

# SHELL LETTERGRAM

SHELL DEER PARK



*Aerial view of the delayed Coker Unit taken shortly before startup.*

## COKER UNIT STARTS UP

**A** major milestone took place at the end of April with the startup of the delayed Coker Unit, a major piece of the Deer Park Refinery Limited Partnership's \$1 billion upgrade program.

Actual startup of the unit, which processes heavy Maya crude from Mexico, began late April. The number of startup operations personnel (Shell and contract) totaled about 70 in addition to about 100 maintenance personnel on the Engineering Support side at the peak of startup activity. Personnel actually running the unit was expected to drop down soon to about 70 Shell operators, foremen, inspectors, engineers and crafts people.

Personnel executed plans to start the unit in a safe and environmentally responsible manner and were successful. The unit passed an extensive pre-startup safety review in March that assessed the readiness of the unit. Earlier, operators completed six weeks of intensive classroom and hands-on field training. Coker startup personnel also reviewed the plant's layout with Emergency Response teams.

Before all systems were go, performance tests on the compressors that drive the units were also completed. Air was pumped through part of the piping systems, a process that is an "extensive effort," says NICK BELL, Mechanical Equipment, who heads up the "air runs".

"Once we got through the checkout of the compressors, motors, turbine drivers and all the other support systems, we were ready for the actual startup and run," says Bell.

Construction assurance has been a critical success factor in the project, according to DAN YODER, Coker, GOHT operations manager. This activity, ongoing since the early part of the year, has

*(Continued on Page 6 -  
See "Coker Unit Startup")*

YOU'RE THE...  
VERY BEST IN...  
ALL YOU DO.



# Safety

## Recommitting to premier ENVIRONMENTAL PERFORMANCE

**D**ue to a number of circumstances, Shell Deer Park's 1994 environmental performance was not up to the high standard of performance DPMC employees expect of themselves. To make significant progress in 1995, the Environmental Conservation Team, with the support of all employees, is taking a lead role in helping to drive performance improvements. They're doing it through a five prong approach that calls for:

- Asking all DPMC employees to recommit themselves to executing all tasks in a manner that protects the environment, as that is a fundamental expectation we all clearly have of ourselves;
- Validating that investigations and prevention action plans in response to each 1994 exceedance are on track;
- Driving for root cause solutions to systemic or recurring issues from 1994 or previous years;
- Studying the environmental risk areas resulting from new unit startups to ensure appropriate prevention plans are in place.

"Throughout the year we'll keep monitoring, measuring and reporting out to management teams and employees about where we stand and, hopefully, that we're improving," says TOM TULIG, technical manager, Environmental Engineering.

"We want to reinforce our strong personal commitment to making substantial improvement in environmental performance in 1995," says JIM NICHOLS, Refining superintendent.

"With all of us pulling together, WE CAN DO IT," says J.D. JOHNSON, Chemical superintendent, "and we would like to ask each member of the Deer Park Oil Products and Chemical teams to join us in making 1995 our best year ever!"

Members of the team are:  
J.D. JOHNSON, JIM NICHOLS,  
CHARLIE GILLARD, JOE McADAMS,  
JOHN HOLDEN and TOM TULIG. ■



## Safety Stars to enter the spotlight

**T**he Safety Star Awards program, an element of the 1995 Health and Safety Direction, kicks into high gear with plans to start the departmental nomination process. May 15 is the deadline for managers to submit departmental write-ups to nominate their department.

This year four areas have been designated as award targets: safety meetings improvement, JSA (Job Safety Analysis) improvement, positive intervention program, and departmental safety committees. Write-ups should explain the department's progress in meeting or exceeding the quality benchmark in one or more of the four areas.

A maximum of one office and two field departments are eligible for Safety Stars per quarter. The Health and Safety Coordination Team (HSCT) will choose the winners. Winners will receive four pectens per

person, a hard hat sticker identifying them as safety stars, possession of a traveling trophy and dinners (at the department manager's discretion and budget).

The HSCT is scheduled to select winners by July 17 for the second quarter. On July 28 awards will be delivered and in August, trophies presented at the Supervisors' safety meetings. ■



Your department could win this Safety Star Award Trophy.

## Deer Park Makes MOST of Oil Spill Clean Up

**W**hen pipelines broke and oil spilled into the San Jacinto River last year, industries called on the Clean Channel Association (CCA), and the CCA called on MOST, Shell Deer Park's Marine Oil Spill Team.

Offering its high tech mobile command center and its members, MOST, with the help of the U.S. Coast Guard, helped lay a boom in front of the Battleship Texas to help contain oil movements into the area.

The CCA is a cooperative group made up of members of industry, including Shell, whose purpose is to supply resources to rapidly contain an oil spill in the inland waterways of the Upper Gulf Coast and to protect environmentally sensitive areas from contamination.

MOST members are trained and ready to respond to oil spills. ■

# OLEFINS BD-3 PRODUCTION TAKES OFF...



## DPMC the victor over Norco in production challenge

### A different way to run

BD-III production records soar with imported feeds

**B**D-III broke a long-time practice of running imported feeds last year and it payed off. Having overcome the resistance of augmenting the supply of crude BD by purchasing it outside of Shell, DPMC's BD-III Unit hit an all-time production record that has translated into big money for Base Chemicals.

Last year BD-III broke BD-2's record of 247.7 million pounds with a whopping 260.6 million pounds. In dollars that translates to about \$1 million net income. "If we had just relied on feed from Olefins, we'd have only made about 240 million pounds," says RUSS RHODES, manager Heavy Olefins.

The jackpot came only after some hesitation and resistance, according to Rhodes, who explained that Shell Deer Park apparently had not recovered from a bad experience with outside crude back in the 1980s and solvent contamination problems in the IRU. "But, with the push for 100 percent unit utilization, the temptation to experience production leaps was irresistible," says MICHELLE IMHOFF, TSO.

"We had to set specs for crude BD so that people could feel comfortable that we wouldn't go off spec, that we wouldn't put something in the plant that would impair our ability to run," adds Rhodes.

Emotions ran high when the first feeds were turning up an ugly coffee color solvent instead of the weak-tea color the unit was used to. After having fought through that came the realization that things were a little different, "but we were still able to make good product with good quality and more pounds," says Rhodes.

"We did something we just had to try," says JIM CARMICHAEL, BD-III SOM. "When we found it would work, it kind of brought us together. Everyone shared in the risk and we discovered things might work if we gave them a chance."

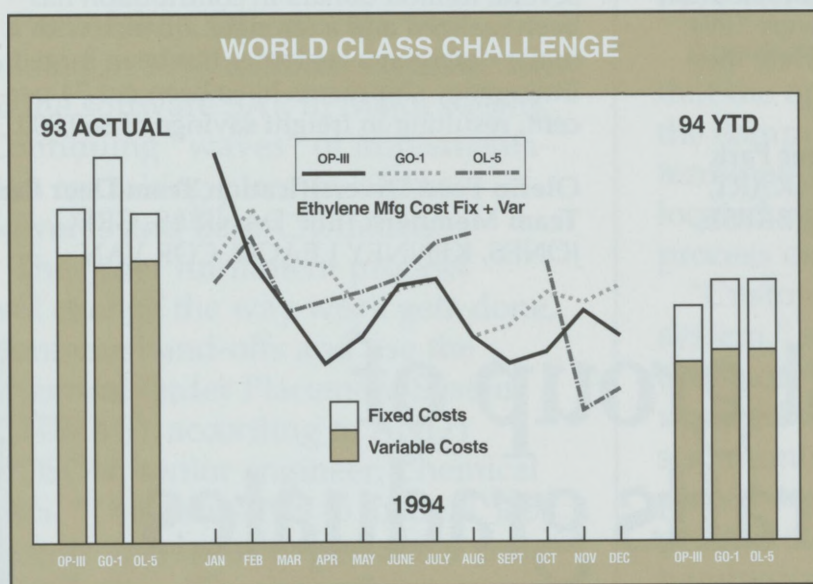
Production at BD-III has done well ever since; so much so that the capacity for BD-III was raised - at least unofficially - a figure the department and other support folks at Shell are still confident of reaching even during a turnaround year.

So far this year, BD-III hasn't let the department down. After another record month in January, "it's become the norm to have crude BD in the plant and make high levels of production," adds Rhodes. ■

**S**hell Deer Park and Norco locked horns again last year in the second round of a World Class Challenge that has been growing in popularity. And, DPMC has come out the victor in reducing ethylene production costs.

Turning around a poor start, DPMC's OP-III unit vied with Norco's OL-5 and GO-1 on a plant by plant basis, and showed a 30 percent reduction in CEM (Cost of Ethylene Manufacturing) from 1993 to 1994; compared to Norco's OL-5 which reduced CEM 20 percent over the same period; GO-1 actually demonstrated the most improvement with a 33 percent reduction in CEM, but still finished nearly one cent per pound behind OP-III. The reduction in CEM for Deer Park was worth over \$50 million in increased contributions before taxes, according to JIM OVERMAN, manager, Olefins.

"We were very aggressive in getting the new feedstocks in here," says Overman, explaining the win. "We ran ten new types of feeds, and we continued good work in fixed cost control and overall good reliability for the year."



The World Class Challenge, originating as a half-serious gesture by Overman to his OL-5 counterpart in 1993, became a somewhat emotionally charged battle ever since. The Base Chemical Business Center decided to adopt sponsorship for the Challenge last year.

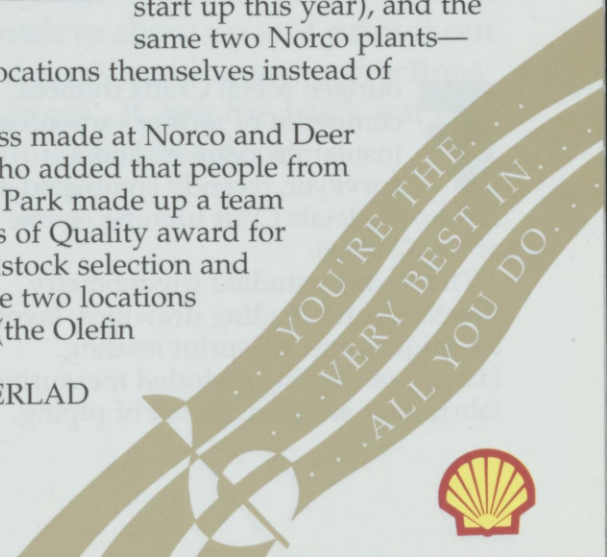
Norco won the 1993 challenge, a close race that narrowed a large gap at the outset.

The 1995 challenge is underway, this time pitting DPMC's OP-III and newly revamped OP-II (which will start up this year), and the same two Norco plants—

but this time comparing the locations themselves instead of unit by unit.

"There was fantastic progress made at Norco and Deer Park both," says Overman, who added that people from Head Office, Norco and Deer Park made up a team which won a 1994 Champions of Quality award for these same techniques in feedstock selection and feed processing techniques the two locations used during the competition (the Olefin Feed Diversification Team).

Base Chemicals Manager GERLAD SYLER visited the Complex last month, presenting Olefins with a World Class Challenge Trophy. ■





# RECOGNITION

## IS ON BUSINESS SERVICES' AGENDA

**F**or well over a year, Business Services has been dedicated to recognizing performance achievements of its people through a formal recognition process. Earlier this year, it held its first presentation to employees for significant accomplishments, including perfect attendance and safety performance.

From each of the Business Services departments, plaques and a dinner invitation were awarded and a synopsis given on each person's achievement during a Business Services breakfast. Sixty-one employees were also recognized for perfect attendance—27 of which had no absences for at least five years, while six had surpassed 10 years. The group also celebrated a two-year record with no OSHA recordables as of September, 1994.

The breakfast was the second gathering of Business Services since forming a formal recognition process in August last year. A team of seven employees was formed at that time to implement a program that would encourage recognition by both peers and supervisors to reinforce those who have made significant contributions toward Shell's Mission, Vision and Values, according to STEPHANIE BROOKS, a member of that team.

The team created an on-line RMDS form so that employees could nominate their co-workers for significant accomplishments. It also distributed a list of recognition criteria—innovation, creativity, exceptional contributions and achievements and leadership. Currently, the team is exploring ways to incorporate Shell's Core Values into the criteria. ■

Recognition team members are:

STEPHANIE BROOKS  
Operations Business  
Support-Refining

BOB HENDRICKS  
Business Support-MPO

CAROL MITCHELL  
Product Analysis

RHONDA PEREZ  
Administrative Services

DAVE TIETJEN  
Information Services

FLOYD VAN WAGNER  
Security

DENNIS WYMORE  
Operations Business  
Support-Chemical

## Let's not forget these Quality Champions

**A** couple of issues back, the Shellegram lauded the effort of six DPMC Champions of Quality nominees. Missing, at least in part, from that article were two teams: the Make to Consumption Team and the Olefin Feed Diversification Team, which, in combination with other teams and renamed, were 1994 Champions of Quality winners. Here they are in their Deer Park form.

**Make to Consumption Team Deer Park Team Members:** BRIDGET FRANKART, BUDDY KELLY, CHARLIE CALABRESE, JON STOKES, TONY PYER.

The Make to Consumption Team designed and implemented several radically different approaches to production planning and inventory management, the results of which are still unfolding.

Already, substantial new business worth several million dollars in contribution has been realized and a stronger alliance with a major detergents customer has been forged. Emergency shipments have been cut 74 percent, resulting in freight savings of \$60,000.

**Olefin Feed Diversification Team Deer Park Team Members:** JEFF DANIELS, GREG JONES, KENNEY LEACH, COR VAN

EGMOND, VINCE SLOTERDIJK; CHARLES DODSON and RICHARD RODRIGUEZ.

By uncovering, testing and processing eight new feedstocks, the Olefin Feed Diversification Team moved Base Chemicals closer to its strategic objective of becoming the low-cost ethylene supplier to the industry.

An important variable in this effort was feedstock selection and processing of economically advantaged feeds, an effort in which Shell Olefins has become the world's leader. The team achieved a \$10 to \$15 million CIBT improvement in feedstock value with minimal capital investment. ■

## First group of Metal Crafts graduates

**F**ourteen Metal Crafts trainees, composed of former carpenters, insulators, painters and a surveyor, recently completed a 288-hour Metals Craft training course at Lee College.

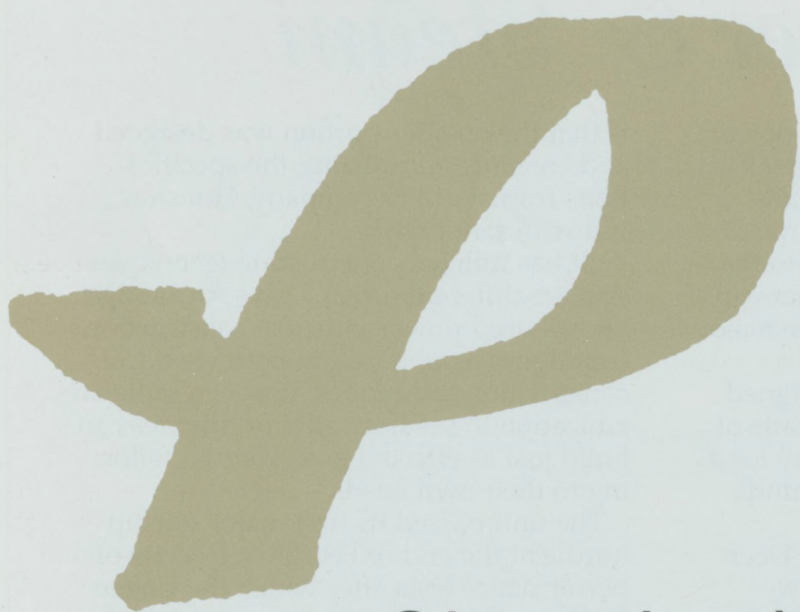
The trainees studied trigonometry, sketching and reading drawings, layout techniques and blueprint reading. Hands-on training included measuring fabrication and installation of piping.

This accomplishment is especially noteworthy because, according to college officials, the trainees surpassed all previous classes from other local refining and chemical facilities in quality of work, performance and desire to learn.

Says RAY STARNES, their foreman, "Most importantly, they accomplished this training without an injury." ■



DPMC'S First group of Metal Crafts trainees and their instructors: Barry Baker, Gus Geisler, Lee College Instructors; James Licklider and Ned Bush, Earl Davis, Mike Campbell, Mike Cayton, Don Chase, Guy Thornton, Jack Johns, Mickey Walton, Quincy Rodgers, Rickey Witt, Steve Rouse, Ed Johnson, Joe Wolf, and Ronnie Sims.



## Chemical reinvents the supply chain with Process Redesign

**P**rocess Redesign began in 1993, new processes and tools for the rethinking and radical reengineering of business processes which are being implemented throughout the Chemical organization.

Resins and Solvents have been the first to incorporate the changes developed from Process Redesign. Two key activities, Production Planning and Operations Redesign (PP&O) and Customer Order Inquiry and Fulfillment (COIF) are linking Resins and Solvents suppliers and customers in a new way.

PP&O involves the entire supply chain for a given product. It includes the production and logistics of deciding what product and how much to make, identifying and procuring raw materials, unit schedules, packaging, warehousing and distribution. New Supply Manager positions for Resins and for Solvents were created to manage the entire supply chain. A key tool in the PP&O redesign is the use of "make to" models for unit production planning. A Make to Consumption (MTC) pilot is underway for SolB, C6, BPA and

cumene. All Resins and Solvents products will be scheduled with a "make to" model when the PP&O redesign work is complete.

COIF involves the process from initial customer inquiry through invoicing and financial settlement.

Part of the COIF process was piloted in 1993 with the introduction of the software SAP in Major Resins. Continuing "waves" of implementation are taking place in Resins, Solvents and Base Chemicals.

The order fulfillment process will change the way work gets done, eliminate hand-offs and use the Chemical Order Placement System (CHEOPS), according to ANDY EIDSON, senior engineer, Chemical E&S. "This translates to loaders, lab technicians, security personnel and Distribution/Customer Service accessing CHEOPS through a PC for each shipment," says Eidson.

The work process flow for truck, rail and marine movements is also being altered by COIF redesign. Innovative tools will streamline processes through drastic changes in information technology, according to Eidson. ■

## Customers served faster since rack redesign

**P**rocess Redesign makes its mark at the West Rack in the form of an order processing redesign that reduces hand-offs in order taking, billing and delivery times.

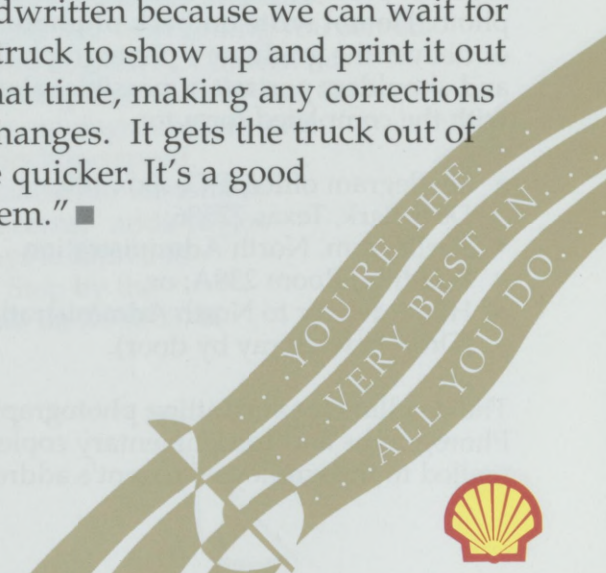
With the new Chemical Order Placement System (CHEOPS), orders are taken by an account service representative (ASR) and are then scheduled to load at the rack. The operator, with access to the same system, accesses the order placed by the ASR, and creates the paperwork needed to load the products.

After loading, the operator updates the order with the correct weights and then assigns it a "Goods Issued" notation, which is used to remove that amount of product from inventory and to create a customer invoice.

"This system allows an order to be on its way to the customer in eight hours instead of the next day," says LEO TREVINO, West Rack foreman.

Another feature of the redesign is that the operator has easy access to the computerized order through a terminal housed in a new building located right on the rack and can process orders right there.

"Customers and drivers like the system," says CHUCK TIMM, operator. "The bills of lading can be updated with truck numbers and seal numbers (seals are plastic tags placed on the truck outlet valve). It's printed out on the bill rather than handwritten because we can wait for the truck to show up and print it out at that time, making any corrections or changes. It gets the truck out of here quicker. It's a good system." ■



**COKER UNIT STARTUP**  
(Continued from page 1)

employed as many as 10 operators and 20 or more inspectors working daily with Construction Assurance and Brown & Root so the Coker could complete startup within eight days of the completion of construction.

Another big effort, operator training, started in late 1994. Everyone working in the Coker operations organization has been given an average of six weeks of training, according to Yoder.

Startup kicked off with an open house April 23 when families of Coker personnel toured the plant. The following day a private dedication ceremony was held with attendees PHIL CARROLL, Shell Oil Company president and PEMEX Director General ADRIAN LAJOUS. ■



## COGEN: Firing up Power & Steam

Shell's capacity to generate power and steam to run the Complex is now expanded with the start-up of two Cogeneration Units, another piece of the work related to the Deer Park Refinery Limited Partnership, the Shell and PEMEX joint venture major upgrade.

The Cogeneration Units are designed to generate a nominal 160 megawatts of electrical power (enough electricity for a city of 30,000) and one million pounds per hour of steam.

A unique arrangement for Shell Deer Park, the Cogeneration Unit has two facets—on-sites and off-sites. Both have been managed, designed and constructed by contractors for a third party, Houston Industries, the organization that will actually operate the facility.

Another interesting aspect of the project, according to CHAD ALEXANDER, Major Projects, construction staff engineer,

is that the on-sites portion was designed and constructed utilizing the specifications from a utility company, Houston Industries, not Shell.

"It has utilized construction techniques that are different for us," says Alexander. "It has used power industry construction techniques as opposed to petrochemical construction techniques. It's been quite an education to see how other industries can build just as effectively as we can, tailoring to their own needs."

The unit passed its first major startup hurdle at the end of February, a series of performance tests after which the Cogen Unit was designated as "commercially operational."

Construction on the unit began in February last year and was completed at the end of January this year, "a fast-track schedule for a fairly sizeable power plant," says Alexander. ■

## Residents stashed trash at annual collection day

Deer Park area homeowners once again had an opportunity to rid their homes of unwanted, unused and out-of-date hazardous household products properly during East Harris County industry's Household Hazardous Materials Collection Day 1995 held April 22.

Five locations were set up this year in Deer Park, Clear Lake, Houston, Channelview, Baytown and Pasadena.

Household Hazardous Materials Collection Day 1995, now in its seventh year, honors the 25th Anniversary of Earth Day, a day of

environmental awareness, held nationwide each year.

The program is endorsed by John Hall, commissioner of the Texas Natural Resource Conservation Commission, who considers it a part of the TNRCC Clean Texas 2000 program.

Each year Texans throw away 60,000 tons of household hazardous waste. Household Hazardous Materials Collection Day has accommodated the growing need to dispose of these items properly.

Last year 2,094 Ship Channel-area

households disposed of 264,254 pounds of automotive, paint, cleaning and other waste materials, a jump of over 62 percent over the previous year's collections. A total of 619,844 pounds have been collected since 1987.

Sponsors of the event this year include some 85 members of the East Harris County Manufacturing Association (ECHMA), area cities and Local Emergency Planning Committees (LEPCs), as well as environmental service companies. ■

## Turn in your graduate photos

The Shellegram once again is making plans to honor graduating sons and daughters of Deer Park Complex employees and retirees. The annual Graduates Issue will be published in July and will include graduating employees and their spouses. Be sure to get your photo in by June 6.

Please print graduate's name clearly on a separate piece of paper and apply to back of photo. **Do not write on back of photo.** Send or deliver the graduate's photograph (head-and-shoulders portrait, if possible) along with the completed form to:

- Shellegram office, P.O. Box 100, Deer Park, Texas 77536;
- Shellegram, North Administration Building, Room 238A; or
- Hand-deliver to North Administration Building, Room 238A. (Drop in wall tray by door).



The deadline for submitting photographs and forms is Wednesday, June 6. Photographs and complimentary copies of the Graduates Issue will be mailed to the employee/parent's address listed on the form provided.

TYPE OR PRINT CLEARLY

Graduate's Name \_\_\_\_\_  
son/daughter \_\_\_\_\_ spouse \_\_\_\_\_ self \_\_\_\_\_

Employee/Parent's Name \_\_\_\_\_  
Department \_\_\_\_\_ Work Extension \_\_\_\_\_

Graduating From (Check one)  
High School \_\_\_\_\_ College \_\_\_\_\_

Name of school \_\_\_\_\_

Location of school (city, state) \_\_\_\_\_  
Degree \_\_\_\_\_ Major \_\_\_\_\_

Employee/Parent's Address \_\_\_\_\_

Home Phone \_\_\_\_\_

**Attach photo of graduate with name on back.  
Final deadline for submission is June 6.**

## Step back in time at the Shell museum

A new look makes it  
more attractive than ever

Take a trip down memory lane—drop by the Shell Historical Museum for a tour to see what's new—or rather, old. Actually, there is something new about the museum. New carpeting, new exhibits and new arrangements of existing exhibits give it more of a museum appearance instead of the feeling of office space designated as a museum, explains KIM WESTBROOK, Engineering Support, a member of the Shell Historical Society who are the caretakers of DPMC's decade-old house of Shell memorabilia.

Volunteers from the society, an organization of employees and retirees, have labored to create new arrangements and lighting effects that will be a delight to all who enter.

"What we have is more than just a memorabilia collection now," says Westbrook. "We've put things on display in such a way that it draws people's interest."

One such display is a collection of paintings by local artist Martha Scott Hayes, which was created for Shell and displayed during a Sesquicentennial celebration.

A new display that they feel sure will peak some interest is an artistic antique shoe collection, one of the employee-loaned exhibits the museum will be showcasing.



Bud Kyzer, Alky/Thermal Cracking, stands beside his mother's miniature antique shoe collection now on display at the museum.

The shoe exhibit, on loan from LAWANDA KYZER, mother of employee BUD KYZER, Alky/Thermal Cracking, is part of a new program for the museum. Although all other exhibits are Shell related, Historical Society members wanted the museum to give employees an opportunity to share a part of their personal history, explains Westbrook.

"It adds to the variety of what we have here," adds MAURINE BISHOP, retiree and Historical Society president.

The museum continues to

break out of the confines of its four walls by loaning exhibits and display skills to the local community. A travel display, which included old Shell service station maps, was the subject of a Deer Park Library exhibit. Another was a display for the City of Deer Park's Salute to Industry.

"We like to show off," quips Bishop, who helps staff the museum during the museum's regular hours, 10-4 Wednesdays (formerly Fridays) and during private tours. She pitches in for a lot of the curator work according to fellow Historical Society members.

The museum is fast becoming a "must-see" side tour to groups coming to Shell Deer Park. The museum was asked to set up a special display recently for a PEMEX visit . . . and people from other Shell locations come to tour Shell Deer Park's museum since the word has spread, says Bishop.

The museum encourages calls for private showings and for any other special groups or individual appointments. The number is (713)246-1195. (Voice mail is processed daily so your call will be received promptly.)

Bishop sometimes acts as a Shell museum consultant, sharing information and skills with others since the Deer Park museum was the first of its kind for Shell nationwide. She finds it fun interacting with other Shell museums which have begun popping up over the years.

She recently attended a meeting to discuss the newest plans to open a sprawling glassed-in museum at One Shell Plaza to contain Shell artifacts dating back to the early 1900s. The museum is scheduled to open in September. Another is to open soon at Norco.

"We've become a real network, sharing ideas back and forth," says Bishop.

"We've been able to give something to these new startup museums, too," says Westbrook. "Sometimes we'll have an item that came from Wilmington or Norco or some other location. We like to offer it back to that location's museum to start them off." ■



## Cafeteria caters to broader, healthier food selections

It's lunchtime. You're hungry. And to satisfy your workday palate, the cafeteria has been cooking and preparing for hours to bring you a quick, delicious meal that'll keep you fueled until quitting time.

Canteen Dining Services, the company that runs the breakfast and lunch lines and caters your meetings and special on-site events, is constantly working to keep up with you and your varied dining preferences.

Lunches have changed since Canteen took over food service in June 1993. "We've come a long way in terms of offering low-fat, low-calorie choices," says CAROL TAYLOR, manager of the cafeteria.

Right beside the meats and potatoes and chicken fried steak platters are healthy choices beginning with fat-free salad dressings, light pasta entrees and sugar-free soft drinks, and healthy dessert selections. The lighter selections are going over big.

Daily low-fat, low-calorie Lean Cuisine lunches have been a big hit—some 50 to 80 customers daily eat them. In addition to Lean Cuisine, the cafeteria offers light choice/right choices like tuna and other salads packed to go, frozen fat-free fruit bars, and sugar-free snacks. There's also fresh cut fruit on the salad bar, prepared without added sugar. To start out the day, the light choice/right choice breakfast selections include sugar-free cocoa, skim milk, whole wheat toast, non-fat yogurts, fresh cut fruit and cereals.

Lighter meals are also built into the main food selections. Canteen adds no salt, pepper, butter or other fat to its vegetables and beans, and rice is steamed with no butter added. Even the vending machines offer low-fat cookies, pretzels and animal crackers.

To take healthy eating choices a step further with a program that extends to home, Canteen offers a Lifestyle 2000 health and wellness program for their customers. Have a personalized nutrition analysis of your daily eating habits worked up, and get dieting advice complete with menus. Taylor has presented the program at many safety meetings.

What you see all around you in the dining center is a product of what customers have said they would like to see—lots of variety for the dieter, the diabetic, the fat gram counter, and for those that love a good Philly cheese steak—pizza, hamburger and fries.

Taylor is also concerned with getting you served and out fast if you're in a hurry. Canteen has added a second serving line, a "Grab and Go" area, and is always moving things around to help improve lunchline speed.

"Canteen appreciates our customers' comments and concerns," adds Taylor.

The staff is always attentive to customers' needs. Stop by the dining center or call on X6-6503. ■



## MILESTONES

<b>SERVICE ANNIVERSARIES</b>	B. MANZANALES East Maintenance	R.E. HEDDEN, JR. Heavy Olefins Manufac.	S.L. SHIPPY Olefins
<b>25 YEARS</b>	D.H. NELSON Mechanical Equipment	J.D. LOWERY Community Relations	T.G. SMITH BPA4
J.E. BREWER Olefins III	L.I. RILEY CCU	G.J. LUBRICK Solvents & Treating	D.L. TITTLE Major Resins
G. BUSTAMANTE Central Maintenance	M. RODRIGUEZ Olefins Maintenance	D.W. McNABB Docks	P.T. TRAN Control Systems
P.B. COTEST Control Systems	G.R. VILLARREAL Docks	J.H. MARTIN Heavy Olefins Manufac.	J.M. VASQUEZ Alky/Thermal Cracking
P.J. KELLY Olefins Maint.	R.A. WALSH Engineering Maintenance	B.C. MATTHEWS Dispatching	J.C. WATSON Control Systems
V.S. ROOPNARINE Project Engineering	G.F. WILSON Control Systems	M.F. MOODY Solv./Distribution	A. ZAMORA, JR. Lube Logistics
R.J. TIMMONS Employee Development	<b>15 YEARS</b>	S.R. RAMSEY MPO/Coker	G.E. ZIER Quality Assurance
C.W. VASEK S&S/Engrg. & Pr.	E.R. ARRENDONDO Dispatching	G.D. RAY CCU	<b>10 YEARS</b>
<b>20 YEARS</b>	D.W. BLACK Log/Util./Env.	P.W. REED Aromatics	J.R. JENKINS BS/Financial Co.
L.A. ALLEN Resins/SET	T.W. BRADLEY Solvents & Treating	K.M. ROUSE Solv./Distribution	D.L. TACKETT Health & Safety
J.W. ASH Heavy Olefins	T.B. BROWN Control Systems	N.E. SALAMEH Lube Manufacturing	T.S. TIPPIT BS/Information Services
J.L. BATIS Utilities	J.M. CASTANON Solv./Distribution	W.J. SARGENT Lube Manufacturing	<b>MEMORIUM</b>
P.A. DENMAN Quality Assurance	M.D. CHAMBERLAIN Olefins Manufacturing	J.M. SENNETT Lube Manufacturing	M.L. (LUTHER) ROLLER, retiree, died Feb. 25 in Pasadena
W.S. GOODWIN MPO/Startup Supt.	A.S. CRUZ Solv./Distribution	R.L. SEXTON Docks	F.W. (FRANK) BALDWIN, JR., Lube Logistics, died Feb. 26 in Liberty
F.Y. GRAY Major Resins	R.M. DOTSON Lube Manufacturing	A.E. SHIPLEY Phenol Acetone	
W.A. LEA Control Systems	J.M. HARRISON Phenol Acetone		

## SERVE



SERVE volunteers serve up hot dogs and other party lunch items to those involved in the clean-up effort during Bays 'n Bayous Trash Bash March 25 at the San Jacinto Monument.

## SCORANOTES

Put these camping dates and places on your calendar:

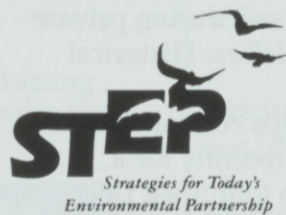
- May 12-14 at San Luis Pass
- June 9-11 at Lake Livingston
- July 7-9 at Hank's Marina (Sam Rayburn)

For those interested in a big splash of another kind, put on your bathing attire for a Wave Pool Party at La Porte Wave Pool, June 3 from 6:30 p.m.-10:30 p.m.

And, for some good eating, join SCORA members June 17 for a Shrimp & Crawfish Boil at Rotary Pavillion.

## CLASSIFIED

**FOR SALE:** Hill country house on Lake L.B.J. Beautiful 3 bdrm, 2-1/2 baths oversized 2-car garage (25'x25') brick. Concrete dock, sprinkler system, newly decorated, basement. Contact J.F. LIEDER, 915/388-3331.



Editor's Note: DPMC supports these initiatives: Responsible Care, through the Chemical Manufacturer's Association, is a continuing effort to improve the industry's responsible management of chemicals; STEP, through the American Petroleum Institute, addresses public concerns by improving our industry's environmental health and safety performance.

WE HAVE A COMMON GOAL TO KEEP PEOPLE FROM GETTING HURT.

## SHELLEGRAM

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