Flint Hills Resources is committed to being a good neighbor and corporate citizen. We strive to create value for society through our business and by supporting causes that improve the quality of life in Minnesota. The Flint Hills Resources Pine Bend refinery provides approximately 50% of the gasoline and diesel fuel used in Minnesota and much of the jet fuel used at the Minneapolis-St. Paul airport as well as asphalt and other essential products.

LOCAL INVESTMENT

• In the last 10 years, Flint Hills Resources’ project investments at Pine Bend have equaled the resources required to build more than five Minnesota Twins baseball stadiums.
• Flint Hills spends and invests roughly $300-400 million annually to operate and maintain the refinery, which is a top local employer and Minnesota’s most active continuous construction site.
• The Flint Hills Resources Pine Bend refinery employs more than 900 people full-time and can have between 400 and 2,000 contract workers on-site on any given day.
• Statewide, Flint Hills Resources employs more than 1,000 full-time workers. Separate studies by Harrah Analytics and the Minnesota Department of Employment and Economic Development estimate that Flint Hills Resources is responsible for creating 5,400-7,500 jobs annually in Minnesota.
• Newly proposed reliability and efficiency improvement projects (crude/coker improvement projects), estimated at $400 million, are expected to create as many as 4 million hours of new work, increasing the temporary contract workforce from a daily average of about 500 people to more than 1,000 over at least the next five years.

MAKING A DIFFERENCE

Flint Hills Resources is proud to support many organizations and programs that help make Minnesota a special place to live and work.
• The annual Flint Hills International Children’s Festival in partnership with the Ordway Center for the Performing Arts
• Science Museum of Minnesota programming, school assemblies, and overnight field trips
• Minnesota Zoo traveling “Zoomobile” and school assemblies
• The annual Girls and Science exhibition in partnership with FOX 9
• Ducks Unlimited statewide wildlife preservation and habitat restoration programs
• Pine Bend Bluffs natural prairie and habitat restoration project in partnership with Friends of the Mississippi River and Great River Greening
• Project Green Fleet and the Minnesota Clean Air Dialogue in partnership with Environmental Initiative
• DARTS Learning Buddies program
• Flint Hills Resources Discovery Scholarships

INVESTING IN THE FUTURE OF THE PINE BEND REFINERY

Maintaining the continued health and viability of the Pine Bend refinery – Flint Hills Resources is investing in reliability and greater efficiency, while reducing key emissions.
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January 2013
Since it was established as the Great Northern Oil Company in 1955, the Flint Hills Resources Pine Bend refinery has played a pivotal role in providing the transportation fuels that power Minnesota and the Midwest. Today, with a capacity of 320,000 barrels per day, Pine Bend is among the nation’s top producers of fuels and other petroleum-based products that are essential to the economy and modern life. Most importantly, Pine Bend is one of the safest and cleanest refineries operating in the United States, and it continues to improve. Since 1997 the Pine Bend refinery has lowered emissions of traditional criteria pollutants by 70%, while increasing production to help meet demand for transportation fuels. The refinery’s emissions per barrel are 50% lower than the industry average for large refineries. Pine Bend has also realized new standards in safety, earning recertification as a Minnesota STAR worksite and reducing injuries by more than 80% over the past 15 years.

Flint Hills Resources is planning a number of projects at Pine Bend that are in various stages of development. Some of these projects may require permits, and each project is subject to final management review.

- **Propylene Storage and Distribution**—gives the refinery the flexibility to diversify its product mix by marketing a key ingredient in the manufacturing of plastics. The project involves building a rail rack and staging area on Flint Hills Resources’ property as well as adding two storage spheres.

- **Crude/Coker Improvement Projects**—involves replacing three less efficient heaters with two new state-of-the-art heaters, upgrading an existing process heater, and making improvements to the refinery’s cooling towers. The new and modified heaters will include best available control equipment for nitrogen oxide emissions and will use cleaner-burning natural gas or fuel gas. The new equipment and process improvements will lead to more efficient operations, allowing the refinery to operate closer to its current design capacity of 320,000 barrels per day while continuing to make reductions in key emissions.

- **Wastewater Treatment Plant**—strengthens the refinery’s wastewater treatment capability and improves its ability to remove materials from its water discharge which will help ensure the refinery remains well below its permit limits. Among other things, the project includes adding a large equalization tank and adding additional oil/water separation equipment.

- **Coke Drum Replacement**—improves the safety and reliability of essential equipment that allows the refinery to convert petroleum to fuel. The project involves replacing two large, 10-story coke drums that are reaching the end of their useful lives with newly fabricated vessels of the same size. One of the largest cranes in the U.S. will be on site in the fall of 2013 to install the new drums.

- **New Buildings**—provide space for personnel and equipment, including adding up to 100,000 square feet for construction and project management offices, contractor offices, engineering space, machine shops, and an upgraded lab. As part of the ongoing safety improvements, approximately 30 state-of-the-art, reinforced office modules will be added to provide contractors a place inside the refinery for regular breaks and meetings.

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Pine Bend is committed to building on its success. With a number of projects underway and others proposed for implementation over the next several years, the refinery is focused on maintaining a safe work environment, becoming more efficient, continuing to lower key emissions, and remaining fully compliant with all state and federal regulations. These projects range in scope from a recently completed $2 million staircase safety structure around one of Pine Bend’s major units to a series of proposed reliability and efficiency improvement projects, costing approximately $400 million, which will reduce key emissions and improve the refinery’s ability to convert crude oil into transportation fuels. These new projects are expected to create as many as 4 million hours of new work, increasing the temporary contract workforce from a daily average of about 500 people today to more than 1,000 over at least the next five years. The projects require a permit from the Minnesota Pollution Control Agency and still must receive final approval from Flint Hills Resources management.

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