



## ROYSTON ROYFILL HOT FILL #406 Wax Casing Filler WORK PROCEDURE

### Personnel and Equipment:

- All projects will have a heated tanker truck and a support truck
- Crews will be made up of a crew leader and 2 to 3 technicians
- The owner company must have a representative present at all times

### Pre-fill Process:

- If required traffic control will be established
- The crew leader will get the truck ready to fill by preheating truck and control valves
- The technicians will get the vents ready for filling by:
  - Attaching hoses from truck to bottom tapped vent
  - Placing a bucket to capture excess wax
- Crew leader will obtain estimated volume from Contractor
- Contractor to verify that meter, hoses and pressure gauge certifications are current

### Fill Process:

- Wax is pumped by gravity flow. If water is present pressure will build but will be limited to a maximum pressure of 15 psig.
- The bypass valve for tank is eased closed and the fill valve is opened to start flow of wax.
- The gauge at the fill vent is monitored to ensure pressure stays below 15 psig
- Meter will be monitored and compared to the estimated volume required for the casing. If volume exceeds estimate, pumping will be halted to determine if wax is escaping from casing.
- The outlet vent is monitored to ensure airflow during fill
- Fill will continue until approximately one gallon is pumped thru the vent, unless metered volume creates concern that a leak exists in the casing or casing seals

### Completion Process:

- The pressure is back bled off once the casing is full
- Any filler discharged from the vents will be cleaned up by the crew
- The hose will be cleared by reversing the pump and pumping any remaining wax back into the truck
- A material ticket will be completed based upon the volume recorded through the meter. The ticket will specify the date, number of gallons and location.
- Truck will be packed and equipment removed
- Traffic control removed

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