

Flint Hills Resources has owned and operated the Pine Bend Refinery for more than 55 years. The refinery is located at the intersections of Highways 52 and 55 in Rosemount, near the Twin Cities.

Flint Hills Resources has more than 900 employees at the refinery, which is considered one of the largest continuous construction projects in Minnesota. At any given time, there are 200 to 2,000 construction workers and contractors on site working on projects totaling more than \$200 million annually. Employees of Flint Hills Resources are engineers, chemists, plant operators, office workers, electricians, nurses, welders, pipefitters, lab technicians, computer specialists and maintenance reliability specialists. Sixty percent of employees live in the suburban communities surrounding the refinery.

The Pine Bend Refinery has a crude oil processing capacity of about 320,000 barrels per day<sup>1</sup> and is among the largest processors of Canadian crude in the United States. Crude oil and raw materials arrive at the complex via pipeline and are processed into petroleum products including gasoline, diesel, propane, butane, heating fuel for homes and businesses, and sulfur for fertilizer products. In 2006, the refinery completed a \$350 million to produce ultra low-sulfur diesel fuels and convert diesel fuel to gasoline to meet growing market demand.

Fuel produced at the refinery is distributed throughout Minnesota and the Midwest by pipeline, truck and rail. The pipeline system that delivers much of Pine Bend's fuel products covers 537 miles in Minnesota and Wisconsin. It is owned by Flint Hills Resources and operated by Koch Pipeline Company, L.P. This system includes a dedicated pipeline to the Minneapolis/St. Paul International Airport that supplies a large percentage of the jet fuel used at the airport, as well as strategically located terminals in Roseville and Rosemount, Minn.; Junction City, Waupun, Madison and Milwaukee, Wis.; and Bettendorf, Iowa. Flint Hills Resources also produces about 900,000 gallons of asphalt daily and operates terminals in Minnesota, Iowa, Nebraska, North Dakota and Wisconsin.

### **Background**

Flint Hills Resources, LLC, through its subsidiaries, is a leading refining and chemicals company. It markets products such as gasoline, diesel, jet fuel, ethanol, biodiesel, olefins, polymers and intermediate chemicals, as well as base oils and asphalt. The company, based in Wichita, Kan., has expanded its operations through capital projects and acquisitions worth more than \$6.4 billion since 2002. With more than 3,800 employees, Flint Hills Resources strives to create value for customers and society.

Flint Hills Resources refineries in Alaska, Minnesota and Texas produce a wide range of fuels that are transported through proprietary and common carrier pipeline systems, stored in strategically located terminals, and marketed to wholesalers and retailers throughout the United States. Ethanol plants in Iowa have a combined annual capacity of 435 million gallons of ethanol. The company's chemical business includes production facilities in Illinois, Michigan and Texas. These plants produce aromatics, olefins, polymers and intermediate chemicals. The company also owns an interest in a base lube oil facility in Louisiana, has made equity investments in bioenergy companies, and operates a biodiesel plant near Fort Worth, Texas.

## **Safety and Environmental Commitment**

Flint Hills Resources is committed to operating a safe and environmentally sound business that provides high-quality products and services while contributing to Minnesota's economy. Between 1999 and 2004, the refinery reduced its emissions by 50 percent, and earned a Special Recognition Certificate for Clean Air Awards Program from the EPA in 2005.

Other achievements include:

- The company's success at reducing flaring earned a Clean Air Award from the U.S. Environmental Protection Agency in 2004.
- In 2010, the company's overall refinery operations criteria air emissions per barrel were 64 percent lower than the average among peer refiners (based on latest comparison data available<sup>2</sup>).
- Since 1997, the refinery has reduced its emissions by 71 percent; it has the seventh lowest air emissions per barrel among the nation's 50 largest refineries.
- The refinery has earned the Wastewater Treatment Facility Operational Award in 2011 and the Operator Award in 2010 from the Minnesota Pollution Control Agency.
- The refinery has been a MNSTAR designated worksite since 2005. The designation, given by the Minnesota Department of Labor, recognizes an ongoing safe work environment and effective safety and health management systems.
- The refinery has decreased recordable injuries by 91% since 1998.
- Consistently earns American Fuel and Petrochemical Manufacturers' (formerly NPRA) safety awards, including Meritorious Safety Performance and Gold awards.
- The company's products terminals in Minnesota received the Platinum Safety Award from the International Liquid Terminals Association for its commitment to continuous safety improvement.
- The refinery has earned the Minnesota Safety Council's highest safety award, the Award of Honor, for three consecutive years. It has also earned the Outstanding Achievement Award.
- The refinery received the Minnesota Conservation Award from Xcel Energy for saving 8.7 million kilowatt hours during 2006.

## **Community Commitment**

Flint Hills Resources prides itself on being a good corporate citizen by participating in projects and activities that add value to the community and improve the quality of life in Minnesota. Outreach is primarily focused on science education, environmental stewardship and public safety. The River Heights Chamber of Commerce honored Flint Hills Resources with its 2011 Business of Year Award.

Community Highlights:

- In 2000, Flint Hills Resources and Ordway Center for the Performing Arts created one of the country's first international children's festivals. Today, the Flint Hills International Children's Festival is one of the best performing arts festivals of its kind not only in the United States, but in the world. The event has reached more than 350,000 people and grows more popular every year, inspiring new generations of children from all across Minnesota.
- As a premier sponsor of the Science Museum of Minnesota, Flint Hills Resources promotes science education and helps make science fun by sponsoring overnight camp-ins at the museum for children throughout Minnesota. Flint Hills "30 Schools in 30 Days" program with the Science Museum also brings hands-on science assemblies to area schools. The program has reached nearly 70,000 students during the past 13 years.
- Since 1994, Flint Hills Resources has been the title sponsor of Regions Hospital Foundation's Wine Auction and over the years has helped make it one of the premier charitable events in the state. To date, the event has raised more than \$5.2 million for patient care, research, and education.
- For the past 11 years, Flint Hills Resources has partnered with Friends of the Mississippi River to enhance and restore more than 1,300 acres of natural areas on Flint Hills' property along the Mississippi River, which provides critical habitat for both resident and migratory animals.

- Flint Hills Resources is a long-time supporter of the Ducks Unlimited’s Living Lakes Initiative. During the past 16 years, Flint Hills Resources contributions have led to the preservation and management of more than 36,000 acres of wild rice on 116 lakes, many thousands of acres of wetlands, and other waterfowl habitat throughout Minnesota.
- Flint Hills Resources sponsors DARTS’s community bus and underwrites its intergenerational mentoring program which focuses on math, science and reading skills. The Dakota Area Resources and Transportation for Seniors is a volunteer-based nonprofit organization that provides services for seniors in Dakota County.
- Since the Discovery Scholarships program started in 1992, Flint Hills has awarded more than \$500,000 in scholarships, helping to advance the academic careers of more than 400 deserving students from the local community.
- Flint Hills Resources, along with other Minnesota businesses, government agencies, and non-profit organizations sponsor Project Green Fleet. The project installs pollution control equipment in Minnesota school buses. More than 130,000 students across Minnesota ride in cleaner buses because of the program. The project was recently recognized by the U.S. Environmental Protection Agency as a national model for improving air quality, and earned a Clean Air Excellence Award in the Community Action category, one of only two nationwide.
- Since 1989, Flint Hills has supported a number of the Minnesota Zoo’s education programs, including the Zoomobile and the Zoo Safari program that supports the Minnesota State Science curriculum.
- Flint Hills provides regular fire training to our mutual aid partners in Rosemount, Inver Grove Heights, Hastings and Eagan, and for the volunteer fire departments along pipelines and for Minneapolis and St. Paul firefighters. Flint Hills also provides multi-faceted training center near the Pine Bend refinery designed for law enforcement tactical units, military personnel, and first responders. The facility is provided free to law enforcement agencies. More than 2,000 officers were trained at the facility in 2009 alone.

**Other Community Involvement**

Rosemount Leprechaun Days

Hastings Rivertown Days

Inver Grove Heights Star City Days

Engineers in Schools

Dakota County Technical College

Wildlife Habitat Council

Clean Air Minnesota

Minnesota Environmental Initiative

**Communicating With Neighbors**

Flint Hills Resources believes open communication with neighbors is paramount. As a result, the company actively sponsors and participates in the Community Advisory Council. The nineteen member council meets monthly to advise Flint Hills Resources on community needs and to serve as a sounding board for the company’s projects. All of the meetings are open to the public.

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More information at [www.fhr.com](http://www.fhr.com)

<sup>1</sup> Capacity figure as reported in the Oil and Gas Journal’s “Worldwide Refining Survey.”

<sup>2</sup> Emissions data calculated using publically available data from state or federal environmental departments.