



**We're proud of our accomplishments in safety, health and the environment**

A successful refiner today is described not only in terms of profitability, but also by its Environmental, Health and Safety (EH&S) performance. Our organization is very proud of our accomplishments during the last several years: Occupational, Health and Safety Association Voluntary Protection Program Star Recognition, National Petrochemical Refiners Association Distinguished Safety Award, and an industry leader in emission reductions for both our facilities and the fuels we produce. The key to our success is based on:

- 100% commitment from the entire organization toward an injury free workplace and being environmentally responsible.
- Total employee involvement in our EH&S process.
- Industry leadership in EH&S Excellence.
- Our belief that EH&S performance is the foundation for our business success.
- How we value community and stakeholder involvement in our EH&S process.
- How we value the quality of life in the community and our ability to positively influence it.

As a result, Flint Hills Resources-Corpus Christi is more efficient and productive, our community is safer and has cleaner air, and our business is successful. Today, we feel very good about what we have accomplished and confident about the future.

**Joe Coco**  
vice president refining and manufacturing manager, Flint Hills Resources Corpus Christi Complex

**Developing nature tourism a boon to the economy and environment**

Can economic development, environmental stewardship and conservation coexist in harmony? That has been a major focus of the Flint Hills Community Advisory Council during this year. This dedicated group of community advisors, working with Flint Hills Resources as the sponsor, has set out to prove that those two goals are not mutually exclusive.

Flint Hills Resources Community Advisory Council (FHR-CAC), made up of volunteers from throughout the Coastal Bend, is taking on the challenge of promoting and developing nature tourism through an alliance of nature tourism partners. Nature tourism, also known as ecotourism, capitalizes on the public's interest in wildlife and their desire to escape from the city.

The idea to develop nature tourism came out of regular FHR-CAC meetings, said Teresa Carrillo, a council member and executive director of the Coastal Bend Bays Foundation.

"We already have the components of a nature tourism economy," she said. "It's just that the fabric is not woven together, so our Council took it upon itself to push the nature tourism alliance idea forward."

That effort led to a workshop in



Ted Eubanks, president of Fermata Inc., responds to a question from Patti Young of B-Bar-B Ranch after his lunch presentation.

February, featuring speakers who discussed nature tourism benefits and methods. Ted Eubanks, president of Fermata Inc., a consulting firm specializing in nature tourism, said it is both a popular and a powerful conservation tool. He said some 65 million Americans last year traveled 50 miles or more to a nature destination, and that some of the money generated by tourism went toward conservation.

More than 80 people attended the workshop sponsored by FHR-CAC. Roger Knot was another council member who helped plan the workshop.

"Everybody involved was pleased to see the great interest in nature tourism and the interest in the alliance," Knot said.

**PROFILE:**

**Flint Hills Resources-  
Community Advisory Council**

Flint Hills Resources Community Advisory Council is made up of a diverse group of 50 people from Nueces and San Patricio counties, chosen from a cross-section of community stakeholders.

They all have at least one thing in common: a desire to make the Coastal Bend a better place to live and work. With that in mind, the council's four committees – education, economic development, environment and quality of life – generate and research ideas for improving the Coastal Bend.

The best ideas are then presented to the full council for possible action. Project task forces and the full council meet monthly with Flint Hills Resources representatives to work through an eight-step incubation project model for implementation.

Anyone interested in serving on the council should contact Rich Tuttle, FHR's director of regional public affairs at 242-8572.

**Nature Tourism,**

continued from page 1

This environmental partnership known as the Texas Coastal Bend Nature Tourism Alliance is in the active planning stages. The concept of the proposed alliance is to promote and increase nature tourism development in the Coastal Bend through coalitions and partnerships.

In March, a planning group of about 35 people, representing a number of area nature locations and organizations, attended an all-day retreat at Laura Berry's Lonesome Dove Ranch. Working with Miles Phillips, ecotourism extension program specialist for Texas Cooperative Extension, they helped identify areas of strength and opportunities for developing this industry. A smaller steering committee, created out of this group and chaired by Carrillo, will provide direction for organizing the

alliance – what it will look like, how it will function, how it will be funded and how it will make things happen. Phillips said the Coastal Bend hasn't capitalized on the nature tourism market as much as it could.

"It takes focusing in on a combination of resources and marketing, and I think there's a lot of room for doing

that," he said.

Wayne Bennett, president of the Corpus Christi Convention and Visitors Bureau, applauded the FHR-CAC for putting the

various interests together. "Since nature tourists tend to be older, better educated and have more disposable income, it's a good group to go after," Bennett said, "and the market is worldwide."



Robyn Cobb, Martha Ruiz, Maggie Moorhouse, Barbara Sheppard and others participated in a planning workshop for a proposed nature tourism alliance.

**Earth Day-Bay Day promotes environmental awareness and fun**

Once a year, people around the world celebrate nature, environmental conservation and learn how to be more responsible stewards of Mother Earth. Coastal Bend residents celebrated this year's annual Earth Day-Bay Day at Hazel Bazemore Park with a daylong outdoor festival. Thousands visited the park to kayak, climb a 24-foot-tall rock wall and learn how to protect our planet.

"We're trying to educate the public on how important it is for each individual to become involved in protecting the earth and our environment," said Teresa Carrillo, executive director of the Coastal Bend Bays Foundation.



Jim Needham, Texas A&M University-Corpus Christi, demonstrates kayaking to Salinda Vergara. Salinda is the daughter of FHR's Sarah Vergara.

**BAY DAY, continues on page 3**

## FOCUS ON THE ENVIRONMENT

### FHR's Learning Preserve is an outdoor classroom

Robstown High School students and Texas State Aquarium Sea Campers don't have far to go to see American avocets, roseate spoonbills, black-necked stilts and the tracks of coyotes, white-tailed deer, bobcats and other Coastal Bend wildlife.

The Flint Hills Resources Wildlife Learning Preserve is a 112-acre tract on Suntide Road in northwest Corpus Christi. The Preserve offers unique environmental education opportunities to groups interested in learning about wildlife and their native habitat.

The Preserve's landscape consists of coastal marshes, fresh-water ponds, upland grasses, mudflats and mesquite brush land. This relatively unspoiled habitat provides fresh water, forage and shelter for a variety of wildlife, including raccoons, opossums, rabbits and more than 50 species of waterfowl, wading birds and shore birds.

The Preserve has three transitional areas: upland mesquite grove, flats and two wetland

ponds. These areas exhibit a tremendous amount of diversity in soil, plants, insects, birds, wildlife and water.

The Preserve was created through a conservation easement granted by Flint Hills Resources to one of its educational partners, the Coastal Bend Land Trust. Property owners grant conservation easements to ensure land will be kept in its natural state.

Students use the site to learn wetland ecology and wildlife habitat management. They identify plant, marine and mammal life, birds and their nests. They also make plaster castings of animal tracks and Sea Camp classes learn how to subdivide an area, take mud samples and seine to identify marine life.

The Preserve hosts tours for the Texas State Aquarium's Sea Camp and teachers working on their master's degrees at Texas A&M University-Corpus Christi. The Preserve also has an official State of Texas Adopt-A-Wetland area monitored by a science class at Robstown High School.



Teachers learn to make plaster casts of animal tracks in Teaching Environmental Science II at the Learning Preserve.

In addition to the Preserve, FHR uses the bay to help students learn about the environment. Each year for the past five years, Flint Hills Resources has hosted a trip aboard the R.V. Katy, a research vessel owned by the University of Texas Marine Science Institute in Port Aransas.

The Katy pulls a trawl for 20 minutes and allows students to sift through the contents. Mud and water samples are also taken and viewed under a microscope, which transmits an image to an onboard television.

Students have been treated to kayaking to experience an environmentally friendly way to view wildlife. The trip shows students what is in the water, the cycle of the food chain and why it's important not to pollute the water.

#### BAY DAY, continued from page 2

Flint Hills Resources, a major sponsor of the event, donated funds and volunteer hours to the fifth annual Earth Day-Bay Day. In the Coastal Bend celebration, emphasis is placed on protecting its bays.

"We want people to understand that the things they do impact this bay right here," Carrillo said.

Daiquiri Richard, executive director of Beautify Corpus Christi Association, said "We participate to promote environmental awareness and to educate people of all ages about the importance of our natural



Jan Golden, Flint Hills Resources Environmental Engineer, helps out at the volunteer booth at Earth Day-Bay Day.

resources. Well-informed citizens are less likely to litter and tend to care for their environment. Drawing families to Earth Day-Bay Day helps ensure that generations to come will protect and enhance our waterways and native habitats."

Other Earth Day-Bay Day exhibits included the Texas Zoo, the Texas State Aquarium's mobile aquarium "Ocean in Motion," Smokey Bear, free trees given by the Texas Forest Service, live music and exhibits on composting, recycling and other environmental issues.

# FLARES

## Improved technology contributes to safety, the environment and the bottom line

Refinery flares are tall, thin stacks that occasionally emit flames at the top and are visible from outside a refinery’s fence line. Flint Hills Resources’ commitment to reducing flaring not only has important environmental benefits, but also is just good business.

Flares are a key component of refining safety systems that are designed to burn hydrocarbons in a controlled manner when over-

pressuring occurs and protect the integrity of refinery equipment. Hydrocarbons are vented from process equipment through pressure relief valves to the flare tip located at the top of the stacks where they are burned. Steam or air is combined with the material as it is burned in the flare to promote complete, smoke-free

burning. Flaring typically occurs when refinery units are started up, shut down or interrupted for any reason. However, refineries can reduce the environmental impact and economic loss from flaring by installing flare gas recovery systems (FGRS). A FGRS recovers gases that are being sent to the flare and recycles them back into the process system rather than burning them off through flaring. This recycling reduces emissions to the environment and turns waste gases into products.

With a FGRS, a refinery can track flare use. Flaring occurs in situations where the amount of gas produced is greater than the recycle capacity of the FGRS.

“We began tracking flaring time and frequently review the data with our workforce,” says Eric Kaysen, Flint Hills Resources environmental manager. “The results have been significant.” Comparisons between refineries regarding time “in the flare” is difficult to evaluate since some refiners do not track flaring or have flare gas recovery systems. In 2000, management at Flint Hills Resources’ Corpus Christi Complex made a commitment to reduce flaring.

Flint Hills Resources also accomplished the following:

- identified and implemented equipment changes to increase the reliability of the FGRS;



This photo shows a slight steam emission coming from one of Flint Hills Resources new flares that are designed to recover and

recycle gases – rather than burning them off, as in in the file photo at right.



Photo of flare courtesy of John Zink Company, Tulsa, OK.

**“Our goal is to be an industry leader in facility emissions performance. We believe flaring reduction is critical for us to achieve this goal,” says Joe Coco, vice president and manufacturing manager for the Corpus Christi complex. “Reductions in flaring are not only good for the environment, but a good economic decision as well.”**

Refinery Flaring Performance	
Year	% of Time in Flare
1999	10%
2000	14%
2001	5.4%
<b>2002</b>	<b>2.6%</b>

- implemented a flare policy and management system to reduce the load on the FGRS;
- optimized and standardized unit processes to reduce peak loads;
- required non-routine sources to cease flow to the flare system during certain operations; and
- specifically targeted turnaround and maintenance activities with the goal of eliminating flaring whenever possible. This led to both procedural changes and some equipment modifications.

## National award recognizes outstanding 2002 safety performance

Flint Hills Resources received the prestigious National Petrochemical Refiners Association's (NPRA) 2002 Distinguished Safety Award in April in recognition of the ongoing safety commitment of management and employees at the company. NPRA gives only two Distinguished Safety Awards each calendar year. One award goes to a company in the chemical industry, and the other recognizes the outstanding safety efforts of a refining company.

"NPRA has a long history of recognizing refiners that display a superior level of safety performance," said Bob Slaughter, NPRA president. "Flint Hills' Corpus Christi facility's commitment to safety is clear – the facility and its employees have earned safety recognition from the association for 10 consecutive years."

Recipients of the Distinguished Safety Award must pass a comprehensive review of individual safety performance programs. To be considered for the award, a

location must achieve both an employee and contractor total recordable incident rate of 1.0 or less and have had no employee cases involving days away from work for the applicable evaluation period.

At 0.28 Flint Hills Resources – Corpus Christi completed 2002 with its lowest-ever health and safety incident rate, and the complex had zero lost-time injuries. Its 2002 Occupational Safety and Health Administration recordable-incident rate was the lowest in plant history. This compares to an 8.1 rate for all U.S. manufacturing facilities and a 1.4 rate for the petroleum refining industry.

"We are very honored to have earned

this award," said Joe Coco, vice president and manufacturing manager for Flint Hills Resources – Corpus Christi. "Our employees continue to exhibit the dedication and vigilance needed to continue our safety performance, and to demonstrate

our commitment to maintaining the highest safety standards."

The Corpus Christi complex was also awarded the Meritorious Safety Performance Award, Gold Award, Award for Safety Achievement /

Hours, and the Award for Safety Achievement / Years.

Congratulations to all employees for this outstanding achievement.



Accepting the Distinguished Safety Award on behalf of Flint Hills Resources were employees: (L to R) Jerry Hoefling, Ryan Biggs, Willis Jernigan, safety manager, and Jeff Brock. William Kleese, executive VP and COO of Valero Energy presented the award.

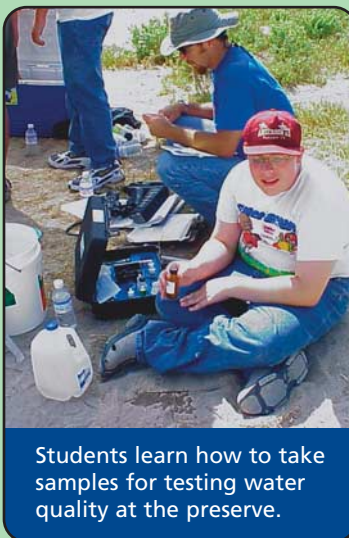
### Learning Preserve receives recognition

Earns Business and Industry Environmental Leadership Award from Coastal Bend Bays Foundation

Flint Hills Resources was honored with the Business and Industry Environmental Leadership Award at the Coastal Bend Bays Foundation's First Annual Conservation and Environmental Stewardship Awards Banquet. The focus of the banquet was to recognize outstanding Coastal Bend citizens, educators, businesses, governing bodies and other entities that made significant contributions to the protection of the natural resources, habitats and native species.

The company's designation of a 112-acre Wildlife Learning Preserve and service to more than 350 area students and over 350 adults with biological and environmental education for the past three years at the Preserve was the driving factor behind the Flint Hills Resources receipt of the award. "Our ongoing efforts in the Wildlife Learning Preserve provide a valuable

hands-on learning experience in addition to showing that industry and surrounding habitat can co-exist," said Eric Kaysen, environmental manager at the Corpus Christi complex.



Students learn how to take samples for testing water quality at the preserve.

Other award recipients recognized at the banquet were:

- Public Service – Art Morris
- Citizen Volunteer – Pat Suter
- Coastal Community – Aransas Pass
- Small Business – Gill Landscape Nursery
- Organization / NonProfit Group – The Coastal Bend Land Trust Wildlife Photo Contest
- Education / Public Awareness – Dr. Henry Hildebrand
- Individual Coastal Contribution – Dr. Donna Shaver
- CBBF Chairman's Award – The Nueces Delta Project

EMPLOYEE SPOTLIGHT

### History reenacted for education

With a combined total of 61 years of service at Flint Hills Resources and with responsibilities ranging from Operations, Maintenance, Rotating Equipment Mechanics to Process Control Systems, what could five employees have in common in relation to history? In addition to their duties at the Corpus Christi refinery, Sonny Smithwick of Orange Grove, Arnold Mendoza of San Diego, John Ramirez Jr. of Corpus Christi, Rick Cantu of Odem, and Luis Flores of Robstown have an unusual hobby. They are members of a historical reenactment team for 3 Ace's Entertainment Group, a local production company.

Established by Smithwick, the group has participated in numerous western films, including HBO's *Pancho Villa*; TNT's *Two for Texas*; *Dead Man's Walk* and *Atanasia*; and Walt Disney's remake of *The Alamo*. Working as historical reenactors, the employees study the historical background of the event and the scene to be shot. This includes understanding period



With this posse of (L-R) John Ramirez, Jr., Sonny Smithwick, Arnold Mendoza, Luis Flores, and Rick Cantu hot on the trail, the outlaw will be going to jail for sure.

wardrobe and military commands. They are responsible for their own equipment, including horses and period equipment. In addition to on-camera action, the group also volunteers to reenact western scenes at fundraisers for non-profits and other events.

When asked why they use their days off for historical reenactment, they agree that involvement in the

community, teaching others about Texas' rich tradition of western and Hispanic cultures of the 1800's, and the excitement of reenacting battle scenes (complete with explosions, blazing six-guns, and horse racing through water) are all aspects that make long days in the hot sun during movie "takes" so enjoyable.

### Easter arrives early

Easter arrived early as employees and their families celebrated Springtime, hunting eggs and visting with the Easter Bunny at the 3rd Annual Flint Hills Resources Easter Egg Hunt at the Corpus Christi Botanical Gardens.



The event is sponsored by the company and provides a fun outdoor activity for employees and their families, as well as an opportunity to get better acquainted with coworkers. An estimated 250 attendants enjoyed inflatable games, face painting and refreshments while taking advantage of the beautiful rose garden. The Easter Bunny greeted and posed for photos with the children.



## On Location:

### BUSINESS HALL OF FAME

Marian Luna Brem, (3rd from left), stands with this year's inductees to the Business Hall of Fame (L to R): Mel Klein, Sam Kane, and Bernard Paulson. Brem, inducted last year into the Business Hall of Fame, served as emcee and presenter at a ceremony and banquet on April 9 at the Omni Bayfront Hotel. Sponsored by Flint Hills Resources, the event benefitted Junior Achievement of the Coastal Bend. Students involved in the program helped spread the word and thanked sponsors during the banquet.



## Calendar of FHR Events

Operation Paintbrush	May 31
Rec Club Fishing Tourney	June 7
Junior Achievement Bowlathon	June 20-21
Rec Club Astros Trip	June 28
Texas State Aquarium Open House	July 19
Rec Club Bowling	Aug. 9
Women's Shelter Great Expectations	Sept. 5
United Way Golf Tournament	Sept. 8
Rec Club Iron Man Playday	Sept. 13
Service Awards	Oct. 23



## Employees lead the way to stop birth defects

Flint Hills Resources' employees participated in WalkAmerica 2003 benefiting the March of Dimes at Cole Park. Team members could choose to walk or jog a 2.5 or 5-mile course down Shoreline Boulevard. They were able to raise nearly \$5,000 through donations, raffle tickets, bake sales and corporate sponsorship for the March of Dimes. Funds raised will support programs of research, education, advocacy and community services. This lifesaving research provides hope for nearly half a million babies born prematurely each year, and for the 150,000 babies born each year with disabling or fatal birth defects.

## Welcome New Employees

Please join us in welcoming these new employees to Flint Hills Resources-Corpus Christi.



**Antonio Aguilar, Jr.**  
PSP Entry Level  
2/24/03



**Travis McCumber**  
PSP Entry Level  
2/24/03



**Benjamin Ball**  
PSP Entry Level  
2/24/03



**Ricardo Mirelez**  
PSP Entry Level  
2/24/03



**Ronald Beasley**  
PSP Entry Level  
2/24/03



**Javier Ramirez**  
PSP Entry Level  
2/24/03



**Dawn Bennett**  
Yield Accountant  
3/24/03



**Tiffany Ramon**  
ROE Accountant  
3/24/03



**Roberto Duenez**  
PSP Entry Level  
2/24/03



**Luis Reyna**  
PSP Entry Level  
2/24/03



**Albert Guerrero**  
PSP Entry Level  
2/24/03



**Harry Smithwick, Jr.**  
PSP Entry Level  
2/24/03



**Clint Kraatz**  
PSP Entry Level  
2/24/03



**John Sutton, Jr.**  
PSP Entry Level  
2/24/03

## Visionarios winners are recognized

The South Texas Institute for the Arts and Flint Hills Resources congratulated nearly 50 students in grades 1-12 for their outstanding achievements in painting, drawing and photography at the 2003 *Visionarios* Youth Art Contest awards banquet in April. The Corpus Christi area students, their art teachers and parents were recognized for making the contest *Discovering Tomorrow Today*, a success and for possessing the vision and creativity necessary for success in school and beyond.

“These students’ vision and creativity will help create a brighter tomorrow for the Coastal Bend,” said Bill Otton, executive director of the South Texas Institute for the Arts.

In keeping with the theme, Navy Captain Paula Hinger, pioneering aviator and Commanding Officer at Naval Air Station Corpus Christi, was guest speaker.

Here are the winning students:



### GRADES 1-2

#### **Dry Media**

First Place - Keera Seiger  
Second Place - Diego Vado  
Third Place - Abigail Perez  
Honorable Mention - Jared Hundley  
Honorable Mention - Maeli Zapata

#### **Wet Media**

First Place - Caimy Harris  
Second Place - Katerina Grace Purdy  
Third Place - Carlos Lerma

### GRADES 3-5

#### **Dry Media**

First Place - Brooke Boriack  
Second Place - Savannah Hicks  
Third Place - Victoria Trujillo  
Honorable Mention - Abigail Cruz

#### **Wet Media**

First Place - Matthew Garcia  
Second Place - Ashley Perez  
Third Place - Theodore Curiel  
Honorable Mention - Belissa Perea

### GRADES 6-8

#### **Dry Media**

First Place - Susannah Duerr  
Second Place - Ben Carlson  
Third Place - Jennifer Kinnison  
Honorable Mention - Samantha Garcia

#### **Wet Media**

First Place - Alita Austin  
Second Place - Stephanie Hinojosa

Third Place - Michael Brasfield

#### **Photography**

First Place - Cassandra J. Hicks  
Second Place - Javier Correa  
Third Place - Gabby Galvan

### GRADES 9-10

#### **Dry Media**

First Place - Brittany Reyes  
Second Place - Ngan Phan  
Third Place - Mark Lopez

#### **Wet Media**

First Place - Brandee Bonker  
Second Place - Richard Sanchez

#### **Photography**

First Place - Brandee Bonker

### GRADES 11-12

#### **Dry Media**

First Place - Marcus Benavides  
Second Place - Bryce Corbett  
Third Place - Selena San Miguel  
Honorable Mention - Andrew Hatcher  
Honorable Mention - Patricia Bell

#### **Wet Media**

First Place - Jessica Bass  
Second Place - Megan Mahlke  
Third Place - Elizabeth Lienau  
Honorable Mention - Max Meza

#### **Photography**

First Place - Candy Rudolf  
Second Place - Blaine Davis  
Third Place - Aaron Green

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