

FLINT HILLS RESOURCES PINE BEND – ENVIRONMENT, HEALTH AND SAFETY

Flint Hills Resources Pine Bend is a leading producer of the transportation fuels that power the Midwest and is among the cleanest, safest, and most efficient refineries in the country.

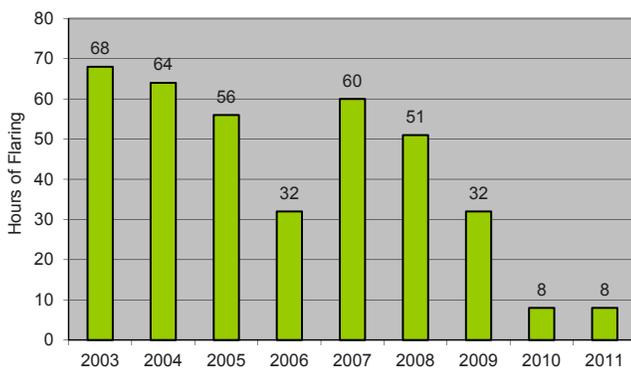
Environmental, Health and Safety Performance Summary

- Voluntarily reduced total criteria air emissions by more than 70% in the past 15 years, with annual reductions in total air emissions 10 of the last 11 years, while increasing production capacity in order to help meet the growing demand for transportation fuels
- Emissions per barrel are 50% below the industry average for large refineries
- Reduced injuries by more than 80% during the past 15 years and is a leader in advancing process safety standards throughout the industry
- Top quartile in energy efficacy among the nation's largest refineries
- Industry leader in flare management



KEY ENVIRONMENTAL AND SAFETY INITIATIVES:

Pine Bend Annual Hours of Flaring



Flaring Reduction Program. In 2011 Pine Bend reduced flaring time to a record low of eight hours for the second consecutive year, down from 32 hours in 2009 and 64 hours in 2004. The Environmental Protection Agency awarded Pine Bend a Clean Air Award in 2004 for its program to reduce flaring.

Water Conservation and Treatment Program. The Pine Bend refinery began a water recycling program in 2006 that enables it to re-use discharged water. The refinery's wastewater treatment plant successfully processes 3.5 million gallons of water per day. The Minnesota Pollution Control Agency has honored the refinery as an outstanding wastewater treatment operator. The refinery has reduced its water use to approximately .5 of a gallon for every gallon of product produced.



Clean Air. Flint Hills Resources is the primary sponsor of the Environmental Initiative Clean Air Dialogue, which is focused on bringing businesses, nonprofits and governments together to explore new opportunities to collaboratively improve air quality in Minnesota.

Ultra-Low-Sulfur Diesel Project and Blue Planet

Gasoline. Flint Hills Resources began producing ultra-low-sulfur diesel fuels two years ahead of a federal requirement. In 1999 Flint Hills introduced Blue Planet, the first low-sulfur gasoline available in all octane grades in the Twin Cities. Blue Planet met EPA requirements five years before they took effect.

Project Green Fleet. Flint Hills Resources is a founding sponsor of Project Green Fleet, a collaborative effort with Environmental Initiative to install pollution control equipment in thousands of Minnesota school buses, heavy-duty trucks, and other diesel vehicles. The project was recognized by the EPA as a national model for improving air quality and earned one of two national Clean Air Excellence Awards.

Habitat Restoration. Flint Hills Resources, Friends of the Mississippi River, and Great River Greening have worked together for 12 years to restore 1,600 acres of natural prairie and oak savanna in an area known as the Pine Bend Bluffs along the Mississippi River. Since 2000 restoration efforts

have focused around the protection and enhancement of native prairie plants with prescribed burns and the removal of invasive plants, helping to restore the area to pre-settlement conditions. Additionally, Flint Hills Resources and Ducks Unlimited have worked together to protect and enhance Minnesota's lakes and wildlife habitat since 1985. Highlights of the partnership include managing more than 36,000 acres of wild rice on 116 lakes in northern Minnesota, restoring and enhancing eight large shallow lakes totaling 6,000 acres, and permanently protecting 1.5 miles of sensitive shoreline and 202 acres of wetlands and grasslands.

Safety Awards. Pine Bend has decreased recordable injuries by more than 80% in the past 15 years. In 2010 the refinery received the Governor's Safety Award from the Minnesota Safety Council for the fourth consecutive year and the Canadian Pacific Chemical Shipper Safety Award. Pine Bend was recertified as a Minnesota STAR worksite in 2008. Pine Bend also received numerous safety awards in recent years from the National Petrochemical & Refiners Association and the National Safety Council.