

Flint Hills Resources is a leading producer of fuels, petrochemicals and other petroleum products such as base oils for lubricants and asphalt. The company, based in Wichita, Kan., has more than 3,700 employees.

Flint Hills Resources' refineries in Alaska (North Pole), Minnesota (Rosemount) and Texas (Corpus Christi) produce a wide range of fuels that are transported through proprietary and common carrier pipeline systems, stored in a vast system of strategically located terminals, and marketed to wholesalers and retailers throughout the United States.

The company's growing chemicals business, with plants in Illinois (Joliet and Peru); Michigan (Marysville); and Texas (Longview, Odessa and Port Arthur); produce about 10 billion pounds of building block chemicals that are key ingredients in the manufacture of everyday items such as plastics and packaging.

The company also produces and markets asphalt in the Midwest and owns an interest in a base oil facility in Louisiana.

Commitment

Flint Hills Resources' MBM® Guiding Principles place integrity and operating in full compliance as the highest priorities. The company strives for 100 percent compliance while operating in a manner that protects the environment, and the health and safety of employees, contractors and the public.

The company nurtures a culture of safety that extends past personal safety to process systems by communicating a vision for excellence and encouraging open communication. Flint Hills Resources' facilities are among the best in their industries when it comes to safety.

Each Flint Hills Resources facility is unique and each develops and utilizes best practices to use resources efficiently and protect the environment. Overall, the company has ongoing efforts to reduce emissions at its plants. A key component is reducing flaring – especially during periods of startup, shutdown and malfunction. The company has been working with the U.S. Environmental Protection Agency since 2004 to develop and share best practices aimed at reducing emissions during these periods.

The company works to build good relationships within the communities where its operations are located. Local advisory councils provide an opportunity for dialog between the community and Flint Hills Resources and serve as a sounding board regarding refinery projects.

Achievements:

- In 2007, the company's overall refinery operations criteria air emissions per barrel were 68 percent lower than the average among peer refiners (based on latest comparison data available).
- Since 1997, the company has reduced its average per-barrel criteria air emissions by 71 percent.
- The company has had an 89.7 percent reduction in flaring since 1999.
- In Alaska, operations teams have developed and implemented more efficient processing methods that decrease production costs and save energy.
- At the Minnesota and Texas refineries, projects to increase efficiency have allowed the plants to produce more products while using less energy, and others save time or resources such as water.
- The Joliet, Ill., chemical intermediates plant has reduced emissions of volatile organic material by 25 percent since the company acquired the plant in 2004.
- A water recycling program at the Minnesota refinery allows it to recover and re-use wastewater discharged from the plant. In 2007, that meant 6 percent of the water discharged from the plant could be re-used. The refinery earned the Waste Water Operator Award from the Minnesota Pollution Control Agency for its water use program.
- All company sites have systems in place to recycle materials, wastewater, trash, paper and steel.

- Refineries in Alaska, Minnesota and Texas, and chemical plants in Illinois and Texas have received numerous awards from the National Petrochemical & Refiners Association for safety performance, including the Distinguished Safety Award.
- In 2007, refinery employees reached safety milestones for hours worked without an incident or injury resulting in time away from work: Alaska, 1 million hours; Minnesota, 2 million hours; and Texas, seven years. Employees at the Odessa chemical plant also reached the 1 million hours safety milestone in 2007.
- The company has nine Texas STAR sites in the U.S. Occupational Safety and Health Administration's Voluntary Protection Program, OSHA's highest safety honor. The company's four fuel terminals in Texas were the first in their industry to achieve this designation.
- The company's terminal operations in five states earned the Platinum Safety Award from the International Liquid Terminals Association. The terminals group completed 2007 with no OSHA recordable or lost-time incidents.
- The Minnesota refinery has achieved MNSTAR worksite designation from the Minnesota Department of Labor and Industry.
- Since 2001, the Minnesota refinery has earned several Minnesota Safety Council's Governor's Awards including the Award of Honor, which is the highest honor bestowed, and the Outstanding Achievement Award.
- Wildlife management programs at the Joliet, Ill., Rosemount, Minn., and Corpus Christi, Texas, sites have received Wildlife Habitat Council certification. Both the Joliet and Corpus Christi sites have also received Corporate Lands for Learning™ certification from WHC.

Leadership

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