

	SMITH CONSTRUCTION, INC. Safety Management System	Doc No:	SCI-S014
		Initial Issue Date	06/30/2025
		Revision Date:	10/06/2025
TANK 18 SOUR WATER DRAW		Revision No.	1
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Purpose

The purpose of this procedure is to define the requirements to safely and efficiently perform TK18 Sour Water Draw.

Scope

This policy details the Risks, PPE, Equipment, Key Responsibilities, instruction for General TK18 Sour Water Draw. When performing vacuum truck operations inside Valero Ardmore Refinery, activities must be performed in accordance with SHG E-31 "Vacuum Truck Operation Safety & Health Guidelines".

Risks

- Exposure to Dangerous Vapors
- Damage to equipment during on-loading/off-loading
- Metal Splinters from Cable
- Slips, Trips, Sprang's, Strains during liner install
- Cuts and pinches during liner tear out
- Exiting Tank Dike Route

PPE

- Basic PPE
- Fresh Air Equipment (12 Pack, Hoses and Mask)

Equipment

- Vacuum Truck

Key Responsibilities

Supervisors

- Shall ensure that this policy is followed and properly executed by trained personnel.

Employees

- Shall follow all aspects of this procedure.

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Process Instructions

Pre-Work & Set-Up

1. **Conduct Pre-Trip** on Equipment
2. **Complete the JSA**
3. **Obtain a permit** for sour water draw indicating the specific valve to operate during the process. Each Water Draw Valve will have an Identification marking its specific location.

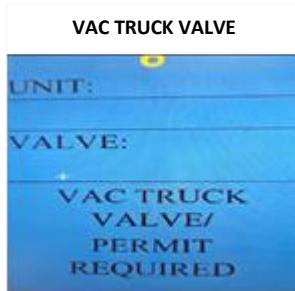
Ex: Equipment TK18

Water Draw Valve "A"

- Before beginning the set-up, ensure that 12 packs of fresh air are in place.
4. **Position Vacuum Truck.** Using a Ground Guide, Back Up to the TK18, chalk wheels, connect ground cable and vent hose.
 5. **Connect the 3" vacuum hose** to the vacuum truck and secure connection with orange safety straps.
 6. **Ensure that the gate valve on the Tank is closed.**
 7. **Connect the grounding cable** to the ground attachment at the tank and ensure that ground light is on.
 8. **Open vacuum truck Ball Valve.**
 9. **Turn on PTO and engage the suction** on the vacuum pump, allow for at least 5psi of vacuum to build
 10. **Ensure the collection tub is located directly under the Water Draw Valve**

SOUR WATER DRAW

11. **Open the Water Draw Valve** on the Tank, (**THIS WILL BE INDICATED BY A BLUE TAG AS SHOWN BELOW**), a near clear stream or yellowish clear stream will begin to flow into the collection tub.



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12. **Using the open end of the vacuum hose**, vacuum the tub until the stream from the tank turns a greyish color, at this time, close the water draw valve closed. Before onloading is complete, make certain to get a sample of the stream.
13. **Complete the vacuum truck log and record the amount of product drawn.**
14. **Close Vac Truck Valve.** Once water draw is complete, close the vac truck valve, verify hose is empty.
15. **Turn vacuum pump to neutral and disengage PTO.** Unhook ground cable, vent hose and secure chalk.
16. **Exiting the Tank Dike –** When exiting the tank dike exit to the LEFT. There is not enough space to make the acute right turn.

CLEAN-UP AND COMPLETION

17. **Clean-Up.** Pick up all trash in the area, store hoses, ensure the water draw valve is secured and not leaking.
18. **Proceed to desalter** and offload per SCI-S001-Desalter Offload procedure.
19. **Contact a supervisor** to advise that the project is complete.