

# Shellgram

AUGUST 1993

DEER PARK MANUFACTURING COMPLEX

Shell thanks Texas for swift action

## DPMC breaks ground for upgrade

Shell took the opportunity to mark the beginning of construction on the major upgrade project of Deer Park Refining Limited Partnership (DPRLP) by holding an official ground-breaking July 8. DPRLP is the joint venture Shell entered into earlier this year with Pemex.

Among those who took part in the ceremonies were Texas Governor ANN RICHARDS, Shell Oil Company President and CEO PHIL CARROLL; and Pemex Director General FRANCISCO ROJAS; with Complex Manager STEVE REEVES as host. Each guest turned a symbolic spadeful of soil at the gathering of a large group of Shell, Pemex and contractor personnel as well as community and government officials.

Governor Richards told the group, "This project is good for the citizens of Texas as well as for the joint venture partners. The economy will be helped by the creation of new jobs for Texans and by the significant new capital investments. This partnership symbolizes the kind of economic initiative that the North American Free Trade Agreement could encourage, which Shell and Pemex management join me in supporting."

In his remarks Carroll stated, "This venture is a significant and innovative under-



TURNING DIRT—(From left) Pemex Director General Francisco Rojas, Texas Governor Ann Richards, Tamaulipas Mexico Governor Manuel Cavazos Lerma, and Shell Oil Company President and CEO Phil Carroll dig in as part of ground-breaking ceremonies for the major upgrade.

taking for Shell and, I believe, for our partner—a true 'win-win' situation for both of us. The improvements in operating efficiency and flexibility will strengthen the long-term competitive viability of the Deer Park refinery, and contribute to the improved economic performance of our company."

Carroll also expressed Shell's compliments to Governor Richards for the diligence and expertise of the Texas Air Control Board

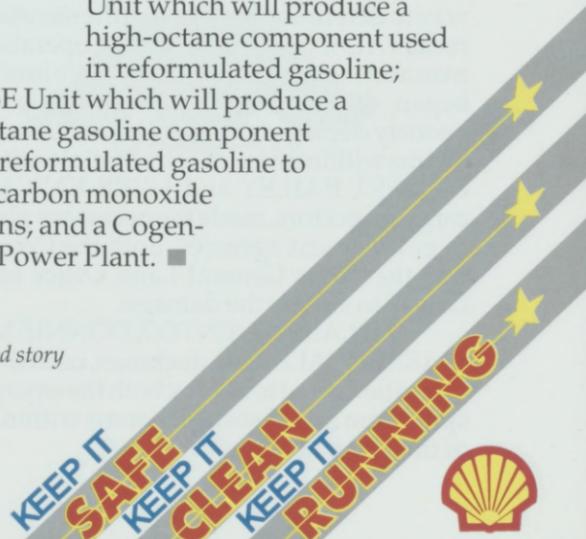
staff in processing the permit applications for the project. He said that communications and cooperation between the parties involved in the permit approval process may well become a benchmark for future negotiations between industry and state permitting agencies.

Rojas said, "The beginning of construction marks another significant milestone in the process of Pemex becoming a more competitive, outward-looking company. Our partnership with Shell complements our restructuring efforts as we further internationalize our business focus. It offers a secure outlet for processing additional Mayan crude, and provides an economic source of unleaded gasoline for Mexico."

The \$1 billion upgrade includes a Delayed Coker, which will enable DPRLP to convert petroleum into higher quality, higher value jet fuel, diesel and gasoline; hydrotreater and sulfur recovery units; an Alkylation Unit which will produce a high-octane component used in reformulated gasoline;

an MTBE Unit which will produce a high-octane gasoline component used in reformulated gasoline to reduce carbon monoxide emissions; and a Cogeneration Power Plant. ■

(See related story on page 3)



## Truck's vibration can mean trouble

by Henry Norris, Control Systems

Once upon a time, I worked for a ship building company. Occasionally I used the company truck to pick up parts. One particular trip proved enlightening for this rambunctious 19-year-old scholar.

I was in a hurry and did not consider the increasing vibration in the truck to be important enough to examine the cause. After all, this truck was the responsibility of the mechanic, not an electrical apprentice. Lo and behold, suddenly I saw my front tire pass my truck, increasing in speed as it rolled into a gas station, jump up into the air, hit a new car, and land only a few feet from a stunned woman fueling her car and from several gas pumps.

As for me, I was having a new experience fighting the truck for control and keeping it from sliding into oncoming traffic.

Things did turn out OK. Besides extreme embarrassment and some fast talking to the boss, all ended well. The story's moral: Stay calm when rushed; ensure that everything is in order. Safety is your responsibility.

That particular day I felt accountable for potentially taking several lives including my own. Don't let this type of error happen to you. You may not be so fortunate.

*Editor's Note: This story was selected from the Family S.A.F.E. Team Safety Storybook files listed on RMDS. Consult RMDS to read or input your own story.*

## Family S.A.F.E. Team Slogan Contest Safety grows; it's the whole picture



John Daniels, East Fuels/Electrical, and family came up with "Safety is not a frame of mind, it's the whole picture." (l-r) Leslie, Katie, John, Naomi.



Zachary Poe, Solvents Distribution E., and family say "Spring safety on your family and let it grow all year 'round." (back, l-r) Muliana, Alonzo, Robert, Kawaina (front) Zachary, Donna, and Crystal.

## Hurricane reminder



Kara Kennedy, Health & Safety, addresses area emergency response professionals at a Hurricane Preparedness Workshop held at South Shore Harbour in June. According to predictions from the Weather Research Service Center, our area has a 50 percent chance of being the target of at least a Category 3 hurricane (extensive winds of 111 - 130 m.p.h.). The most likely month: September.

## Shell East Dock controls spill, gets kudos

On May 25, a barge loading #6 fuel oil (an industry fuel used for fueling ships and tankers) at the Shell East Dock developed a leak on the starboard side. RAY HALLIBURTON, the dockman on duty, immediately began notification procedures. The entire dock staff went into action.

"The leak was under water so there was no way to determine how severe the situation was," recalls ALAN BROWN, Marine operations foreman and incident commander. "We immediately began discharging the barge while simultaneously deploying the spill boom and absorbent booms within minutes of the initial notification." GILBERT BAILEY and HERB KNIGHTSTEP, cargo inspectors, made the necessary phone calls to government agencies. Both the Coast Guard and the Texas General Land Office arrived at DPMC to survey the damage.

ROLAND BUENTEJO, DONNIE McNABB and SAM WALLACE, dockmen, used the Marine Operations boat to deploy both the emergency oil spill boom and absorbent booms within minutes of the initial notification.



DOCKED--Dock employees and representatives from other companies ship channel.

"Their quick action contained the entire spill to the area immediately around the East Dock," says Brown.

JAN KOPERNICKI, Marine manager, Head Office, called to congratulate the Complex on the quick response. According to Brown, the Coast Guard gave him very positive

comments about Shell's response speed, remarking that they were faster than competitors, and that this must be satisfying in light of the new federal law that goes into effect in August.

The Oil Pollution Act of 1990, federal legislation that went into effect on August 17, mandates that oil facilities have workable spill response plans. The State of Texas also requires spill plans in accordance with the Oil Spill Prevention and Response Act. These regulations came after the disastrous Exxon Valdez spill in Prince William Sound. The incident was not the only one on which the docks personnel made a positive impact. The crews have also mitigated the damage of three other vessel-caused spills earlier this year.

"Of the 17 spills at the docks since January 1991, not one of the spills was caused by Shell equipment or personnel," adds Brown. "This is a credit to training and the philosophy of docks personnel concerning oil spill response. We congratulate them for a history of jobs well done."

# Kids Safety Calendar Contest winners are in



Just a winner's hug!

Hundreds of young artists once again set their sights for the winners list in the 1994 Kids Safety Calendar Contest. This year a total of 680 entries were judged. Eight in each of five age categories were selected calendar winners.

The contest team consisted of members from the Awareness SAFE Team and Family SAFE Team. Judges were representatives from Young Audiences and the *Deer Park Broadcaster*, and Dennis Winkler, Community Relations.

All children received Dino beach towels and winners received \$50 American Express gift cheques.

## 5-and-under winners:

Winner	Age	Sponsor
Hilary Rabago	21 mo.	Joe Rabago
Anthony Collier	3	Karen Collier
Darian Williams	3	Vincent Williams
Shane Doughman	5	Troy Doughman

## 6-7-year-old winners:

Winner	Age	Sponsor
Crystal Malkie	6	Earl Malkie
Stephen McCranie	6	Renee Schoenbom
Lori Schubert	6	J.L. Schubert
Kelly Wilson	6	Steve Wilson
Robert Acuna	7	Barbara Acuna
Stevie Hester	7	Sterling Curlee
Lacey Quade	7	Karl Quade
Nickolus Reasoner	7	Vic Ashe

## 8-9-year-old winners:

Winner	Age	Sponsor
Drew Curlee	8	Sterling Curlee
Jaleen Daniel	8	Ronald Daniel
Caitlin Nichols	8	Jim Nichols
John Tristan	8	John Tristan
Steven Williams	8	Vincent Williams
Victoria Hayes	8	T.J. Hayes
Carolyn Holden	9	John Holden
Stephanie Westbrook	9	Kim Westbrook

## 10-11-year-old winners:

Winner	Age	Sponsor
Scott Berens	10	Mark Berens
Scott Cochran	10	Walt Griffith
Brittany Skillern	10	Rick Skillern
Sara Cayton	11	Mike Cayton
Andrea Horace	11	John Horace
Sean Nestor	11	Mike Nestor
Stephen Pehl	11	Donald Pehl
Vincent Hayes	11	T.J. Hayes

## 12-13-year-old winners:

Winner	Age	Sponsor
Lori Hood	12	David Hood
James Robert Kennedy	12	Bill Kennedy
Christopher Pehl	12	Donald Pehl
Dustin Cochran	13	Walt Griffith
Melissa Gomez	13	Adolfo Gomez
Carleigh Hallum	13	Wallace Hallum
Thomas Trevino	13	Tommy Trevino
Jonda Wilkerson	13	Raymond Wilkerson

## 14-15-year-old winners:

Winner	Age	Sponsor
Dustin Lancaster	14	Sterling Curlee
Leia Novosad	14	Ronald Novosad
Michael Campbell	15	W.M. Campbell
Patty Corron	15	Mike Corron
Heidi Huebner	15	John H. Locke
Christina Hummel	15	John Hummel
Rick Marron	15	Bebe Mora
Ryan Young	15	Harry Young

## SCORANOTES

### Glenbrook Scramble winners

Winners of the Glenbrook Scramble were: 1st Place: BRENDA and DANNY WHITE, with a score of 66; 2nd Place: BOB and MIKE TUCKER, 68; Closest to the Pin: BILLY GREEN; and Longest Putt: RANDY WESTMORELAND, 44-1/2 footer. The next tournament is scheduled for August 28 at Clear Lake Golf Course. Flighted format. ■

## CLASSIFIEDS

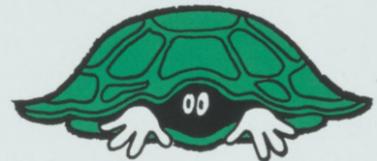
FOR SALE: 17 ft. Laffitte Open Sport, Fiberglass V-bottom, great for fishing, skiing or what ever. '74 Johnson 50 HP outboard, runs great. Heavy duty galvanized trailer, always garage kept. Asking \$1,600. Contact GENE BOURGEOIS, 487-2596 (home) or 246-6549 (work).

FOR SALE: Cape Royale, Livingston. 2-1 patio home. Furnished. Available now. Golf. \$34,000. Owner financed. Contact JOHNNY MATTESON, 479-1450 or 409/653-4269.

FOR SALE: Four cemetery plots, Section C of Grandview Memorial Park, Pasadena. \$1,000 total. L.H. (LES) REEVES, 3804 Maid Marian, Nacogdoches, TX 75961.

To place a classified ad, prepare a brief message indicating that you have something for sale, rent, want to buy, etc.. Include details, price (if desired), your name and a number at which you can be reached. PROFS to AM123 or send to *Shellegram*, North Admin. Room 238. ■

**WHO'S  
THE  
WISE  
GUY?**



KEEP IT  
**SAFE**  
KEEP IT  
**CLEAN**  
KEEP IT  
**RUNNING**



# Behind the scenes of the groundbreaking



ADDRESS—Governor Richards addresses area dignitaries prior to the ground-breaking ceremony.



(Top photo) MEDIA—Shell President and CEO Phil Carroll talks to the news media  
(Bottom photo) MINGLING—Governor Ann Richards and Shell's Phil Carroll

Community leaders at the July 8 Shell-Pemex ground-breaking ceremonies listened as the governor of Texas spoke from a large tent, watched as spades turned up dirt at the coker site, and enjoyed a light buffet and an opportunity to mingle with guests. What appeared as a modest event for Shell guests to celebrate the start of construction on a \$1 billion refinery upgrade actually took weeks of planning and cooperation.

Where should the tent be set up? For safety considerations, should the tent have flooring? How could the ceremonies be arranged without interrupting normal work activities? How should traffic be routed to allow guests easy, safe access?

These and countless other details were attended to by Major Projects, Refinery Engineering and Maintenance, Community Relations, Business Services, Security, and Customer Services.

addressed? Should she arrange for an interpreter? What should be on the name tags? What kind of shovels should be used?

Contingency plans were created for inclement weather. The flower bed in front of South Cafeteria would serve as the ground-breaking site should it be necessary. Potted flowers were prepped and ready so they could be easily lifted out to make room for the shovels.

JUAN JONES, Major Projects, organized the arrangement of a safe, accessible site that would have minimum impact on project construction and general work activity.

"We wanted to show the project and the Complex in the best possible light, one which was appropriate for the distinguished guests," says Jones, a project engineer.

A ground-breaking site was chosen away from current construction efforts yet still in an area which would be used for coker project considerations.

**We wanted to show the project and the Complex in the best light possible, one which was appropriate for the distinguished guests.**

"There are so many details in an event this size that it's very easy to let some little something slip," says DEE LOWERY, Community Relations, who spent long days, and sometimes nights, making sure everything down to the color of name tags was just right.

"Nothing slipped, and I attribute that to teamwork. Everyone was so willing to help and they were so professional even when the pressure was on as the day got closer," she says.

Lowery made sure Shell followed official protocol, keeping the telephone lines to local, state and international protocol offices buzzing. How should Governor ANN RICHARDS, Pemex Director General FRANCISCO ROJAS and Shell President and CEO PHIL CARROLL be seated on stage? How should they be

"We moved some site preparation activities forward to accommodate the ground-breaking," Jones says. "Area access and drainage were prepared according to future major upgrade plans. Few changes should be necessary after groundbreaking."

Jones coordinated the shuffling of project activities such as lunch and safety meetings so that no work activities were taking place close to the ceremony.

He took advantage of the rehearsal to test the tent and air conditioning. He and other planners realized then that 100 tons, not 30 tons, of air conditioning would be needed to cool the tent.

"Coordination was the key to having the area ready the day before the event so that it could go smoothly," says Jones. "And it did." ■

# A tale of two turnarounds

## IRU

**F**or its first major turnaround since start-up in 1990, the Isoprene Recovery Unit (IRU) TA planning team performed in superior fashion and in record time.

The core planning team was challenged with an aggressive charter: to minimize decontamination time and environmental impact, minimize the impact of polymer build-up in column cleaning and meet a very aggressive turnaround schedule, according to RUSS RHODES, operations manager, Heavy Olefins. They accomplished the decontamination effort with a very effective chemical cleaning process.

"We got the columns ready for entry in three days less than our 1991 cleaning and they were very clean," says Rhodes. "Plus, we didn't get acetonitrile (ACN) in the flare so we had no pluming of the OP III flare on shutdown or start-up," a condition that Rhodes says causes permit violations, since no unit is allowed visible emissions for more than five minutes.

Contributing to the start-up success was the influx of ideas from operators, engineers and foremen who offered ideas which were pursued and implemented quickly, according to Rhodes.

These ideas resulted in a start-up of three days, a best ever for IRU. The previous best had been five days. "Maintenance execution was also a highlight," he adds. "From my perspective, as a customer of Turnaround Planning, this was the best of the six major turnarounds I've been involved with from a planning standpoint. People were utilized better than I've ever seen before."

Core team members were: TONY MENDOZA, MICHELLE CLARY and TUAN NGUGEN.



## PHENOL

**"I**n all categories we met or exceeded our goals," says MIKE LEAVERTON, operations manager, Phenol/Acetone. "It was the best Phenol turnaround yet."

"The high focus was on safety," says Leaverton. "We had a number of daily audits, tailgate sessions in areas where risk was more likely, and training sessions with each craftsman about the hazards of phenol and other chemicals." Significant improvements from a planning aspect enabled the turnaround team to perform quicker with less reworks, and to come under budget by over \$800,000, according to Leaverton.

Decontamination posed a major constraint. The team made use of some innovative ideas that cut down time and presented cleaner equipment on which to perform maintenance.

The TA team completely revised blind list drawings to make them more user friendly, which allowed for safer and more efficient installation and removal.

Two critical path jobs—large scope vessel repairs—were completed early or very near to the plan, allowing Phenol to come in ahead of schedule by a day for the total turnaround. Over \$4 million were spent to upgrade the facilities.



CUT-UP--High-powered hydraulic shears cut up tubes pulled out of a furnace as part of the demolition of DU-3. The tubes once carried crude through the furnace, heating it in the process.

## Modifications, dismantling at units make way for Maya crude processing

Work is proceeding on the modification of Distilling Unit #2, Vacuum Flasher #3 and Hydrodesulfurization Unit #2 to enable the processing of 156,000 barrels per day of Maya crude oil. The project is part of the major upgrade announced after the formation of Deer Park Refining Limited Partnership (DPRLP), a joint venture between Shell Oil Company and Pemex. The use of Maya crude oil from Mexico, a 22 API gravity crude (a measure of the density of crude oil) will increase production of the heaviest component of the crude while producing less of the lighter distillate products.

The major changes within DU-2 resulting from the modifications are the addition of more heat exchange surface area to transfer heat from products back to crude oil, and increased crude oil pump horsepower to pump the heavier crude through the unit, according to KEITH REINHARDT, process support, Major Projects, who is providing field process engineering support from MPO to the DU-2 project. New crude oil desalters will be installed and modifications to the HDU-2 naphtha fractionation train will be made to supply the required heat for product distillation.

Another major portion of the project is the demolition of Distillation Unit #3, which has been shut down for a number of years. This unit is being removed to provide plot space for a new marine fuel oil blending system which will replace the current system at Dubbs 9. The new blender will be utilized to blend Maya pitch to marine fuel oil during Delayed Coker shutdowns, thereby preventing a total shutdown of DU-2.

The cleared space will also be used for the new crude oil desalters and other pieces of equipment supporting the operation of DU-2.

Activities related to the demolition of DU-3 began in late May of this year. Completion of the total demolition is expected by the end of this year.

Equipment installation in the cleared DU-3 site is expected to begin during the first quarter of 1994. Construction efforts within DU-2 itself, which will be limited to those items which can be safely accomplished with the unit in operation, is expected to begin during mid-1994. Construction will be finalized during the first quarter of 1995, when DU-2 will shut down for scheduled maintenance. Final piping modifications and equipment tie-ins will occur during this time.

"The DU-2 Revamp Project is an important element of the Major Project effort to improve the future viability of the DPRLP," says JOHN GRIFFITHS, operations manager, West Operations. "Demolition of DU-3 and construction activities at DU-2, HDU-2 and VF-3 is a challenging effort. Close cooperation will be required between Distilling and MPO to insure project activities are accomplished safely and without impairing our ongoing operation. Two members of our Distilling group, SCOTT WILLIS and ALAN MEYER, are working with MPO on this Project."

"Distilling Operations looks forward to this opportunity to improve the economic performance of the partnership," says SCOTT WILLIS, MPO Operations Support. "We look forward to completing this challenging effort, which is an important part of the overall effort to improve the partnership refinery economics." ■



# MILESTONES

## Service Anniversaries

### 25 YEARS

M.C. ARCOS, JR.  
Logistics N. Env.  
H.B. CANTU  
Olefins Maint.  
V.M. CARBAJAL  
Control Systems  
M.F. CEGIELSKI  
Lube Logistics  
G.C. CONARD  
Solv. Distrib.  
W.L. GOBER  
Central Maint.  
L.D. JACKSON  
Project Engrg.  
J.J. MOORE  
Central Maint.  
O. REEVES  
Employee Dev.  
J.C. THOMPSON  
Central Maint.

### 20 YEARS

H.M. HARGIS  
Business Services



B.E. McELROY  
Utilities Prod.  
(above, June)

### 15 YEARS

D.E. HAMALA  
Resin Maint.  
M.R. WILLIAMS  
Business Services  
M.M. KNIGHT  
Resins  
S.D. MATZA  
QA Process Chem.

G.A. STRENK  
BPA4  
J.P. WENTWORTH  
Eng. Proj. & Svcs.

### DPMC WELCOMES

B.C. DILLEY  
Human Resources  
T.E. DOUGHMAN  
Business Services  
C. GEORGIADIS  
Human Resources  
D.W. HARM  
Major Projects  
A.L. HENTGES  
Chem. Eng./Mts.  
P.V. MALONE  
PE/CS/QA  
M.Q. QUNITANAR  
Major Projects  
R.M. STANFIELD  
E. Operations  
K.K. TIXIER  
Business Services

### RETIREMENTS

D.H. KILMER  
E&S



BARREL OF CLOTHES—SERVE volunteers Garth Williams, BPA4 and Bee Fones, Lube Logistics, help sort apparel collected as part of the July Shareable Wearable clothing drive.

## Jitney service changes

Recent changes to the jitney service should make service more cost effective and responsive to customer needs, according to CORT MICHENER, Facility Management.

The North/South jitney route has been eliminated and the two remaining jitneys have discontinued their previously scheduled routes. They now provide service on an "on call" basis between 8 a.m. and 5 p.m.

Individuals requesting service must dial 9 for an outside line and then dial 238-9900. The call will ring to both jitneys, with the drivers coordinating the call to insure the best response time. Callers should tell the jitney operator where he or she needs to be picked up and their destination. Drivers will give callers an estimated time of arrival at the pick-up location.

For those using morning jitney service to reach their work location, two jitneys operate from 6:30 a.m. to 8 a.m., one from the North Main Gate and one from the South Main Gate, delivering passengers on a non-scheduled, as-needed basis. For after work service from a location to the main gates, simply call the jitney number and request service.

"The jitney is not intended to be used for picking up and returning personnel to parking lots," says Michener. "Jitney service will be provided to in-plant locations only, with the exception of Medical."

For jitney service questions call GENE BOURGEOIS at X6549.

## Make plans for Ten & Over Party

The Ten & Over Party is set for Saturday, Sept. 25, at the John Ray Harrison Convention Center in Pasadena. The party is open to active employees and retirees with 10 or more years of DPMC service.



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Alayne Merenstein



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