

GLUTEN PLANT GROUND BREAKING

JULY 24, 11:00 A.M.

NORTH COPELAND STREET, RUSSELL

PROGRAM WAYNE GRABBE, EMCEE 11:00 - 11:30 A.M.

WELCOME MAYOR NEAL FARMER
SPEAK HARRY CLEBERG (3 MINUTES)
SPEAK SENATOR DOLE (3 MINUTES)
SPEAK FRANK JOY, HAYS, ON BEHALF OF THE 5 PARTICIPATING
 CO-OPS (3 MINUTES)
SPEAK DON HABERER, RUSSELL COUNTY COMMISSION
SPEAK LOREN DINKEL

GROUND BREAKING CEREMONY

OPEN TO THE PRESS & PUBLIC

NOON PROGRAM BUFFET LUNCHEON AT ELKS CLUB

12:45 P.M. PROGRAM BEGINS DON HABERER, EMCEE

INVOCATION FATHER GRENNAN, STOCKTON
SPEAK SENATOR DOLE
SPEAK GARY EVANS, FARMLAND
SPEAKERS FROM EACH OF THE 5 PARTICIPATING CO-OPS
 (ELLSWORTH, WALLACE CO., HAYS, MINNEOLA,
 RUSSELL)
CLOSING LOREN DINKEL

OPEN TO THE PRESS. INVITED GUESTS.

BACKGROUND

0 IF WEATHER PREVENTS THE OUTSIDE CEREMONY, THEY ARE EXPECTED
TO SCHEDULE ALL THE EVENTS AT THE ELKS CLUB. (A GROUP OF
VOLUNTEERS, LEAD BY CAROL DAWSON, IS MOVING TABLES AND
CHAIRS BEFORE AND AFTER THIS EVENT, TO AVOID DISRUPTION OF A
COMMUNITY THEATER PERFORMANCE WHICH IS SCHEDULED FOR BOTH
FRIDAY AND SATURDAY NIGHTS.)

0 THE SUN IS OUT TODAY, FRIDAY, AND WAS OUT YESTERDAY AS WELL.

0 FLOUR MILL - FARMLAND TECHNICAL PEOPLE ADVISED NED WEBB THAT
THIS WOULD BE AN ADDITIONAL COMMERCIAL GRADE PRODUCT THAT
THE PLANT AS PRESENTLY DESIGNED WILL BE CAPABLE OF
PRODUCING, USING THE WHITE WINTER WHEAT WHICH WAS DEVELOPED
AT KANSAS STATE UNIVERSITY. NO ADDITIONAL JOBS OR COST IS
INVOLVED.

DAVE SPEARS IS NOT CERTAIN THAT FARMLAND WANTS TO MENTION
THIS IN PUBLIC AT THIS TIME.

PAGE 2

GLUTEN PROGRAM & BACKGROUND

0 ROGER RESLEY, SON OF RALPH RESLEY OF RUSSELL (RETIRED POSTAL SERVICE. HE WAS IN SCHOOL WITH YOU.), CALLED US ON BEHALF OF HIS FAIRWAY, KANSAS, ENGINEERING FIRM, "CONTROL SYSTEMS INTERNATIONAL," THAT SPECIALIZES IN GRAIN HANDLING. HE'D LIKE TO SECURE THE CONTROLS PORTION AS A SUBCONTRACTOR.

SIMONS, THE GENERAL CONTRACTOR, IS FROM MINNESOTA - A SOURCE OF DISAPPOINTMENT TO THE AREA CONTRACTORS. HE ADDED THAT FARMLAND LIKELY NAMED SIMONS BECAUSE THEY WANTED TO SAVE TIME AND HAVE WORKED WITH SIMONS IN THE PAST ON THE SOUTH DAKOTA PROJECT.

HE ASKED ABOUT OUR ROLE. I ADVISED HIM THAT HE SHOULD CONTINUE TO DEAL DIRECTLY WITH FARMLAND, THAT WE ARE NOT INVOLVED IN FARMLAND DECISIONS, BUT THAT WE WOULD ENCOURAGE USING LOCAL/STATE FIRMS WHEN POSSIBLE.

BAR-B-QUE COOKING SCHOOL

RUSS TOWNSLEY HAS 17 ENROLLED. IF YOU MAKE A STOP-BY, THEY'LL CONFER AN "HONORARY PITMASTER" DEGREE. PRIOR TO THE GROUND BREAKING THEY'LL STILL BE COOKING. AFTER THE LUNCH, THEY'LL BE EATING/SAMPLING/JUDGING.

PARTICIPANTS SPEND THE NIGHT IN CAMPERS ON SITE IN ORDER TO STOKE THE FIRE. A 5-6 POUND BRISKET COOKS FOR 12-18 HOURS AT 210 DEGREES.

ATTENDEES FROM: JOHNSON COUNTY, OSBORNE, GREAT BEND, HAYS, ALVA, GALATIA, MILBERGER, & RUSSELL.

TALKING POINTS

GROUND BREAKING FOR WHEAT GLUTEN PLANT

JULY 24, 1993

RUSSELL, KANSAS

0 THIS CEREMONY TODAY MARKS BOTH A MILESTONE AND A BEGINNING,
AND I'M PROUD OF THE DETERMINED EFFORTS OF SO MANY PEOPLE TO
MAKE THIS A REALITY.

0 WHILE WE ALL KNOW THAT THE PAPER WORK AND THE TOUGH
CHALLENGE OF MAKING A SOUND DECISION ARE COMPLETED, THE HARD
WORK AHEAD IS EQUALLY DEMANDING.

0 WHAT ARE THE BENEFITS? - ACCORDING TO CONSERVATIVE FIGURES
PROVIDED BY THE EXPERTS...

JOB 40 AT THE PLANT PLUS A PROJECTION OF OVER 150
RELATED JOBS.

OTHER PROJECTED INCREASES IN THE REGION:

\$25 MILLION IN PERSONAL INCOME
\$1.5 MILLION IN SERVICE RECEIPTS
\$13 MILLION IN RETAIL SALES
\$1.25[✓] MILLION IN BANK DEPOSITS

WE CAN ALSO EXPECT SEVERAL NEW RETAIL AND SERVICE
BUSINESSES.

AND I AM CONFIDENT THAT FARMLAND AND HEARTLAND WHEAT GROWERS
WILL MAKE EVERY EFFORT TO CONTRACT WITH KANSAS COMPANIES FOR
THE DESIGN AND CONSTRUCTION WORK.

0 FOR THE CO-OPS WHO HAVE STEPPED FORWARD AS INVESTORS, MY
PERSONAL THANKS FOR DEMONSTRATING YOUR CONFIDENCE. FARMLAND
HAS ASSURED ME THAT THE DECISION TO MOVE FORWARD WAS BASED
ON GOOD ECONOMICS, AND I THINK I AM SPEAKING FOR ALL OF US
WHEN I SAY THAT THIS EXCITING VENTURE IN VALUE-ADDED GRAIN
PROCESSING PROMISES TO BE A REWARDING EXPERIENCE.

0 RIGHT HERE IN THE FRONT YARD OF THE NATION'S PREMIER WHEAT
PRODUCING AREA, WE WILL BE ABLE TO PROCESS OUR HARD RED
WINTER WHEAT - 4.25 MILLION BUSHELS A YEAR.

0 I FIND THE BREAKDOWN OF INDUSTRIES WHICH THE MARKETING
PEOPLE INTEND TO TARGET AND THE NEEDS OF THOSE PROCESSORS
VERY IMPRESSIVE:

GLUTEN (USE BY PERCENTAGE)

75% - BAKING INDUSTRY

TARGETING 30 COMPANIES WHICH USE 46% OF THE
TOTAL DOMESTIC PRODUCTION - 93.3 MILLION
POUNDS OF WHEAT GLUTEN PER YEAR.

10% - ANIMAL FEED & PET FOOD INDUSTRY

5% - BREAKFAST CEREALS

WHEAT STARCH

67% - FOOD PRODUCTS

16% - PAPER INDUSTRY

TARGETING 18 CORRUGATED BOX PLANTS IN 9
STATES, INCLUDING KANSAS, AND 50 PAPER MILLS
IN 20 STATES, INCLUDING KANSAS.

OTHER - WHEAT STARCH IS A COMPONENT IN INDUSTRIES WHICH
MANUFACTURE PET FOODS, PHARMACEUTICALS, EXPLOSIVES,
CHARCOAL BRIQUETTES, AND THE BREWERS.

0 WITH THE UNITED STATES THE LARGEST USER OF WHEAT GLUTEN IN
THE WORLD, AND 50% OF THAT IMPORTED, WE WILL HAVE A
LOGISTICAL ADVANTAGE OF A LOW-COST PRODUCTION YIELDING
PRICES COMPETITIVE WITH THE IMPORTS.

0 WE ALSO HAVE THE ADVANTAGE OF A STATE-OF-THE-ART FACILITY
AND TECHNICAL EXPERTISE TO PRODUCE NEW PRODUCTS AND TO
EXPAND THE NUMBER OF PRODUCTS. I KNOW THAT ALL OF US HAVE
COME TODAY TO CELEBRATE THIS STEP WITH THE SAME HOPE THAT
THE MOMENTUM WILL CONTINUE AND THE FUTURE WILL BE STRONG.

Heartland Wheat Growers L.P.
Wheat Starch and Gluten
Production Facility
Russell, Kansas

RUSSELL, KANSAS

Ground Breaking

FACT SHEET

Total Construction Estimate Plant	23.4 million
Total cost	26.4 million
Industrial park cost	3.77 million
Direct new jobs created	40 jobs
Indirect jobs created	150 jobs
Wheat processed (raw)	4.25 million bushels
Industrial Park site	80 acres

Major products produced:

- Wheat starches
- Wheat gluten
- Millfeed
- Commercial Grade Flour

General Partner: Heartland Wheat Growers, Inc.

Limited Partners

Farmland Industries, Inc.	Kansas City, MO
Agco Inc.	Russell, KS
Ellsworth County Farmers Co-op Union	Ellsworth, KS
Midland Marketing	Hays, KS
Wallace County Co-op	Sharon Springs, KS
Minneola Co-op	Minneola, KS

Draft

Post-It™ brand fax transmittal memo 7671		# of pages ▶ 2
To <i>Marcia Adler</i>	From <i>Ned Webb</i>	
Co.	Co. <i>EDA</i>	
Dept.	Phone #	
Fax # <i>202-224-6710</i>	Fax # <i>913 483-4397</i>	

Saturday,
July 24, 1993
11:00 A.M.

07/22/93 15:17 913 483 4397 CITY OF RUSSELL

001/002

The Russell Community would like to thank the many honored guests who are in attendance and helped in the team effort to make this project a reality.

Senator Robert Dole
State Senator Janis Lee
State Representative Carol Dawson
State Representative Laura McClure
Farmland Industries:

Harry Cleberg, President, CEO
Gary Evans, Senior Vice President
Richard Markhem
Steve Rhodes

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Ellsworth Farmers - Ellsworth - Jack Rathbun
Wallace County - Sharon Springs - Robert Waugh
Midland Marketing - Hays - Frank Joy
Minneola Co-op - Minneola - Carl Sparks

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Steve Brennen - Denver Regional office
Kansas Department of Commerce and Housing
Carol Morgan
Cal Lantis
Jack Groves

Farmers Home Administration:

Gary Smith
Rodger Meeks

Northwest Kansas Planning & Development Commission:

Herschel Betts
Phil Clark

Wilson & Company Engineers:

Ron Chandler
Levene Brennen

United Telephone

Carolyn Gaston

Union Pacific Railroad

Mick Munn

Kansas Board of Agriculture

Ken Boughton

DRAFT

Program

Ground Breaking Ceremony

Heartland Wheat Growers L.P.

15th and Copeland Street

Welcome & Introductions Wayne Grabbe
President, General Manager KRSL/KCAY

Speakers:

Mayor Neal Farmer City of Russell
Harry Cleberg President, CEO Farmland
Industries
Honorable Robert Dole Senator of Kansas
Frank Joy On behalf of participating
Co-ops
Chairman Don Haberer Russell County Commission
Loren Dinkel Agco

Ground Breaking

Closing Comments Wayne Grabbe

07/22/93

15:17

0913 483 4397

CITY OF RUSSELL

002/002



Farmland Industries, Inc.
Definition Study

Comm. No. 7845A
August 1992

2.0 EXECUTIVE SUMMARY

2.1 BACKGROUND

Wheat gluten and starch are manufactured in the United States from hard wheat flour. Gluten processing represents an opportunity to add value to wheat grown in the Russell, Kansas region.

The primary customers of vital gluten are bakers. Vital gluten improves the quality of white bread, hearth bread, rolls, rye bread and specialty breads. As much as 4% gluten may be added to a bread formula. Bakers supplement poor baking, low protein flour with vital gluten. This practice enables the baker to produce a wide range of bread products from a single grade of flour. It also reduces the number of flour types that the baker must inventory.

For each pound of gluten produced, about 4 pounds of starch results. The three grades of wheat starch produced are; "A", "Refined" and "B" starch. In the proposed process, "A" starch represents approximately 75% of starch production. The "A" starch and "Refined" starch is processed on food grade equipment and is sold to both food processors and non-food industries. "B" starch is a mixture of starch and non-starch components. It sells as animal feed and to industrial users. Wheat starch is useful as a food ingredient, in fermentation processes and in paper and chemical manufacturing.

Refer to Paragraph 2.9, Industrial Starch Production, for an outline map showing starch production by zones.

2.2 MANUFACTURING OVERVIEW

The proposed gluten plant uses a "wheat flour batter" process. No. 2 hard red winter wheat is milled to 80% flour extraction. This flour is mixed with water, and washed to separate starch from gluten. Separated materials are dried with natural gas-fired dryers. Dry starch and gluten are ground and stored. Finished products are shipped in rail cars, trucks or packaged in 50 and 100 lb. bags. Millfeed is a by-product of the flour milling process.

2.3 PLANT CAPABILITIES

The proposed gluten processing plant has the following capabilities:

- Weigh all trucks in and out with automatic card system scale.
- Receive pre-cleaned (No. 2 Grade) wheat and transfer it to the head house at a rate of 7,500 bu/hr. (20 trucks/day).
- Store 3-day supply of wheat (40,000 bu.) in 4 bins.



Farmland Industries, Inc.
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2.3 PLANT CAPABILITIES, CONTINUED

- Clean wheat for milling at a rate of 625 bu/hr.
- Blend and temper wheat for milling.
- Store tempered wheat in 4 bins (24 hour capacity).
- Mill wheat to a straight grade 80% extraction flour.
- Store 16 hour supply of flour in 2 bins.
- Process flour at a rate of 25,000 lb/hr.
- Produce:
 1. Dry Gluten.
 2. Dry "A" Starch.
 3. Refined Starch (optional).
 4. Dry "B" Starch.
 5. Millfeed.
- Dry gluten, "A" Starch, and "B" Starch.
- Load products to rail cars and/or trucks.
- Package gluten in 50 or 100 lb. bags.
- Accommodate future expansions.

2.4 PRODUCTION CAPACITY

The following table shows the manufacturing capacity in hundred weights (cw) per day (24 hours) of plant operation.

<u>Item</u>	<u>Capacity (cw/24 hr.)</u>
Flour Milling	6,000
Vital Gluten	720
"A" Starch*	2,880
"B" Starch	1,000
Millfeed	1,500

**Processing option: "A" Starch can be processed to Refined Starch at 50% of the "A" Starch yield.*

2.5 FACILITY DESCRIPTION

The attached Drawings show a site plan for the proposed facility. The following is a list of design considerations:

- Wheat receiving and storage.
- Flour Milling.
- Wet processing.
- Warehouse and shipping.
- Office, employee locker and rest rooms, laboratory, and control room.
- Utilities.
- Paved roads and parking.



Farmland Industries, Inc.
Definition Study

Comm. No. 7845A
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2.5 FACILITY DESCRIPTION CONTINUED

The mill, wheat storage and wet processing areas are constructed of concrete. This allows for ease of cleaning and meets food processing regulations for sanitary design. The dryer enclosure, utility area and office area are constructed of masonry. The warehouse is a metal building. All structures are insulated. The facility is designed to accommodate future expansion.

2.6 CONSTRUCTION COST SUMMARY

The following table shows the total installed cost for the proposed wheat gluten/starch processing plant for Russell, Kansas.

<u>Item</u>	<u>Cost</u>
Excavation and Site Preparation.....	\$ 286,338
Rail Siding.....	\$ 125,000
Mill Building, Wheat Handling & Equip.	\$ 5,859,775
Process Building.....	\$ 1,197,755
Gluten/Starch Process Equipment	\$ 4,327,240
Utilities/Mechanical/Electrical.....	\$ 2,864,012
<u>Waste Water Treatment System.....</u>	<u>\$ 4,000,000</u>
Total Construction & Mechanical.....	\$ 18,660,120
<u>Eng., Construction Mgmt. and Expenses.....</u>	<u>\$ 1,839,880</u>
Project Total.....	\$ 20,500,000

2.7 STAFFING

A Staff of 35 is required for the proposed plant to operate three shifts (24 hours), 5 days per week. Included are the following positions:

<u>Position Description</u>	<u>Number</u>
Plant Manager	1
Office Workers	3
Maintenance Workers	4
Wheat Elevator Operator	1
Mill Superintendent	1
Mill Operators	2
Process Superintendent	1
Process Operators	15
Packaging Operators	2
Warehouse Workers	3
<u>Sanitation Workers</u>	<u>3</u>
Total	35



Farmland Industries, Inc.
Definition Study

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2.8 SERVICE REQUIREMENTS

The major operating requirements for the factory are as follows:

Natural Gas.....	24,000 Therms/day
Electrical Power.....	150,000 KWHR/day
Water.....	432,000 Gallons/day
Sewage.....	190,000 Gallons/day

Farmland Industries, Inc.
Definition Study



Comm. No. 7845A
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2.9 INDUSTRIAL STARCH PRODUCTION

The total volume of industrial starch production, 172,600,000 pounds per year shown, represents existing starch accounts, accounts formerly on wheat starch, and accounts where wheat starch is interchangeable with corn starch. These accounts use wheat starch in unmodified form. No specialty starches are included.

INDUSTRIAL STARCH PRODUCTION IN POUNDS PER YEAR



UNITED STATES OF AMERICA

ZONE 1

Corrugating	8,500,000
Building Products	5,800,000
Carriers	3,000,000
Briquetting	4,000,000
Large Granule Starch	<u>4,000,000</u>
Subtotal	25,300,000

ZONE 2

Paper Mill	5,000,000
Corrugating	2,000,000
Special Corrugating	3,000,000
Briquetting	17,000,000
Copiers	1,000,000
Building Products	<u>7,000,000</u>
Subtotal	35,000,000

ZONE 3

Building Products	40,000,000
Briquetting	21,000,000
Corrugating	8,000,000
Large Granule Starch	18,000,000
Miscellaneous	2,600,000
Special Carriers	<u>5,200,000</u>
Subtotal	94,800,000

ZONE 4

Briquetting	12,000,000
Corrugating	3,000,000
Large Granule Starch	1,000,000
Paper & Building Products	<u>1,500,000</u>
Subtotal	17,500,000

TALKING POINTS

GROUND BREAKING FOR WHEAT

GLUTEN PLANT

JULY 24, 1993

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11

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Commercial Grade Flour

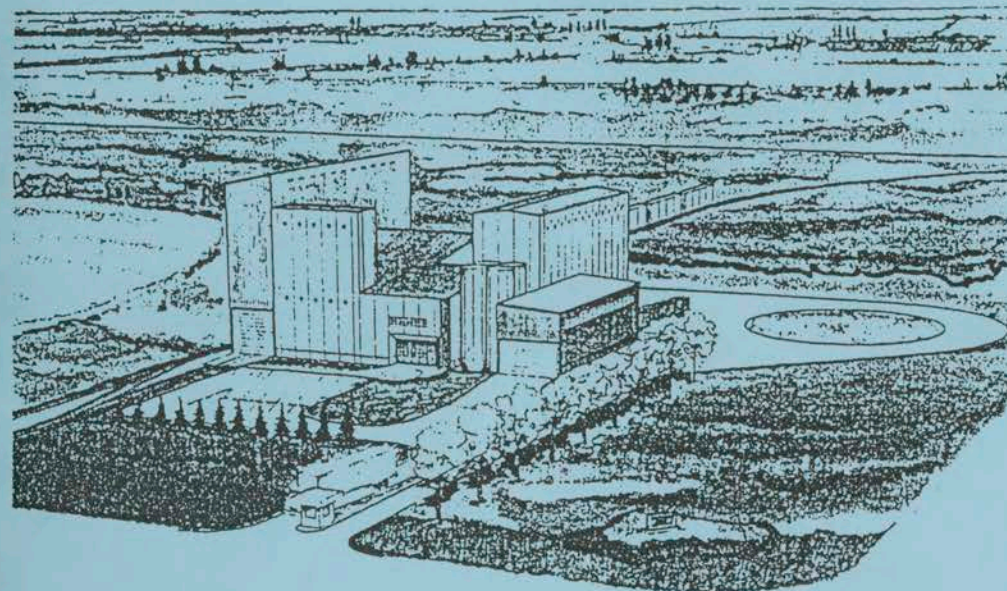
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LaVene Brenden

Ron Chandler

United Telephone:

Carolyn Gaston

Union Pacific Railroad:

Mick Munn

Kansas Board of Agriculture:

Ken Boughton

West Plains Energy:

Lance Boyd

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