

Shellegram

Deer Park Manufacturing Complex

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A BUSY PLACE TO BE THESE DAYS IS BA/EA

BA/EA stands for butyl alcohol and ethyl alcohol.

BA is the process of starting up after its first shutdown in two years.

EA is the oldest current producing ethanol unit in the United States. It was built in 1948, and process

BA finishing columns reach to the sky on a sunny day.

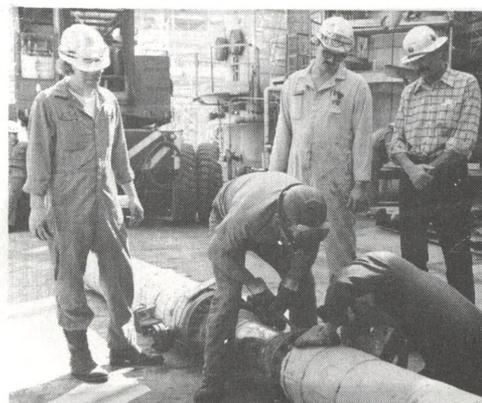
manager Jim Long notes its uniqueness in its interaction with the Bureau of Alcohol, Tobacco and Firearms (ATF).

Why is the federal government interested in the ethanol unit? It's to insure that no ethanol alcohol is used for taxable purposes. Taxable purposes include consumption. Since the tax on ethanol alcohol is \$21 per gallon, they have a large interest in assuring that none of the 40 million gallons produced annually at EA is consumed, or used for taxable purposes.

After all, this same alcohol would sell on the open market for \$1 per gallon plus, of course, the \$21 per gallon government tax.

So, you can understand why the government assigns officers to make certain we don't use it for such purposes. Currently one officer is assigned to the plant. This is a far cry from the 14 government men who worked around the clock to police the unit in 1948. The government still requires one of their men to be present during all transfers of ethanol to ships, tank cars or tank trucks.

However, no government men are required to police the BA unit, which recently underwent a two-week shutdown. BA shutdowns are tied in with Tenneco's as
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EA finishing operator Jerry Stewart takes a sample of 190 proof EA. Marvin Curtis and "Blue" Henshaw go over plans for the BA shutdown. Inspectors Ronnie McMurry and Tommy Sewell join BA operator Sheriff Meriwether in observing the exchanger installation.

A busy place to be these days is BA/EA....

they provide raw material feedstock of synthesis gas (commonly called tail gas), which is used to make butanols for selling to Rohm and Haas and others.

A BA shutdown involves considerable planning and coordination with the maintenance people. The shutdown work list was developed by Fred "Blue" Henshaw, operating assistant. From there a maintenance plan was developed by Marvin Curtis, maintenance supervisor, and Jim Peters, "E" area maintenance foreman.

Planning for the February shutdown began in early December 1975 and continued through January and February with frequent planning meetings. "The key to a successful shutdown is thorough planning and preparation," says Jim Long.

All BA unit operators and shift foremen worked hard to decontaminate the entire unit for the maintenance work to be done. "Blue" developed the decontamination plan and procedure.

"We've been running flat out (or at maximum rates) since January of this year building inventory for the shutdown and will have to run at maximum rates for several months after the shutdown to replenish inventories," says Jim.

The BA expansion startup was completed just prior to the Tenneco shutdown.

The expansion unit utilized idle equipment from the plasticizer alcohol plant and expanded total capacity of butanols by about 30 percent.

This was the first startup of a project constructed under the DPMC Major Projects organization.

The expansion startup team was lead by Jesse A. Whitaker, senior chemist, Shell Dev., and planning began in early November continuing until the startup actually began in late January. Operators and shift foremen were trained in a special school during the first two weeks in December. The school was conducted by the startup team members in the Research conference room located at Chemical.

Part of the distillation system of the expansion was started up in early January with no problems. Major Projects - Construction continued on the expansion reactor unit until late January. The construction was completed on January 26 and the startup of the reactor system began in earnest.

The Operators and startup

team worked extremely hard and completed checkout of the unit by January 31.

Catalyst building in the reactor system began after completion of checkout, and feed was started to the unit on February 2. Design reaction rates were achieved by February 8 and a startup demonstration run was completed by February 17.

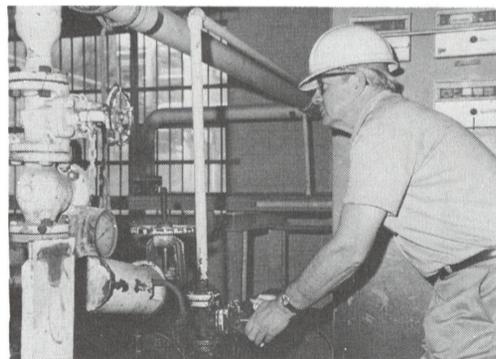
The last four days before the Tenneco shutdown were used to demonstrate approximately 150 percent design feedrate capacity. And, all of this was accomplished two days ahead of the minimum projected time.

"The operators and shift foremen along with the startup team did an excellent job of completing the startup faced with the deadline of the Tenneco shutdown.

The chemical maintenance organization also contributed to the success of the startup," says Jim, "particularly in the instrumentation support."

Plant superintendent Hank Bettencourt summed it up best with, "It was fantastic!"

EA operator prepares to transfer anhydrous EA (meaning dry or without water) to the dock.



BA expansion unit operator Robert Kyle (far left) listens as the start-up team discusses how things are going. l-r are Jerry Walker, "Blue" Henshaw, J. A. Whitaker, L. W. Roberts and Gene Alsandor.



Welder trainee Sam Darden finishes up a weld.



SCORA ELECTS NEW BOARD MEMBERS, ALTERNATES AND OFFICERS



Newly elected SCORA board members include the following employees: Kneeling, Bill Hedrick, Larry Csengery and alternate Frank Saucillo. Standing are Ralph Dewey, Norm Newton, L. B. Burch, Maxine Jones and alternate Randee Rothman. Not present for the picture were board members, Burns Clare and Tom Davis, and alternate Bill Marriott.



1976-77 SCORA officers are John Kindla, treasurer; Maxine Jones, secretary; Robert Taylor, president; and Norm Newton, vice-president.

ALKYLATION OBSERVES SAFE YEAR



Co-workers gathered for Alkylation safety party. Counterclockwise: Homer Benson and his date, Eleanor Jones. Richard and Sharman Corbitt share a laugh with Johnny McLean. Maxine Vallie, Clo Laird, Matthew Vallie and Mauleen Posern line up for their picture. James and Lorine Deaton join E. C. and Carrie Ables for a visit. Both James and E. C. are retirees. All smiles are Daisy and Cliff Brown, retiree Libby Cassner, Ken and Linda Snipes. Another happy group included Wretha and Eddie Barfoot, Earl and Connie Page.



SHELL'S NEWEST FILM RECEIVES AWARD

Shell's newest film, "The Early Americans," will be telecast Thursday, April 1, at 9:30 p.m. over KUHT-TV, channel 3.

The 41-minute film was produced as a sequel to "This Land" - Shell's international award winning film.

"The Early Americans" tells the story of man from his arrival in the New World sometime during the Ice Age to just short of the 15th Century. It portrays early human experiences in America, pre-Columbian history of the Indian peoples, the rise of their cultures and contemporary American research projects in archeology and anthropology.

"The Early Americans" joins the 23 other educational film titles available on free-loan from our Shell Film Library in Indianapolis.

WANT TO BUY, SELL OR TRADE AN ITEM? SEND YOUR AD IN TODAY FOR PUBLISHING IN NEXT WEEK'S SHELEGRAM.

CLASSIFIEDS

FOR SALE

15' 1972 bass boat, 35 hp Chrysler motor, 3 bronze props, other extras, excellent condition. \$1,095. 691-4781

1½-ton Amanda air conditioner. \$100. 1-ton Philco. \$75. 473-0707

1965 Ford V8 pickup, original owner, clean with air. \$650. 473-0707

1972 VW stationwagon, new brake job, good tire, excellent mechanical condition. \$1,095. 674-2891

1973 Honda 750 Four, fully dressed, all extras, 8,000 miles. 473-5741 after 5 pm

C. U. TO HOLD ANNUAL MEETING MARCH 26

The Shell Refinery Employees Federal Credit Union board announces their upcoming annual meeting to be held at the Gaines Mason Auditorium, 201 Ivy in Deer Park on March 26 at 7:30 p.m.

All employees are welcome to attend, but only credit union members and their families will be eligible for the cash door prizes totaling \$2,000.

Remember, the annual meeting is tomorrow night at 7:30 p.m.



"Sir, one of the technicians wants to see you about a possible misprint in a safety manual."

1973 Honda 450 with extras. 473-5741 after 5pm

1972 Mercury Marquis, all extras, 40,000 miles, AM-FM radio. Take up payments of approximately \$1,800. 452-0768

1969 VW bug, needs inspection. \$395. 479-1325

1972 Sundowner Park trailer, 8'x35', air, central heat, full bath, bedroom, kitchen, dining and living area, furnished. Ideal for hunting or fishing site. Sleeps 4. \$2,800. 926-2396

Maternity clothes, size 10-12, about 50 pieces, very nice. \$75. 487-3649 after 4:30 pm

1974 Honda XL100, 3,800 miles, good condition. 455-2040 or 455-8097

1957 GMC pickup, body in fair condition, runs good. \$300. 452-0405

1947 Ford Delux Club Coupe, not running, partially restored. \$400. 471-1444

Sears Kenmore gas dryer, very good condition. 437-5766 after 6 pm

Large mobile home in Nacogdoches, like new, ideal for students or couple. Balance due. 1-512-237-3815 collect

3-piece living room or den set. Custom made, commercial weight nylon, couch and chair in deep rose, large gold chair, stain resistant. \$175. 495-6505

15' Texan glass boat, 35 hp Johnson Electric started, new battery, motor completely overhauled, trailer. \$450. 424-7698

Standard EKO guitar and case. \$25. Tanaka. \$50. 941-0349

1969 Chevy Impala, 350 engine, good tires, new transmission, recent tune-up, runs great, new inspection sticker. \$900. 452-0405

1968 GTO 400 cu in, air, automatic, Rally wheels, vinyl top. \$495. 481-3766

1974 Monte Carlo, p/s, p/b, air, new tires, dark blue, clean. \$3,500. 649-7359

WANTED TO BUY

20-30 bricks for edging flowerbeds. 471-5365 after 5 pm

Youth golf clubs for teenage son, also practice balls. 473-3224

Small puppie, can be a mixed breed, but must be cute. If housebroken, will pay a small price. 477-6742

FOUND

Smokey grey rimmed glasses in the central shops area on 3/18. Claim in SHELLEGRAM office.

Wide, white loop earrings on 3/19. Claim in SHELLEGRAM office.

Several pairs of glasses and sets of keys remain unclaimed in SHELLEGRAM office.

SHELLEGRAM

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Mrs. Dotti West - Editor