

SHELL LETTERGRAM

SHELL DEER PARK

At 50 percent completion, the HVI Lube Crude Optimization Project has been a model of safety and uniqueness in its construction and technology. When complete next year, it should offer the Shell Deer Park Refinery an exemplary performance record, an imposing structure, and the flexibility of running a variety of lube crudes of higher sulfur levels.

Operating quietly and diligently under the shadow of the Maya Project, HVI will soon be visible on the Shell Deer Park industrial landscape. The Lubricants project's vacuum fractionation column, VFC—the centerpiece of the project—should be complete by late October. The total project is scheduled to be complete by June, 1996.

The driving force behind HVI is the limited supply and resulting high cost of the East Texas crude, the source of Shell Deer Park's lube crude for the past 50 years, according to NEIL LANDER, operations team leader, Shell Deer Park.

The new unit is designed to run four crudes ranging from light to medium and varying in sulfur content and in the amount of residuals that they make. This project incentive comes from DPR's ability to process these relatively lower cost crudes while making base stocks of improved quality over the current ones produced.

The crudes will arrive by ship, be off-loaded and pumped to eight new lube crude tanks, and from there travel to DU-I, which will produce a "long residue" stream that will be the feed for the HVI VFC. The VFC, in turn, will make similar distillate cuts as the existing HVI VFC does today.

On the construction front, HVI's nearly 200-foot tall vacuum column is being fabricated on site, one of many unique aspects of the project. On completion, the column will be among the tallest structures at the Refinery.

Also unique is that the column sits on an elevated concrete pedestal higher than most at Shell Deer Park—some 60 feet in height; the use of structured packing, as opposed to trays, which will allow the unit to run at severe vacuum; and a distribute design called Schoepentoeter (pronounced "Shoe-pin-tooter"), a Shell proprietary vehicle used to disperse the partially vaporized feed stream.

The HVI project is also modeling the facilities utilizing 3-D CAD with walk-through hardware and software to better understand operability, maintenance and construction issues. This replaces the normal

HIGH PERFORMANCE TEAM STRIVES FOR EXCELLENCE

plastic model review. It is being further looked at to facilitate the training of operators and maintenance crews.

"We've made a diligent effort to recognize any need for changes in the design phase of the project so when we get in the field, we can reduce any changes where they are much more expensive to accomplish," says JOE SPILLER, Construction Assurance team leader.

"The objective is to reduce construction rework as well as provide a facility that is maintainable," says MARSHALL CHALBERG, site manager of CBI-Nacon.

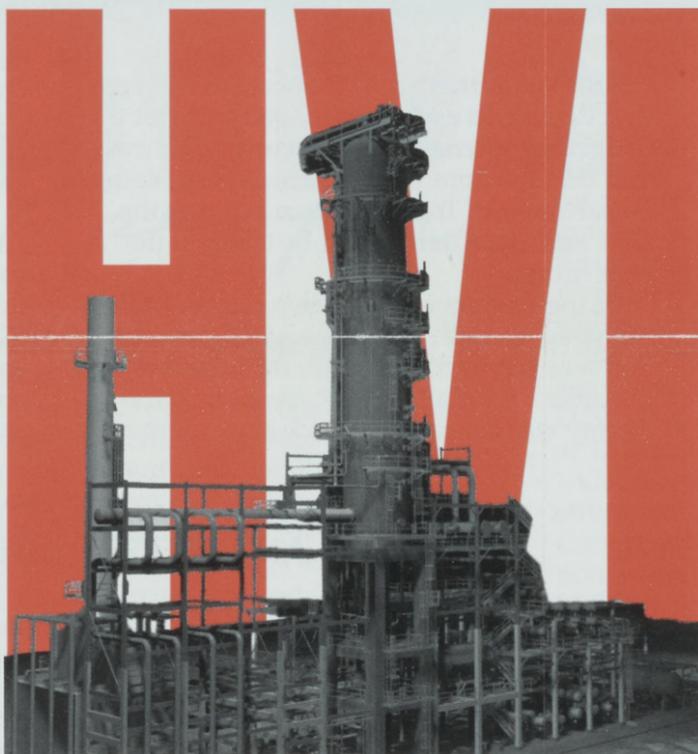
"Another uniqueness has been the level of construction and commissioning integration on this project," says DAVE BURDEN, Shell Project Engineer for HVI. "It's one of the Head Office/Engineering/Construction goals to compress the time between mechanical completion of our facility and when we're able to start up. We have an excellent opportunity to demonstrate the necessary integration with this project."

CBI and S&B contractors are working together with Shell to satisfy a project mission to have mechanical completion by June 7, 1996 and a seven-day start up with a total cost below budget, besides a no-OSHA and no-environmental exceedance record.

S&B started construction in January, 1995, expending about 122,500 work hours to-date with a force of 160 people (220 at peak construction).

"We've done that with no recordables or Lost Time Accidents and only three first aid cases since that time," says DARELL DICKENS, S&B construction manager. "We have an exceptional safety program. We reached a milestone June 22 of 100,000 work hours without an LTA or recordable."

The contractors encourage excellence in construction and safety through their incentive programs. One of them, called Boundary Busters, offers awards for innovative and measurable work that fall outside the norm. Three individuals each quarter are awarded with a dinner, plaque and other recognition. HVI Lubes management feels that recognition programs like Boundary Busters will help them achieve their project mission. ■



CAD drawing HVI Unit serves as walk through in training. The project is scheduled for completion next summer.

NEW FACILITY OFFERS LUBE CRUDE VARIETY



Safety

PERSISTANCE PAYS OFF

IN HIGHWAY SAFETY ISSUE

If you are entering the intersection of Highway 225 and Center Street, there's no question where you need to be to turn left or go straight. It wasn't always that way. You can thank TERESA MILLS, Distribution/ Customer Services for the improvement.

Mills was concerned that the lack of road striping might cause a major accident should a vehicle in the left lane try to go straight at the same time a vehicle in the center lane should try to turn left.

Mills submitted an APR (Accident Prevention Report) in early March, pointing out the dangerous intersection to Security. She was told that the item was reported to the State Department of Transportation but that the state said no action would be taken in the near future.

Taking matters into her own hands, Mills followed up with the Highway Department and was put in contact with the engineer responsible for fixing that intersection. A traffic survey was conducted which showed there

was sufficient traffic to have new graphics and stripes applied on that section of highway.

On July 26 restriping crews finished the work, making it safe for all vehicles.

"It's nice to see people take ownership for situations and try to make things happen, especially when it relates to safety," comments ANDY KING, manager, Distribution/ Customer Service. "Through Teresa's efforts, persistence and repeated dialogue with the engineer, this intersection is a much safer place for all of us." ■



Is it true about walking and weight loss?

by Kara Kennedy and Martin Vasquez, SWIFT Team

Three universal goals most of us share are to live longer, live free of illness and control our weight. Interesting enough, normal walking lets us achieve all three.

In fact, walking may be man's medicine for slowing the aging process. How? First, it works almost every muscle in the body, improving circulation to the joints and massaging blood vessels. Walking also helps us maintain both our muscle mass and metabolism as we age. It also keeps us young in spirit. For anyone out-of-shape or unathletically inclined, walking is the no-stress, no-sweat answer to lifelong conditioning.

MYTHS AND FACTS ABOUT WALKING AND WEIGHT LOSS

MYTH 1: No pain, no gain. If the exercise doesn't hurt, it's not beneficial.

FACT 1: Walking is no pain, all gain. Walking is one of the best exercises for strengthening bones, controlling weight, toning leg muscles, maintaining good posture, and improving positive self-concept.

MYTH 2: Dieting alone will let you lose weight. There's no need to exercise to shed fat.

FACT 2: People who diet without exercising often get fatter with time. Although your weight may initially drop while dieting, such weight loss consists mostly of water and muscle. When the weight returns, it comes back as fat. To avoid getting fatter over time, increase your metabolism by exercising daily.

MYTH 3: To benefit, you must walk 45 to 60 consecutive minutes. 5 or 10 minute walks are worthless.

FACT 3: Everything counts. Leaving your desk for a five-minute walk can reduce your body fat by two pounds annually. Every time you walk—even if only for a minute—your metabolism increases. ■

* Myths and facts source: "Myths & Facts on Walking & Weight Loss." Creative Walking, Inc.

This article is brought to you by SWIFT, the Shell Wellness Improvement and Fitness Team. The team's mission is to improve employee awareness of health and wellness issues by providing activities, information and resources to encourage better fitness, nutrition and general health. SWIFT welcomes any comments or questions. Contact MELISSA SMITH, S/ADM 133, PROFS N/N MNM9.

Pipeline Hydraulic Study Team makes direct-to-pipeline breakthrough

The Pipeline Hydraulic Study Team has set the stage for potentially great inventory reductions, tank maintenance cost savings and improved operations with direct-to-pipeline blending.

The team gathered early in June to determine whether the hydraulics and instrumentation aspects of the system were suitable for a direct-to-pipeline blend. The goal was to have a test blend by the end of June. By the team's third meeting, they concluded that the direct blend would work and were ready to put their theories to the test.

The right BLEND of people

"We had to build some inventory ahead of the blender because we wanted to make a big blend," explains WES POLING, Planning & Economics. "So we scheduled a 125,000 barrel tender of RU to the Collex Terminal. Working with Products Supply, we set it up to start at 7 a.m. June 29 so we could have all the right people in place."

"After letting the piping and the hydraulics stabilize, Shell Pipe Line's Control Center downtown started Sinco Station #3," relates ANDY VECSEY of Shell Pipe Line. "We went down on low suction pressure a few times and determined that since Sinco Station #3 is the larger of the two existing units, we would bring up Sinco Station #2. We were then able to stay on line for 1-1/2 hours, sustaining delivery rates of approximately 5,300 barrels per hour."

The team's objective was to demonstrate the capability to deliver at least 5,700 barrels per hour, so they were short on their target.

Sinco Station was placed on manual control to boost the rates, "but that resulted in losing Sinco Station on either low suction or high case pressure," continued Vecsey.

Later that afternoon, the team regrouped with the appropriate personnel in place and modified some systems on the blender computer.

"This allowed us to deliver higher discharge pressures and let both Sinco units stay on-line," explains JOHN CORNELISEN, Control

Systems/Processing Engineering. "The remaining barrels of the batch were finished at 6,700 barrels per hour."

"So we proved that not only can we meet, but we can exceed the target rate by 1,000 barrels an hour," adds Vecsey.

"We met Wes's target on the pipeline," says Cornelisen, "We were afraid we were going to have to cut the gasoline tender short. So the additional effort to prove our capabilities actually proved to be worthwhile."

Where does the team go from here

and what's to become of direct blending?

The team expects to blend direct as often as possible, perhaps once or twice a month and possibly as much as 40 percent of their tenders, according to Cornelisen, but for now they'll turn over their findings to Operations, let them develop procedures and then wait for Head Office scheduling to give them the go.

By year's end the team expects they'll drop down by five tanks, a considerable inventory reduction that will result in less maintenance costs and a sizable cash income.

"I've been here long enough to see two of these attempts made before, unsuccessfully," adds Poling. "The only reason it was a success this time, as far as I'm concerned, is that we took the time to get the right people involved—from Shell Pipe Line, Engineering, Control Systems, and Mechanical Equipment. I made the recipe and told them what I needed and they did it."

"No capital or operating costs changed as a result of this modification," says ALAN MCINTYRE, Process Engineering. "So it was an opportunity right in front of us for all those years. Like Wes said, it just took the right people and the right time."

Pipeline Hydraulic Study Team members were: JOHN CORNELISEN, WES POLING, ALAN MCINTYRE, ANDY VECSEY, WILLIE BRAGGS, Gasoline Systems foreman; and RICH HULL, Mechanical Equipment. ■

DISTRIBUTION/CUSTOMER SERVICE

ATTACKS "COMMUNITY PARTNERING"

GOAL AT FULL SPEED

When the idea of "community partnering" was presented to the folks in Distribution/Customer Service, they didn't walk, they ran with it. Today more than 85 percent of the department is involved in helping those in their community that need help, and there's no end in sight.

To fulfill the community segment of Shell's Mission, Vision and Values goal, D/CS has been doing yard work, collecting toys, making home visitations, and even sorting clothes at a local shelter. They expected the hard work, but were taken by surprise at the deep feeling of satisfaction they experienced helping those less fortunate.

After mowing and weeding at the home of a La Porte senior citizen, the volunteer group got so attached that they adopted the Evans family. Every other week they and others from the Railroad group come back to keep Mrs. Evans' lawn looking good. TERESA MILLS comes more frequently to visit the elderly woman. She lives alone. Her husband has just been moved to a nursing home. Teresa helps her with some of the things she can't do herself, and occasionally just drops by with some ice cream.

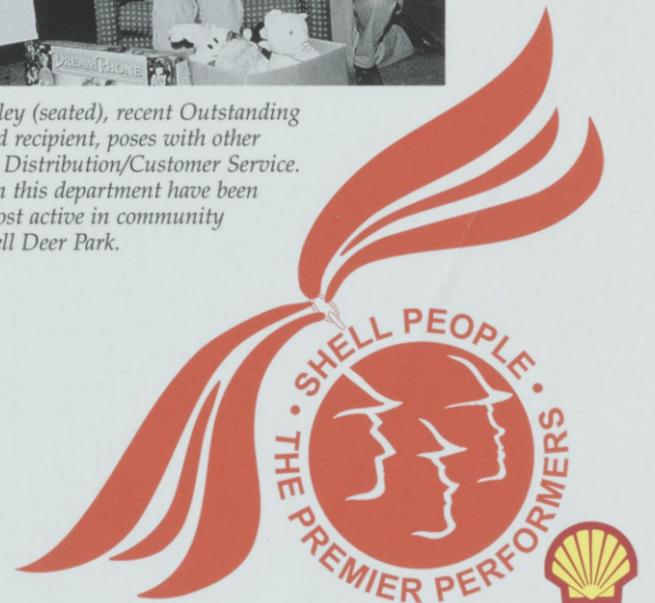
For those who prefer not to be exposed to the hot weather, "The Bridge Over Troubled Waters," an area resale shop, offers a chance to sort and hang clothes for a couple hours once a month. A Fall project is going to be a food drive for Thanksgiving baskets. (Food and toys can be dropped off in RDO 118.) Also planned is participation in Walktoberfest, a six-mile walk in October for the American Diabetes Association.

To contribute time or materials in these and other activities, view the volunteer bulletin board in the D/CS Department or contact Teresa Mills via PROFS at TAM3.

Good deeds don't go unnoticed. The best volunteer efforts are recognized with a quarterly Outstanding Community Partner Award, and some special recognition awards plus a traveling trophy. BARBARA STANLEY was the first recipient of the Outstanding Partner award and traveling trophy. Teresa Mills also received special recognition. ■



Barbara Stanley (seated), recent Outstanding Partner award recipient, poses with other volunteers in Distribution/Customer Service. Individuals in this department have been among the most active in community service at Shell Deer Park.



MILESTONES

SERVICE ANNIVERSARIES

25 YEARS

I.J. ALVAREZ
Ref/W Log./Util./Env.



J.M. BUSH
Ref/Central Maintenance
(above, July)

S.L. DARDEN
Chem/Solv. Dist/Mtce.

T. FERNANDEZ
Ref/W. Log./Util./Env.

D.J. FINE
Chem/Olefins III

W.L. HARBUCK
Major Projects/Coker/HT

D.M. KELLY
Chem/Control Systems

R.N. KELLEY
Chem/Solv./Dist./Cust. Svcs.

J.M. KHALAF
Ref/Lube Logistics

B.R. LEE
Ref/Turnaround Plng.

D.F. LIPSCOMB
N. Admin.

J.J. PALERMO JR.
Business Services

J.E. WISDOM SR.
Chem/Phenol Acetone

15 YEARS

T.W. KEELING
Chem/Central Mtce.

10 YEARS

D.L. KIRSHMAN
Chem/Phenol Acetone

Science teachers learn lessons on chemicals

Forty-eight high school science teachers throughout Texas saw Shell Deer Park and other facilities in the chemical industry up close this past summer in an intensive one-day workshop designed to help them better teach their students about chemicals and the environment.

In the sixth annual workshop "Chemicals and the Environment," science teachers spent one day each at Solvay, Rohm & Haas, Rollins Environmental and Shell Deer Park, learning how a chemical manufacturing facility works, how workers stay safe and prepared for emergencies, and how chemicals impact the community.

The workshop at Shell Deer Park Chemical included a presentation about the facility's emergency preparedness where teachers went into the field for a live fire training demonstration, to the effluent treaters and outfall, and to an emissions monitoring demonstration. They also heard Shell Deer Park experts discuss health, safety and environmental issues. ■



Gary Hart, Environmental, shows high school science teachers a fugitive emissions monitoring device. The teachers spent the day touring the Chemical plant as part of an industrial environmental course.

SCORANOTES

FALL CAMPING

Pack up your gear and head out to Wolf Creek campgrounds. Oct. 13-15

GOLF TOURNEY

On October 21 look for a tournament at Bay Forest in La Porte.

CHRISTMAS DANCE

A Christmas dance will be country this year on Dec. 8 with country western artist "Randy Meadows and the Straight Up Band" at the East Harris County Civic Center on Kyle Chapman Rd off Spencer Highway. Dress is casual. Check the SCORA office for more information.

CHRISTMAS FOR KIDS

Kids, meet Santa at the cafeteria on Dec. 16.

CLASSIFIEDS

FOR SALE: 16' Glastron ski boat, 115 Johnson motor on custom built large wheel trailer, all extras including cover. \$4,000. Contact MELVIN H. MUECHE at 941-1505.

FOR SALE: Lot in Deer Park. 89' x 95'. Large pecan trees. \$17,500. Owner will finance. Contact EARL EBELT at 479-1357.

To place a classified ad, indicate briefly what you have FOR SALE, FOR RENT, WANT TO BUY, etc. and send to Shellegram, ECB 121.

LETTER TO THE EDITOR

A WORD OF THANKS

To all of my friends and co-workers at Shell: My wife Pat and I would like to thank each one of you for your prayers, cards, flowers, phone calls and genuine concern during my recent illness. It's having friends like you that helped us get through a very trying time. Thanks and God bless you all.

J.M. "BULL" DURHAM



Editor's Note: Shell Deer Park 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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