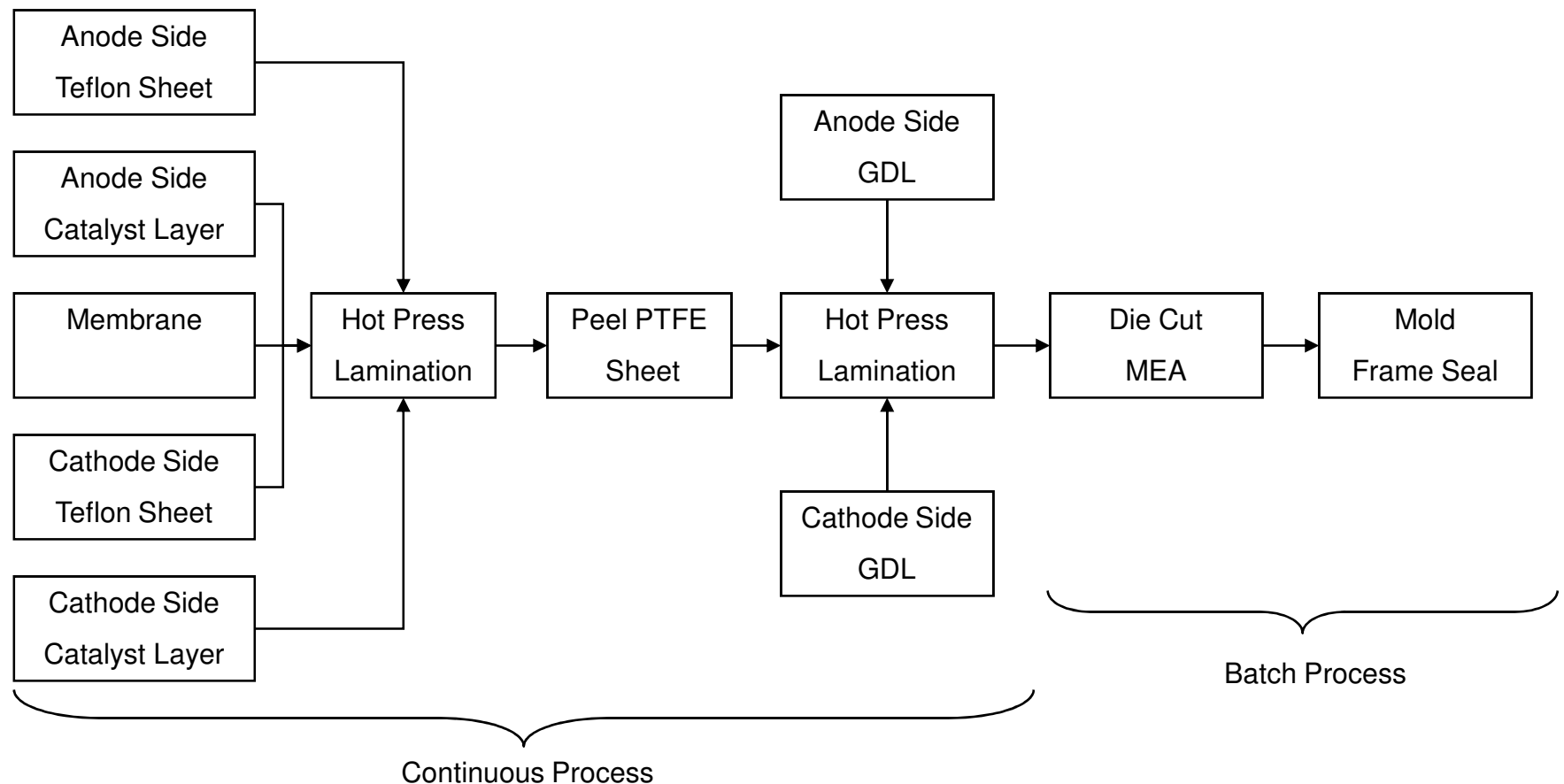


Nanostructured Thin Film Catalyst
before transfer to a PEM¹

¹M. K. Debe, Durability Aspects of Nanostructured Thin Film Catalysts for PEM Fuel Cells, ECS Transactions, 1(8) 51-66 (2006)

Progress MEA Assembly

The anode and cathode organic whisker layers were hot pressed to the membrane with Teflon® backing sheets.



The catalyst coated membrane and GDL layers were laminated to form an MEA in roll good form; the MEA was cut into sheets and molded with a frame seal.



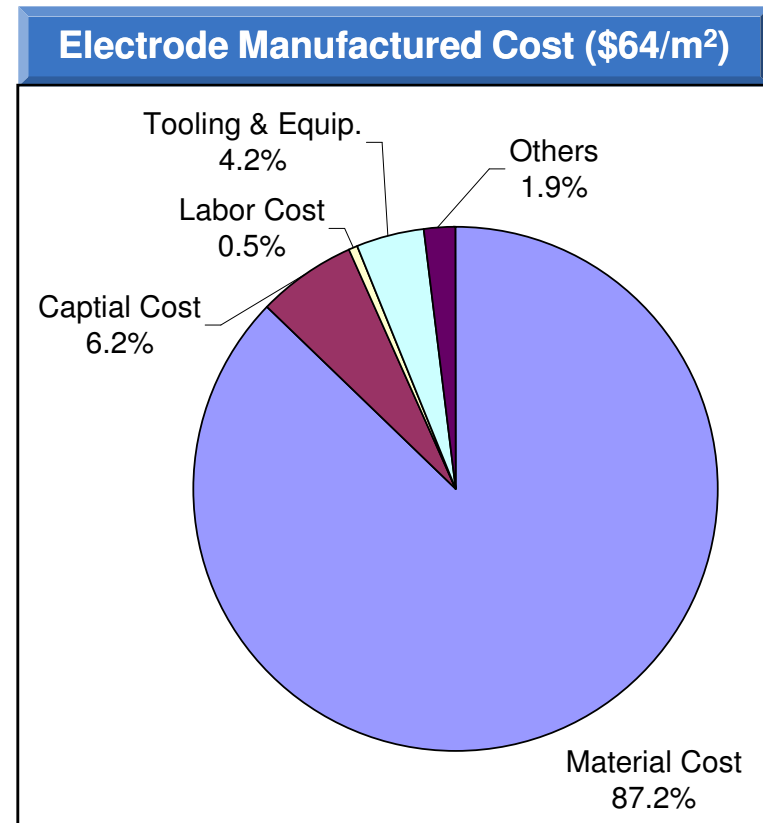
Progress 2009 Electrode Cost

Platinum price dominates the electrode cost of \$64/m². We have assumed Pt price to be \$1,100/tr.oz. or \$35.4/g.

Manufactured Cost	Anode ¹ (\$/m ²)	Cathode ¹ (\$/m ²)	Total ¹ (\$/m ²)
<i>Material</i>	19.28	36.97	56.25
<i>Capital Cost</i>	1.49	2.54	4.02
<i>Labor</i>	0.16	0.19	0.35
<i>Tooling</i>	1.04	1.68	2.72
<i>Other²</i>	0.47	0.73	1.20
Total	22	42	64

¹ m² of active area

² Other costs include utilities, maintenance, and building



Platinum at \$1,100/tr.oz. is close to the average price (\$1,096/tr.oz.) over the last year.

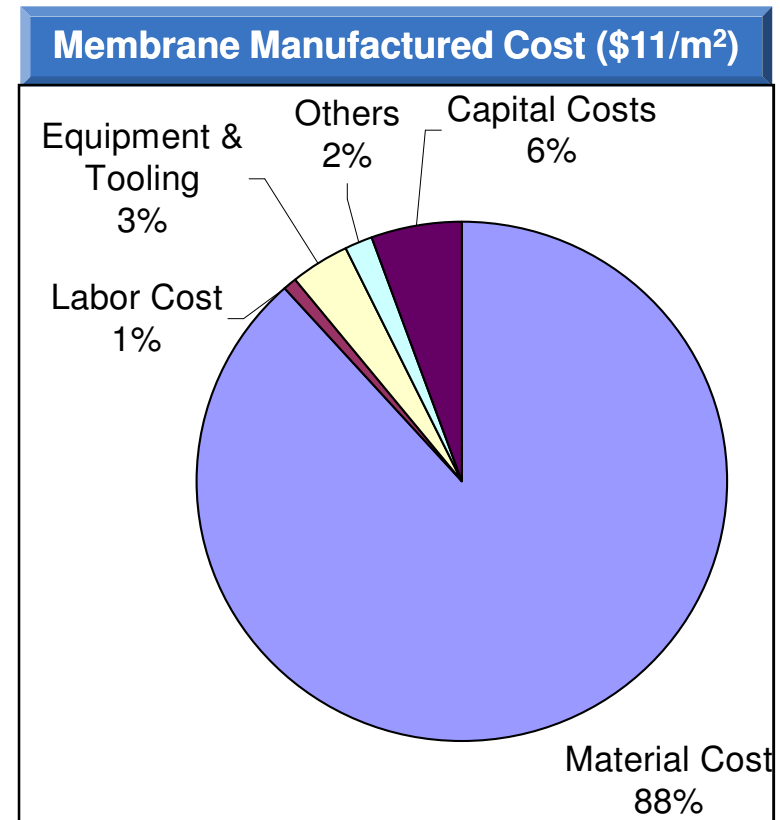


Progress 2009 Membrane Cost

The estimated membrane cost on an active area basis is \$11/m², with material cost representing about 88% of the total cost.

Membrane Manufactured Cost ¹				
Component	Material		Process	
	(\$/m ²)	(\$/kg)	(\$/m ²)	(\$/kg)
Film Handling	0.31	5.25	0.22	3.71
Coating	7.80	132.62	0.29	4.90
Drying & Cooling	0.00	0.00	1.00	17.02
Quality Control	0.00	0.00	0.04	0.60
Laminating	0.00	0.00	0.06	0.94
Packaging	1.66	28.29	0.07	1.16
Subtotal	9.77	166.16	1.67	28.34
Total	11.44 (\$/m²)			
	194.50 (\$/kg)			

¹ Manufactured cost on an active area basis or per kg of finished membrane basis (accounts for scrap and yield)



In 2008, the membrane cost was \$16/m² due to higher material costs associated with a thicker 30 μ m membrane.



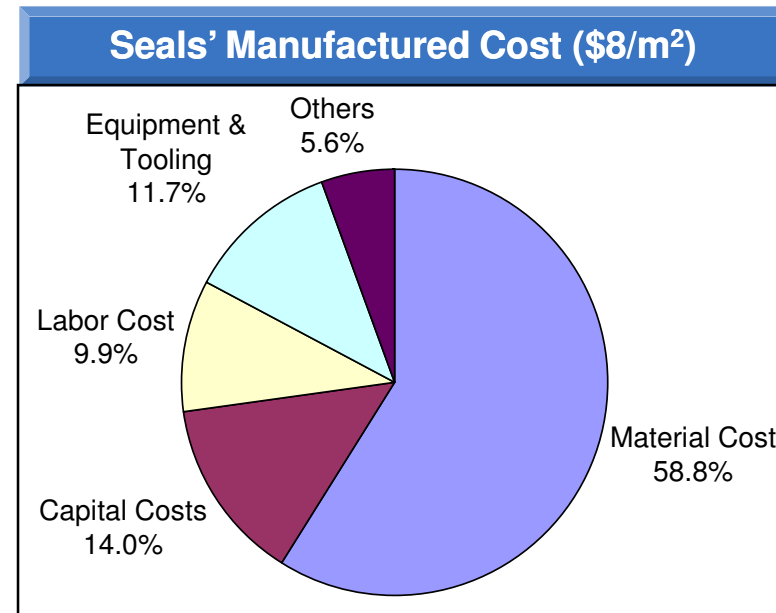
Progress 2009 Seal Cost

Transfer molding is used to fabricate the seals between the MEA and bipolar/cooling plate. The seal cost is ~\$8/m².

Manufactured Cost ¹	Seals (\$/m ²)
<i>Material</i>	4.78
<i>Capital Cost</i>	1.14
<i>Labor</i>	0.81
<i>Tooling</i>	0.95
<i>Other²</i>	0.45
Total	8.13

¹ Manufactured cost on an active area basis

² Other costs include utilities, maintenance, and building



The seal material is Viton[®] which costs ~\$20/lb.

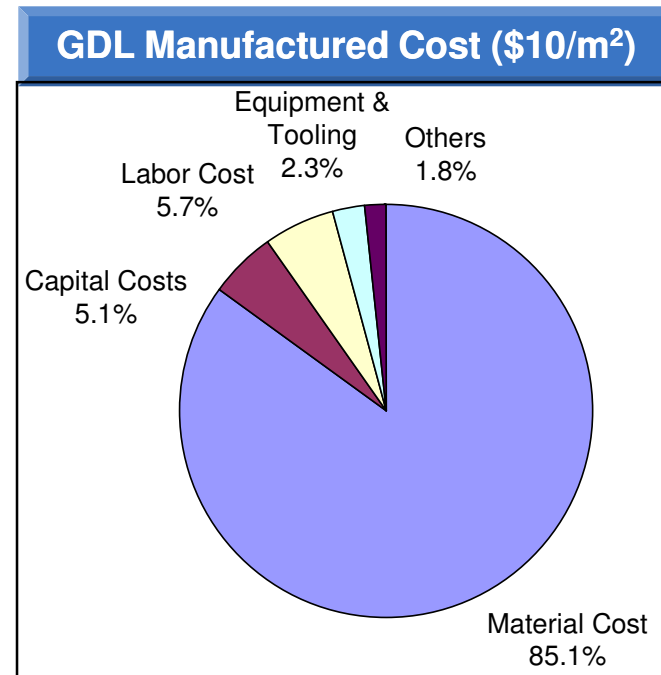


The estimated high-volume cost of the woven carbon fiber GDL (for *both* anode and cathode), is ~\$10/m², on an active area basis.

Manufactured Cost ¹	GDL (\$/m ²)
Material	8.23
Capital Cost	0.50
Labor	0.55
Tooling	0.22
Other ²	0.17
Total	9.67

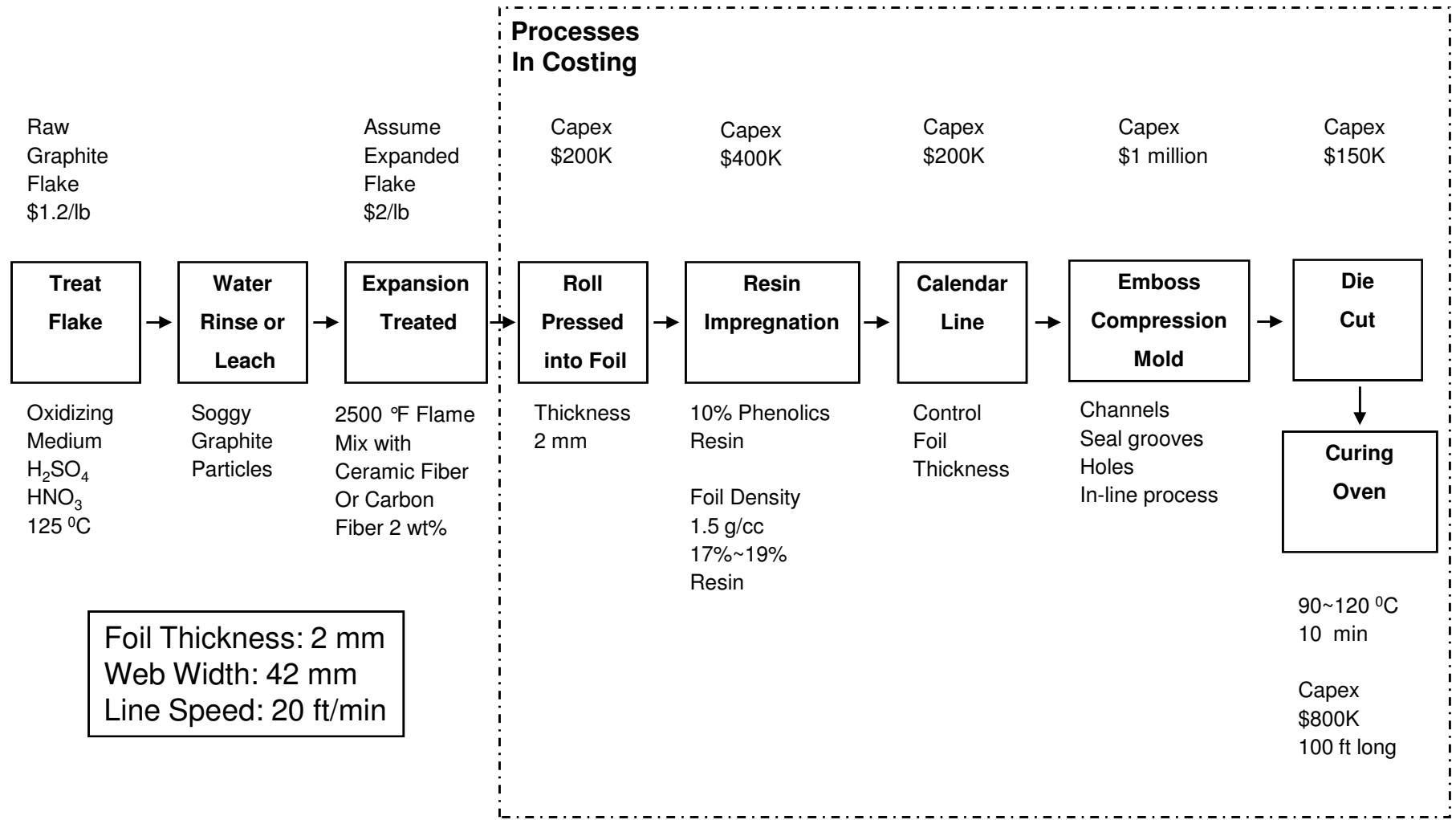
¹ Manufactured cost on an active area basis

² Other costs include utilities, maintenance, and building



Progress 2009 Bipolar Plate Manufacturing Process

Our process flow for the expanded graphite bipolar plate is based on a GrafTech® process chart and related patents.

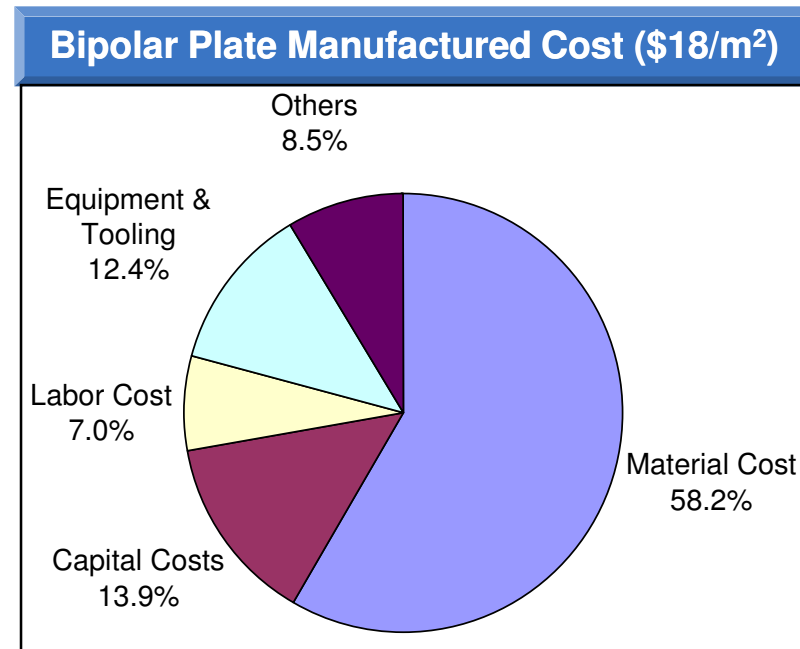


Progress 2009 Bipolar Plate Cost

We estimate the expanded graphite foil bipolar plate cost is \$18/m² at high volume.

Bipolar Plate Manufactured Cost ¹ (\$/m ²)		
Component	Material	Process
<i>Roll Form</i>	10.25	0.92
<i>Impregnation</i>		1.03
<i>Calendar</i>		0.66
<i>Compression Molding</i>		2.15
<i>Die Cut</i>		0.57
<i>Curing</i>		2.01
Subtotal	10.25	7.35
Total	17.60	

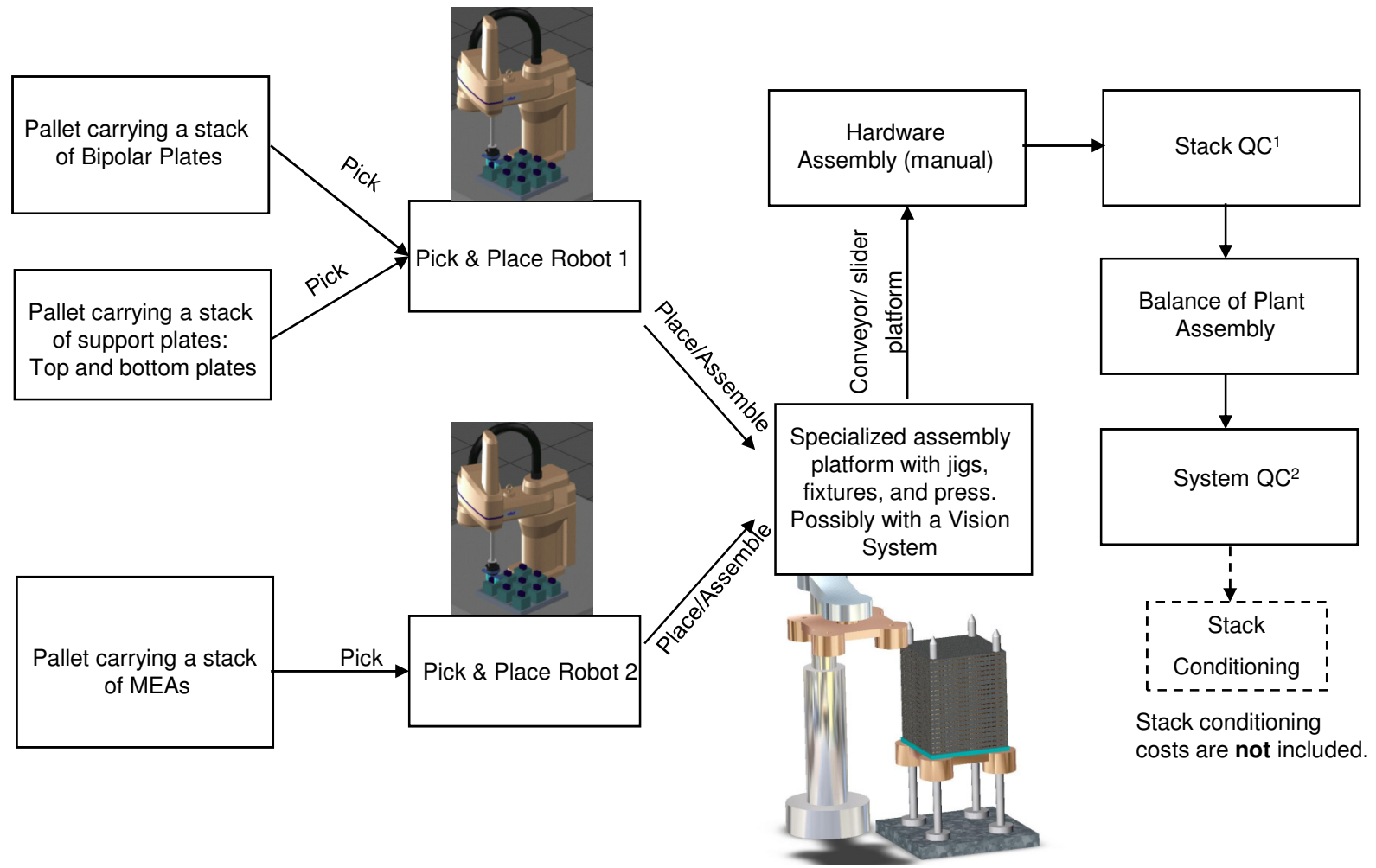
¹ Manufactured cost on an active area basis



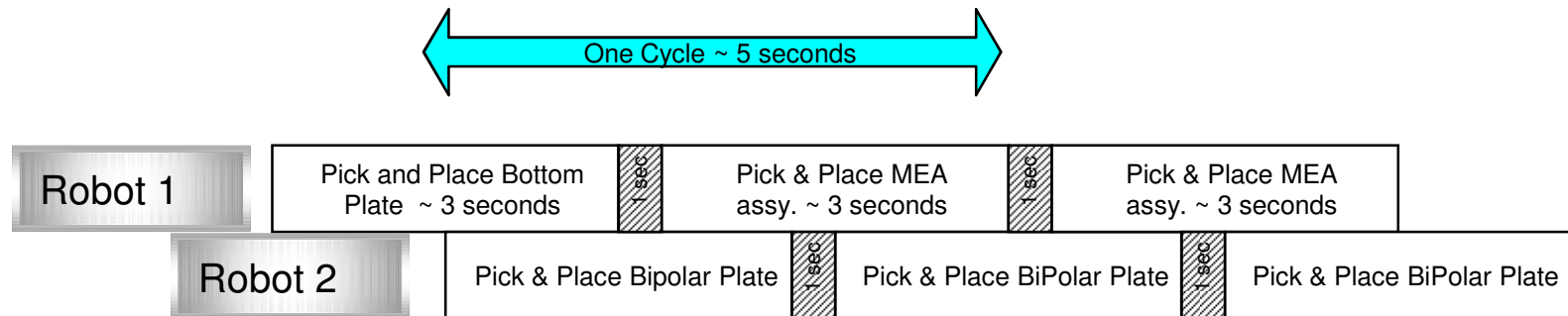
We assumed a raw graphite flake cost of \$1.2/lb and expanded graphite flake cost of \$2/lb.



A pair of robots in a specialized assembly station with a vision system is assumed to assemble the stack.



Assuming a two-robot assembly station, we estimate that two stacks¹ and the Balance of Stack are assembled in ~ 1 hour.



Stack assembly step	Time	Comments
Pick & place a single repeat unit	~ 5 seconds	Based on two-robot setup
Assemble a single stack ¹	~ 19 minutes	For 217 MEAs and bipolar plates
Assemble balance of stack (BOS)	~ 10 minutes	BOS includes endplates, electrical insulators, outer wrap/stack manifold, current collectors, tie bolts
Stack Quality Control ²	~ 15 minutes	Stack burn-in / conditioning time is not included

¹ We assume two stacks per 80 kW_{net} PEMFC system

² Stack QC includes visual inspection, and leak tests for fuel loop, air loop and coolant loop

Progress H₂ Blower Manufacturing Processes

The rotor and single vane structure in the Parker Hannifin Model 55 Univane H₂ blower are referenced from U.S. Patent 5,374,172.

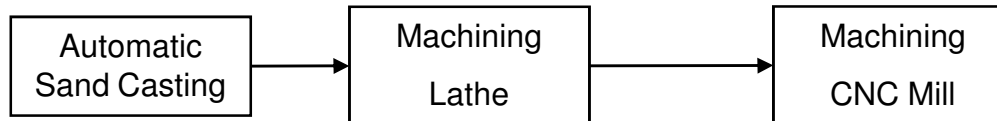
#	Selected Components	Material	Major Manufacturing Processes
1	Motor Side End Plate	SS316	Automatic sand casting; Turning; Drilling
2	Blower Housing	SS316	Automatic sand casting; Turning; Drilling
3	Inlet Manifold	SS316	Powder metallurgy
4	Outlet Manifold	SS316	Powder metallurgy
5	End Plate	SS316	Automatic sand casting; Turning; Drilling
6	Blower Shaft	SS316	Turning; Milling; Heat treatment; Grinding
7	Rotor	Al	Casting; Turning; Milling; Broaching
8	Vane	SS316	Hot forging; Drilling; Reaming

The major manufacturing processes for selected components of the H₂ blower are tabulated above.



Progress H₂ Blower Process Flow

The blower housing manufacturing process represents the level of detail we captured in the costing¹ of the H₂ blower.



- Load part to 3 jaw chuck
- Face rough
- Face finish
- chamber
- Central hole boring rough
- Central hole boring finish
- Chamber
- Reverse the part
- Face rough
- Face finish
- Chamber (inner & outer)

- Load part to fixture
- Milling the manifold connect surface rough
- Milling the manifold connect surface finish
- Drilling & tapping
- Rotate the fixture
- Milling the manifold connect surface rough
- Milling the manifold connect surface finish
- Drilling & tapping
- Load the part to vise
- Drilling & tapping
- Reverse the part (vise)
- Drilling & tapping

H₂ Blower Housing Manufacturing Process

Progress 2009 PEMFC System H_2 Blower BOM

The projected H_2 blower manufactured cost is \$219 per unit.

#	Part Name	Quantity	Material	OD (cm)	L (cm)	W (cm)	Wall Thickness (cm)	Total Vol. (Cm ³)	Total Wt. (kg)	TIAX Model Total (unit Cost)
1	100We DC Motor	1	Misc	16.51	8.89			1902.24	1.00	40.00
2	End Plate (motor side)	1	SS316	16.51	2.54		0.32	96.48	0.75	\$13.75
3	Screw	4	Misc	0.64	2.54			0.80	0.02	0.20
4	O-Ring	1	Misc	13.97					0.01	0.50
5	Labyrinth Seal (main)	1	Misc	5.08	1.27				0.02	2.00
6	O-Ring	1	Misc	5.08					0.01	0.20
7	C-Clip	1	SS316	5.08					0.01	0.10
8	Labyrinth Seal	1	Misc	4.45					0.02	2.00
9	Blower Housing	1	SS316	15.24	8.89		0.32	106.65	0.83	\$19.66
10	Screw	8	Misc	0.64					0.04	0.40
11	O-Ring	1	Misc	13.97					0.01	0.50
12	Compressor Shaft	1	SS316	1.59	12.70			25.12	0.20	\$9.17
13	Bearing	2	SS316	3.81	2.54			28.94	0.23	18.70
14	Seal	2	Misc	3.81					0.01	0.40
15	Rotor	1	Al	10.16	7.62			308.73	0.83	\$9.40
16	Vane Guide	2	SS316	7.62	1.27		1.27	32.06	0.50	\$15.60
17	Vane Guide Bearing	2	Misc	7.62	1.60			61.62	0.48	30.00
18	Vane	1	SS316		7.62	2.54	1.27	24.58	0.19	\$3.82
19	Vane Pin	1	SS316	0.95	9.62			6.85	0.05	4.00
20	C-Clip	2	SS316	1.35					0.01	0.10
21	Inlet Manifold	1	SS316	4.45	8.89		0.64	35.17	0.27	\$7.33
22	Seal	1	Misc		5.08	3.81			0.01	0.50
23	Screw	4	Misc	0.32					0.02	0.20
24	Fitting	1	SS316	4.45	5.08				0.10	1.00
25	O-Ring	1	Misc	2.54					0.01	0.20
26	Outlet Manifold	1	SS316	4.45	8.89		0.64	35.17	0.27	\$7.33
27	Seal	1	Misc		5.08	3.81			0.01	0.50
28	Screw	4	Misc						0.02	0.20
29	Fitting	1	SS316	4.45	5.08				0.10	1.00
30	O-Ring	1	Misc	2.54					0.01	0.20
31	End Plate	1	SS316	15.24	3.81		0.64	72.36	0.56	\$11.97
32	Screw	8	Misc						0.04	0.40
33	O-Ring	1	Misc	8.89					0.01	0.50
34	End Cover	1	SS316	7.62	0.64			28.94	0.23	\$5.21
35	Screw	4	Misc						0.02	0.20
36	O-Ring	1	Misc	6.35					0.01	0.20
37	Support	1	Steel		15.24	15.24	0.25	58.99	0.46	0.00

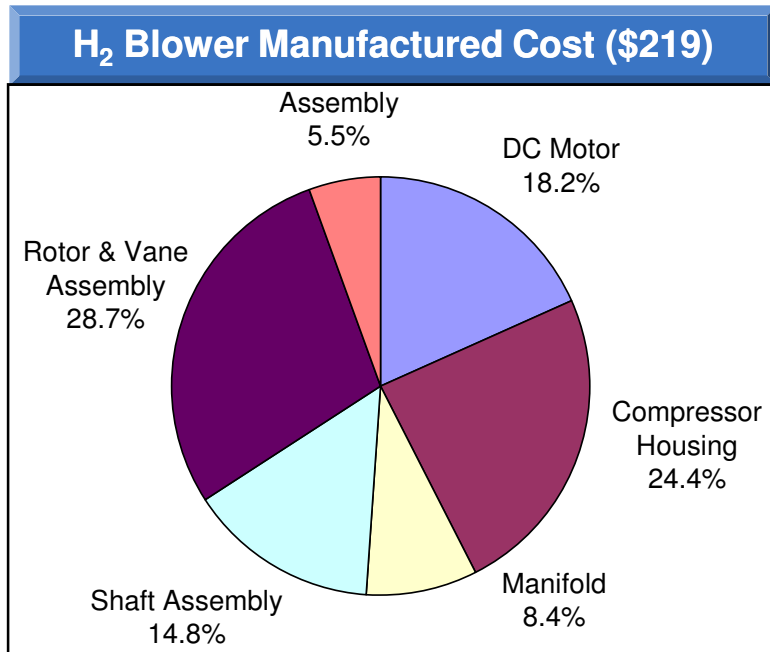
SubTotal: **\$207.44**

Assembly: **\$12.00**

Total: **\$219.44**



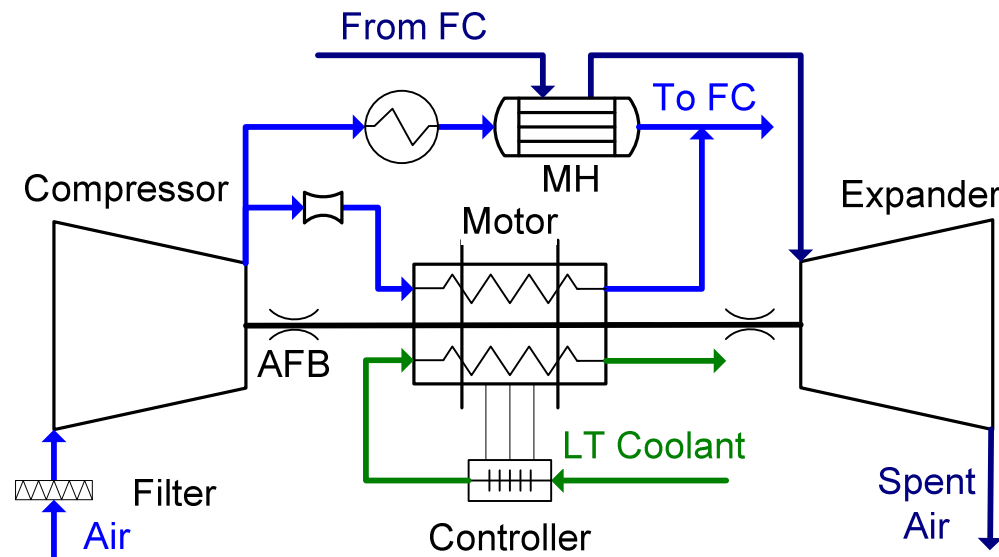
The rotor & vane assembly, blower housing, and DC motor are the top three cost drivers for the H_2 blower.



H_2 Blower Cost (\$)		
Component	Factory Cost ¹	OEM Cost ^{1,2}
DC Motor	40	
Blower Housing	53	
Manifold	18	
Shaft Assembly	33	
Rotor & Vane Assembly	63	
Assembly	12	
Total:	219	252

¹ High-volume manufactured cost based on a 80 kW net power PEMFC system. Does not represent how costs would scale with power (kW).

² Assumes 15% markup to the automotive OEM for BOP components



- Mixed axial flow compressor
- Variable nozzle turbine
- 3-phase brushless DC motor, liquid *and* air cooled
- Motor controller, liquid cooled
- Air foil bearing (AFB)
- Efficiencies at rated power: 70% compressor, 73% expander, 86% motor, 87% controller

R. K. Ahluwalia and X. Wang, Automotive Fuel Cell System with NSTFC Membrane Electrode Assemblies and Low Pt Loading, July 21, 2009

Progress CEM References and Manufacturing Processes

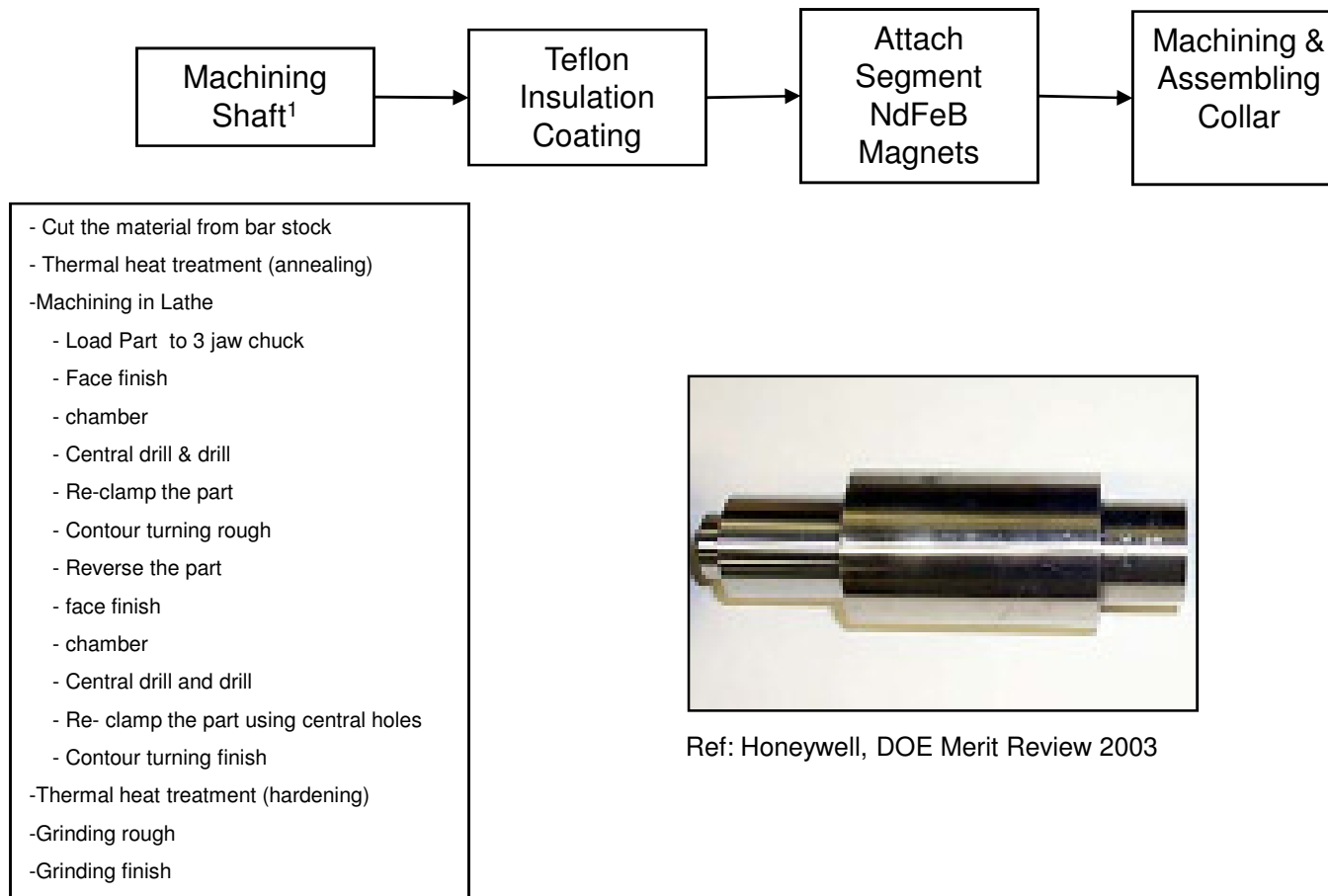
The references used to determine the overall design and major manufacturing processes for the CEM are tabulated below.

Component	References
Overall System	Honeywell, DOE program review, progress report & annual report, 2005, 2004, 2003, 2000; U.S. Patent 5,605,045
Electrical Motor	Honeywell, DOE program review, progress report & annual report 2004; U.S. Patent 5,605,045
Motor Power Electronics	Honeywell, DOE program review, progress report & annual report, 2005; Caterpillar, DOE Contract DE-SC05-00OR-99OR22734
Turbine Variable Nozzle Vanes, Unison Ring	U.S. Patent 6,269,642; Garrett/Honeywell, DE-FC05-00OR22809
Journal Bearings	U.S. Patent 2006/0153704; Honeywell 2005 Fuel Cell Seminar

#	Selected Components	Material	Major Manufacturing Processes
1	Turbine Housing	Al	Cold chamber die casting; Turning; Drilling
2	Motor Housing	Al	Cold chamber die casting; Turning; Drilling
3	Compressor Housing	Al	Cold chamber die casting; Turning; Drilling
4	Motor connecting shaft	Steel	Turning; Heat treatment; Grinding
5	NdFeB Magnet	NdFeB	Mixing; Molding; Sintering (purchased)
6	Turbine Wheel	Al	Investment casting; HIP
7	Compressor Impeller	Al	Investment casting; HIP
8	Thrust Bearing Runner	Steel	Turning; Heat treatment; Grinding

Progress CEM Process Flow

The motor rotor manufacturing process represents the level of detail we captured in the costing of the CEM.



CEM Motor Rotor Manufacturing Process

Progress 2009 PEMFC System CEM Bill of Materials

The estimated CEM (including motor and motor controller) cost is \$687 per unit.

#	Part Name	Quantity	Reference	Ref. Part #	Material	OD (cm)	L (cm)	W (cm)	H (cm)	Wall Thickness (cm)	Total Vol. (Cm³)	Total Wt. (kg)	TIAX Model Total (unit Cost)
1	Turbine Housing	1	US6269642	24	Al	20.32			7.62	0.16	127.19	0.34	\$5.39
2	Bolt	6			Misc	0.60	1.20				2.03	0.02	\$0.30
3	Washer	6			Misc	1.00	0.10					0.01	\$0.30
4	Tie Rod	1	US6269642	30	Steel	1.00	4.00				3.14	0.02	\$3.72
5	Turbine Wheel	1			Al	5.00	5.00				0.07	0.20	\$20.00
6	Variable Vane Assembly												\$0.00
7	Nozzle Wall	1	US6269642	38	Steel	17.78				0.30	36.46	0.28	\$2.54
8	Vane	9	US6269642	36	Steel	3.00	0.50	0.50			6.75	0.47	\$15.39
9	Vane Post	9	US6269642	40	Steel	0.20	1.00				0.28	0.02	\$0.00
10	Actuator Tab	9	US6269642	44	Steel		1.00	0.30	0.30		0.81	0.06	\$0.00
11	Unison Ring	1	US6269642	48	Steel	15.24	0.50				84.88	0.66	\$16.88
12	Actuator Crank	1	US6269642	50	Steel		2.00	1.00	1.00		2.00	0.02	\$1.11
13	Crank Bushing	1	US6269642	60	Steel	1.20	1.00			0.10	0.35	0.00	\$0.05
14	Crank Gear	1	US6269642	62	Steel	2.00	1.00			0.50	2.36	0.02	\$4.21
15	Crank Gear Pin	1	US6269642	64	Steel	0.20	2.00				0.06	0.00	\$0.10
16	Crank End Bearing	1	US6269642	66	Misc						3.00	0.02	\$2.15
17	Actuator Housing	1			Al	20.32	1.50			2.54	212.71	0.57	\$6.03
18	Solenoid Valve	1	US6269642	85	Misc							0.20	\$5.00
19	Solenoid Valve Bracket	1	US6269642	108	Steel		3.00	1.20		0.20	0.72	0.01	\$0.01
20	Solenoid Valve Bracket Bolt	1	US6269642	110		0.40	1.00				0.13	0.00	\$0.05
21	Washer	1	US6269642			0.60				0.10		0.00	\$0.05
22	Rack Gear Rod	1	US6269642	88	Steel	0.60	6.00				1.70	0.01	\$0.46
23	Motor Rotor Assembly												\$0.00
24	Motor Shaft	1	US6605045	16	Steel	3.31	20.32			0.00	115.21	0.90	\$10.64
25	Thermal Insulation	1	US6605045	60	Teflon	3.81	12.70			0.25	35.49	0.07	\$1.47
26	NdFeB Magnet	4	US6605045	62	NdFeB	4.68	12.70			0.44	73.64	0.55	\$48.60
27	Collar	1	US6605045	70	Steel	5.08	12.70			0.20	38.92	0.30	\$7.58
28	Labyrinth Seal	1	US2006/0153704	130	Misc	5.31				1.00		0.02	\$2.00
29	Journal Foil Bearing	1	US2006/0153705		Steel	3.31	5.08					0.10	\$10.00
30	Motor Housing	1	DE-FC36-02AL67624		Al	20.32	20.32			0.20	432.55	1.17	\$12.26
31	Bolt	8			Misc	0.60	1.20				2.03	0.16	\$0.40
32	Washer	8			Misc	1.00	0.10				0.00	0.04	\$0.40
33	Motor Stator Assembly	1	FY2000 Progress Report		Misc	9.20	12.70			1.50	460.59	2.95	\$17.91
34	Motor Sator Position Ring	1	FY2000 Progress Report										\$0.50
35	Bolt	8	FY2000 Progress Report		Misc	0.60	1.20	0.00	0.00	0.00	2.03	0.16	\$0.40
36	Washer	8	FY2000 Progress Report		Misc	1.00	0.10	0.00	0.00	0.00	0.00	0.04	\$0.40
37	Motor Connector	1			Misc								\$0.50
38	Labyrinth Seal	1	FY2000 Progress Report		Misc	5.31						0.02	\$2.00
39	Thrust Bearing Runner	1	FY2000 Progress Report		Steel	8.00	5.08			0.50	25.00	0.20	\$7.59
40	Thrust Bearing	2	FY2000 Progress Report		Misc	8.00						0.20	\$20.00
41	Thrust Bearing Holder	1	FY2000 Progress Report		Steel	10.00	1.00			0.50	50.00	0.39	\$8.59
42	Labyrinth Seal	1			Misc								\$0.00
43	Journal Foil Bearing	1	US2006/0153705		Misc	3.31	5.08					0.10	\$10.00
44	Compressor Housing	1	FY2000 Progress Report		Al	25.40			7.62	0.16	134.69	0.36	\$5.39
45	Bolt	8	FY2000 Progress Report		Misc	0.60	1.20	0.00	0.00	0.00	2.03	0.02	\$0.40
46	Washer	8	FY2000 Progress Report		Misc	1.00	0.10	0.00	0.00	0.00	0.00	0.01	\$0.40
47	Compressor Impeller	1	FY2000 Progress Report		Al	5.00	5.00					0.20	\$20.00
48	Compressor Impeller Tie Rod	1	FY2000 Progress Report		Misc	1.00	10.00				7.85	0.06	\$3.91
49	CEM Mounting Bracket Left	1			Steel	25.40	7.62			0.10	19.35		\$0.00
50	CEM Mounting Bracket Right	1			Steel	25.40	7.62	0.00		0.10	19.35		\$0.00
51	Control Box Assembly	1	DOE target \$40/kW / 5.5kW input									6.50	\$402.00
52	Box	1											\$0.00
53	Integrated Motor Cable	1											\$0.00
54	Inverter	1											\$0.00
55	EMI Section	1											\$0.00
56	Wire Harness & Cooling pipes	1											\$0.00
57	Final Assembly												\$9.65
													\$686.73