

86618

**FORM U-1A MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS**  
 Alternate Form for Single Chamber Completely Shop-Fabricated Vessels Only S.O. 106-36046

1. Manufactured by BLAW-KNOX COMPANY, Food & Chemical Equipment Division, Buffalo, N.Y.  
(Name and address of Manufacturer)

2. Manufactured for MONSANTO COMPANY, ST. LOUIS, MISSOURI  
(Name and address of Purchaser)

3. Type Horizontal Vessel No. (17081) (                      ) Natl. Bd. No. 7595 Yr. Built 1970  
(Horis. or Vert.) (Mfrs. Serial) (State & State No.)

4. SHELL: Matl. SA-285 GR.C T.S. 55,000 Nom. Thk 1/2 In. Corr. Allow 1/16 In. Diam. 4 Ft. 0 In. Length 6 Ft. 0 In.  
(Kind and Spec. No.) (Fig. or F.B. & Spec. Min. T.S.)

5. SEAMS: Long Dbl. Butt H.T. YES X.R. Complete Sectioned NO Efficiency 100 %  
(Welded, Dbl., Single, Lap, Butt) (Yes or No)<sup>1</sup> (Spot or Complete) (Yes or No)

If riveted or brazed describe seams fully under remarks.

Girth - H.T. - X.R. - Sectioned - No. of Courses 1  
Firebox Qual.

6. HEADS: (a) Material SA-515 GR. 70 T.S. 70,000 (b) Material                      T.S.                       
Location (Top, bottom, ends) Thickness Crown Radius Knuckle Radius Elliptical Ratio Conical Apex Angle Hemispherical Radius Flat Diameter Side to Pressure (Convex or Concave)

(a) Ends 2-1/4" 47"  
 (b)                                                               

If removable, bolts used                      Other fastening Heads welded to shell  
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)

7. Constructed for max. allowable working press. 60 psi at max. temp. 650 °F. Min. temp. (when less than -20°)                      °F. Hydrostatic                      Pneumatic or                      Test Press 90 psi.  
Combinator

8. SAFETY OR RELIEF VALVE OUTLETS: Number                      Size                      Location                     

9. NOZZLES:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached

10. INSPECTION Manholes, No.                      Size                      Location                       
 OPENINGS: Handholes, No. 2 Size 6" dia. Location One in each head.  
 Threaded, No.                      Size                      Location                     

11. SUPPORTS: Skirt NO Lugs                      Legs                      Other Trunnions Attached Welded in each head.  
(Yes or No) (Number) (Number) (Describe) (Where & How)

12. REMARKS: FLAKER DRUM  
Cooling Water - Interior  
Product - Exterior

**Ultimate Destination: Monsanto Company, Sauget, Illinois**

(Brief description of purpose of the vessel as Air Tank, Water Tank, L.P.G., Etc.—State Contents. If postweld heat-treated. List other internal or external pressures with coincident temperature when applicable.)

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Unfired Pressure Vessels.

Date 1/13/70 19                      Signed BLAW-KNOX COMPANY By                       
(Manufacturer)  
 Food & Chemical Equipment Division  
 Certificate of Authorization Expires #2231 December 31, 1970

**CERTIFICATE OF SHOP INSPECTION**

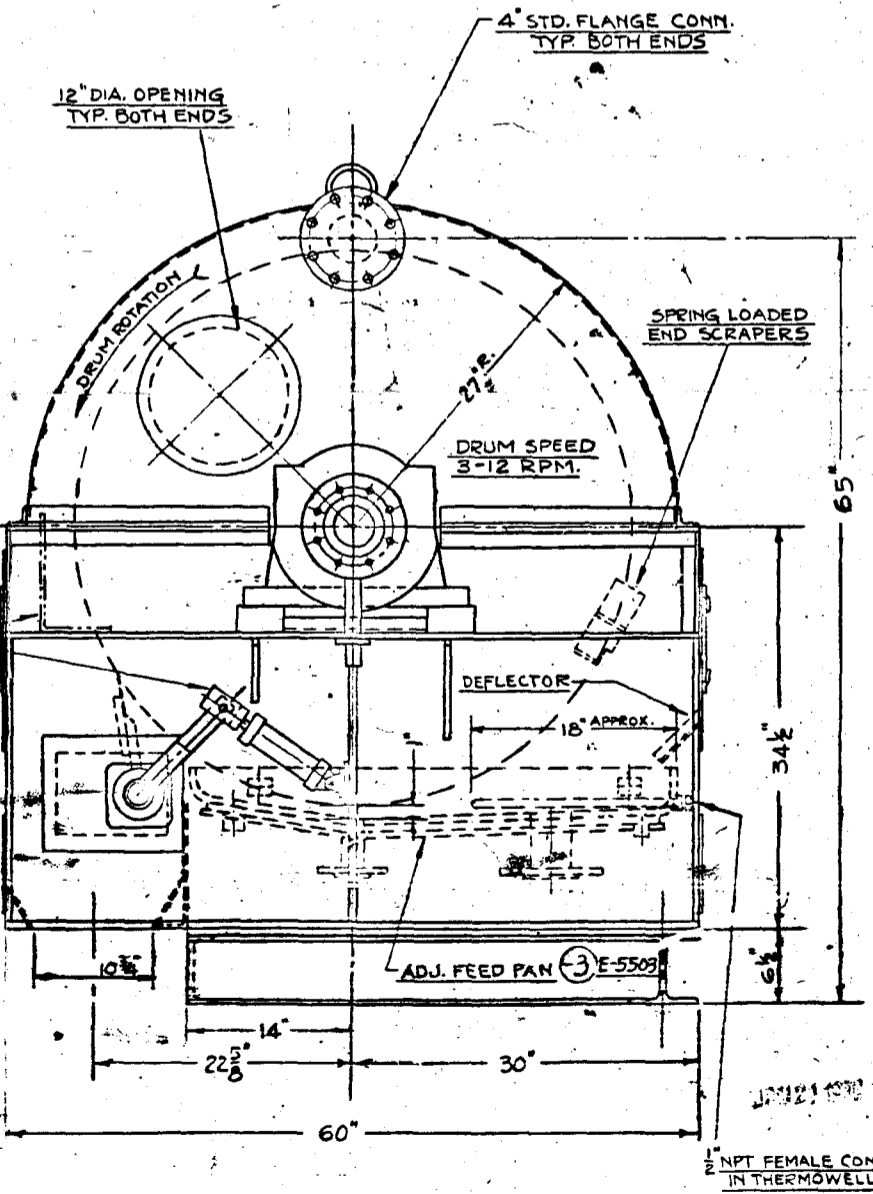
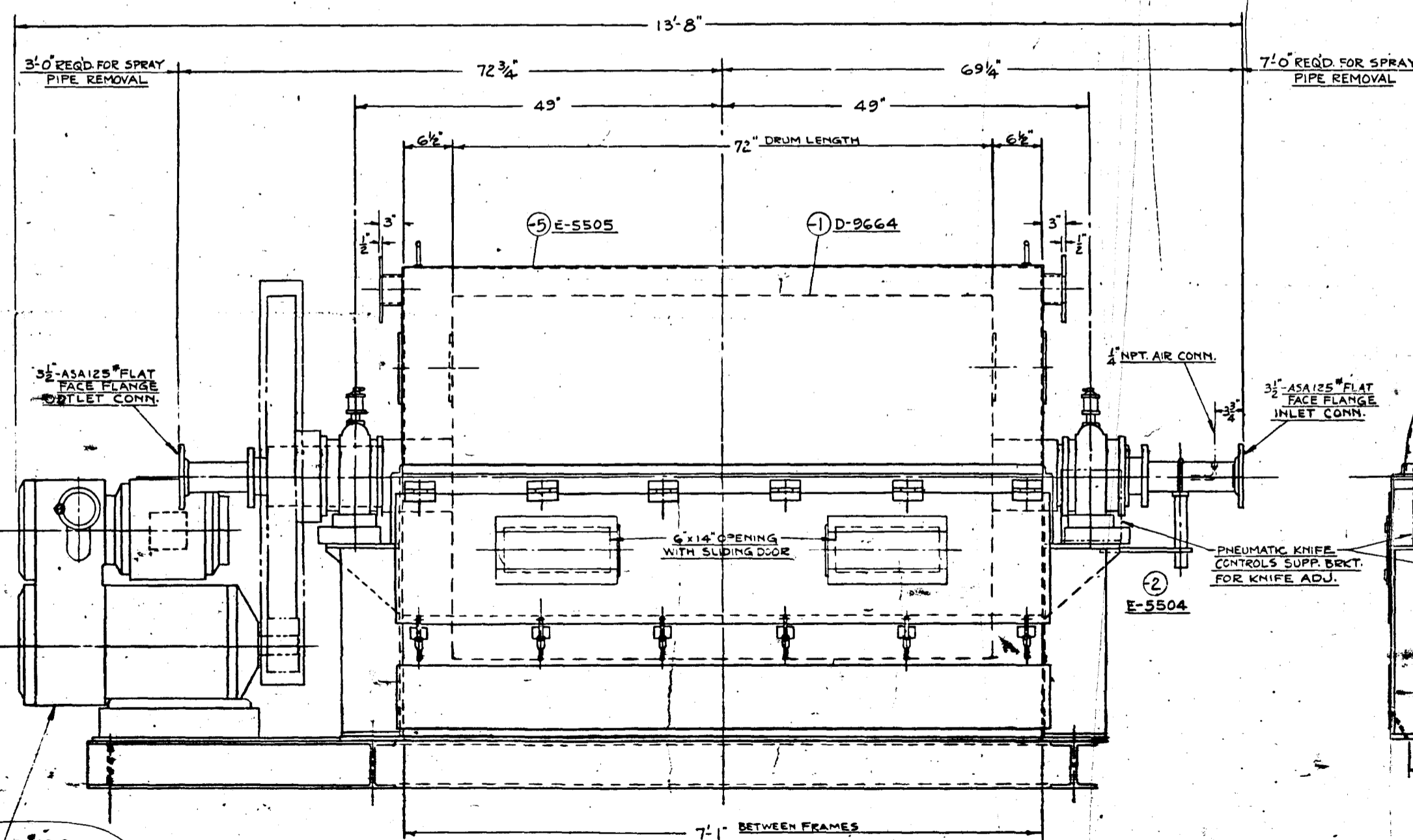
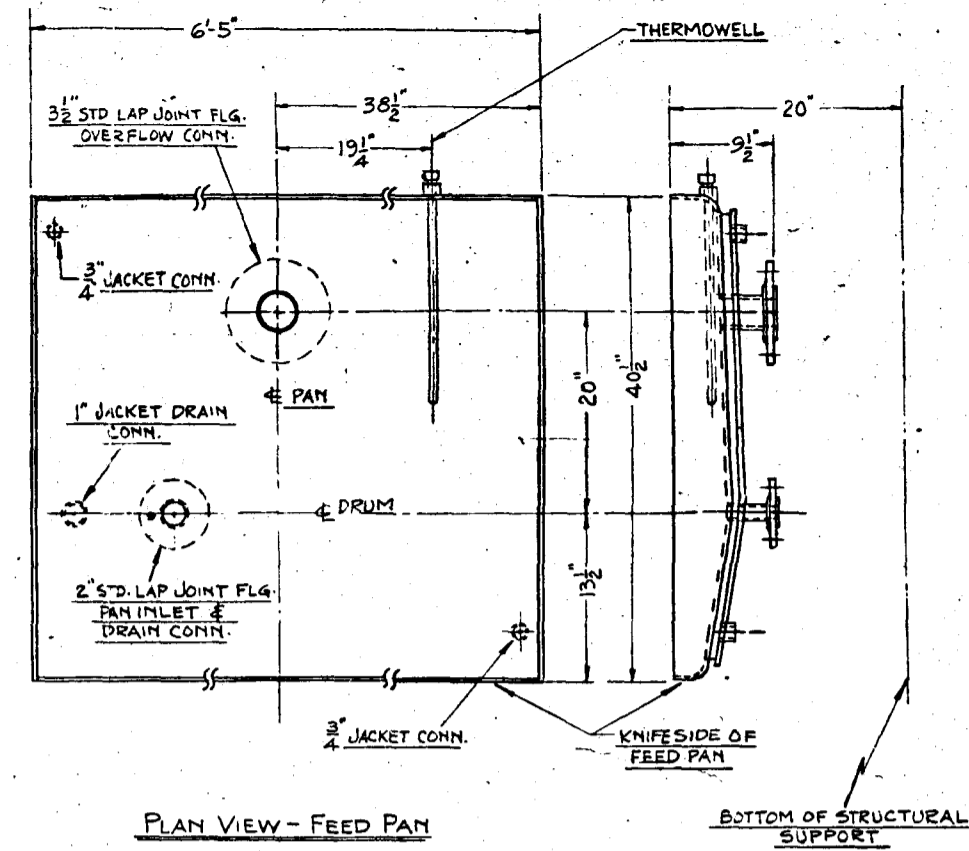
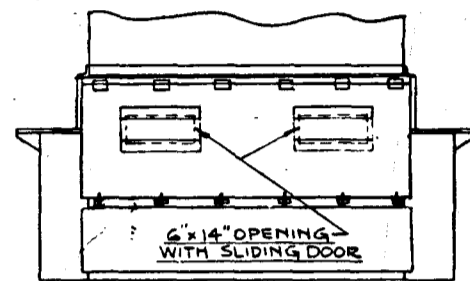
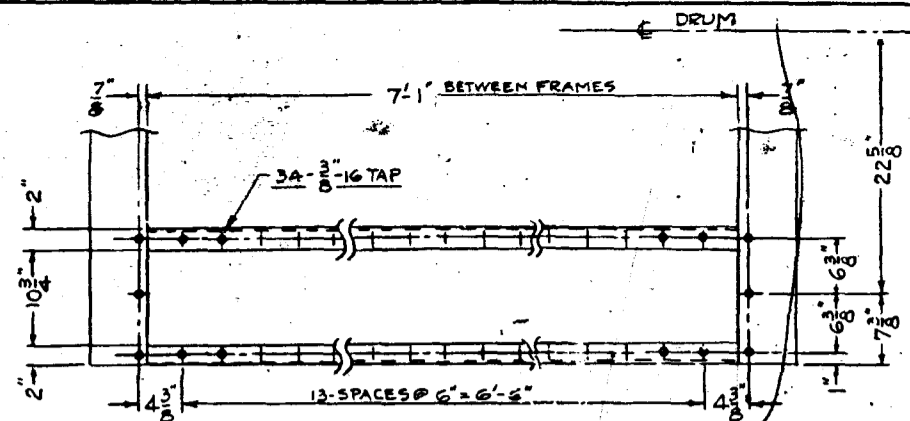
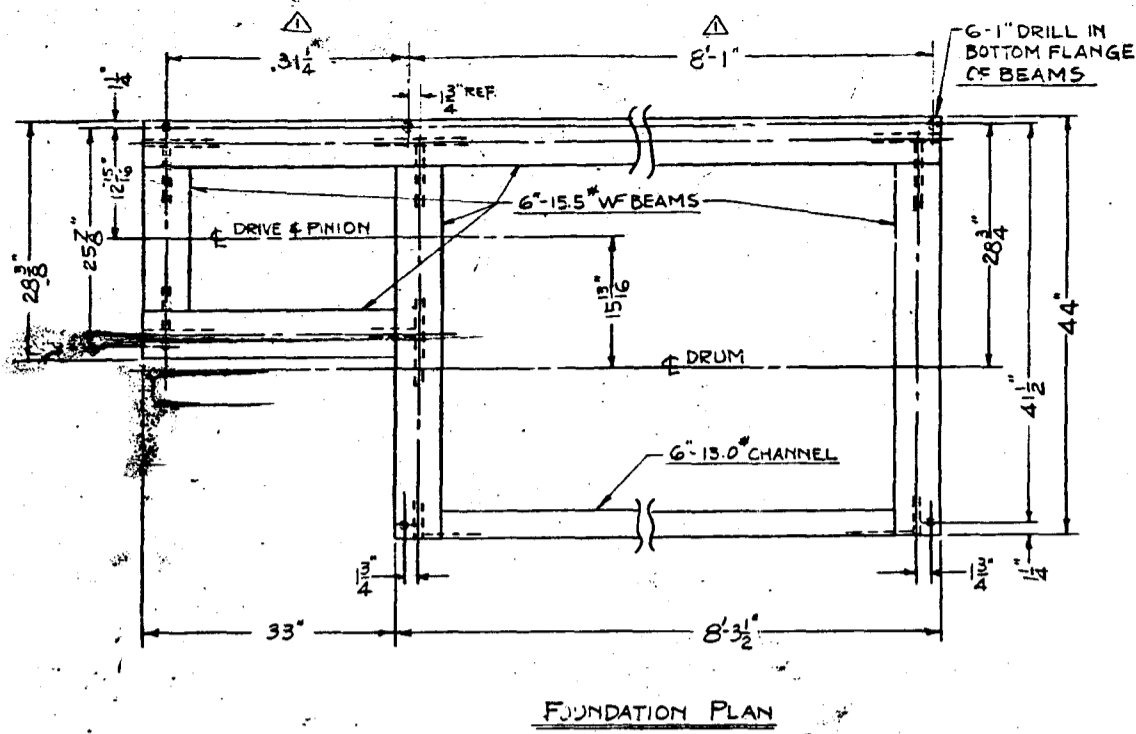
T-6258 **BLAW-KNOX COMPANY**  
 VESSEL MADE BY Food & Chemical Equipment Division at Buffalo, New York

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State of New York and employed by Travelers Indemnity Co. of Hartford, Connecticut have inspected the pressure vessel described in this manufacturer's data report on                      19                     , and state that to the best of my knowledge and belief, the manufacturer has constructed this pressure vessel in accordance with the applicable sections of the ASME Boiler and Pressure Vessel Code.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this manufacturer's data report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date Feb 13 19                       
 Inspector's Signature                      Commissions NB 5886 Nat'l Board or State and No.                     

224-10012  
 431  
 222



**NOTICE**  
 This print is loaned subject to return upon demand and upon the express condition that it is not to be used directly or indirectly in any way detrimental to our interests.  
 BLAW-KNOX COMPANY  
 FOOD & CHEMICAL EQUIPMENT DIVISION  
 BUFFALO, NEW YORK  
 U.S.A.  
 CERTIFIED PRINT FOR CONSTRUCTION PURPOSES  
 CUSTOMER'S ORDER No. 9-2026  
 Blaw-Knox Company  
 Food & Chemical Equipment Division  
 Approved by [Signature] Date: 1-21-70

**REFERENCE DWGS.**  
 DRUM ASS. D-9664  
 SCRAPER ASS. C-11942  
 KNIFE CONTROL D-9603  
 KNIFE ASS. D-9335  
 END ASS. E-5505

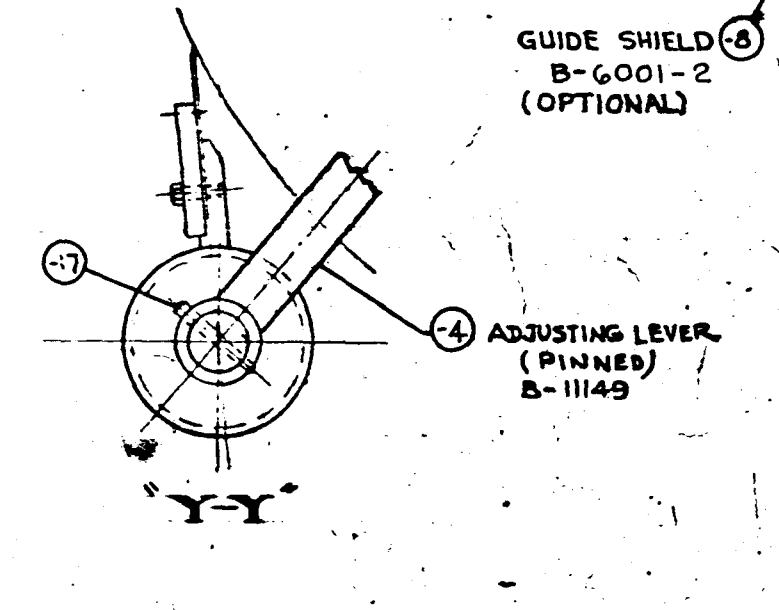
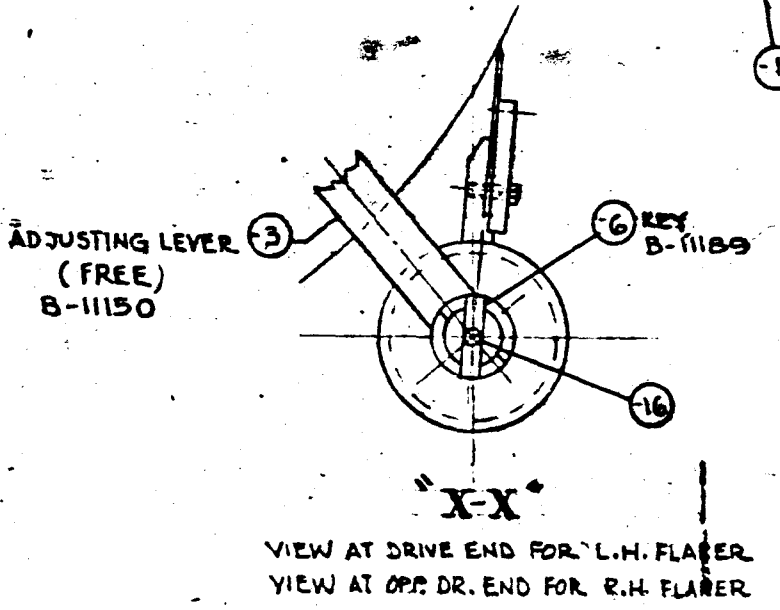
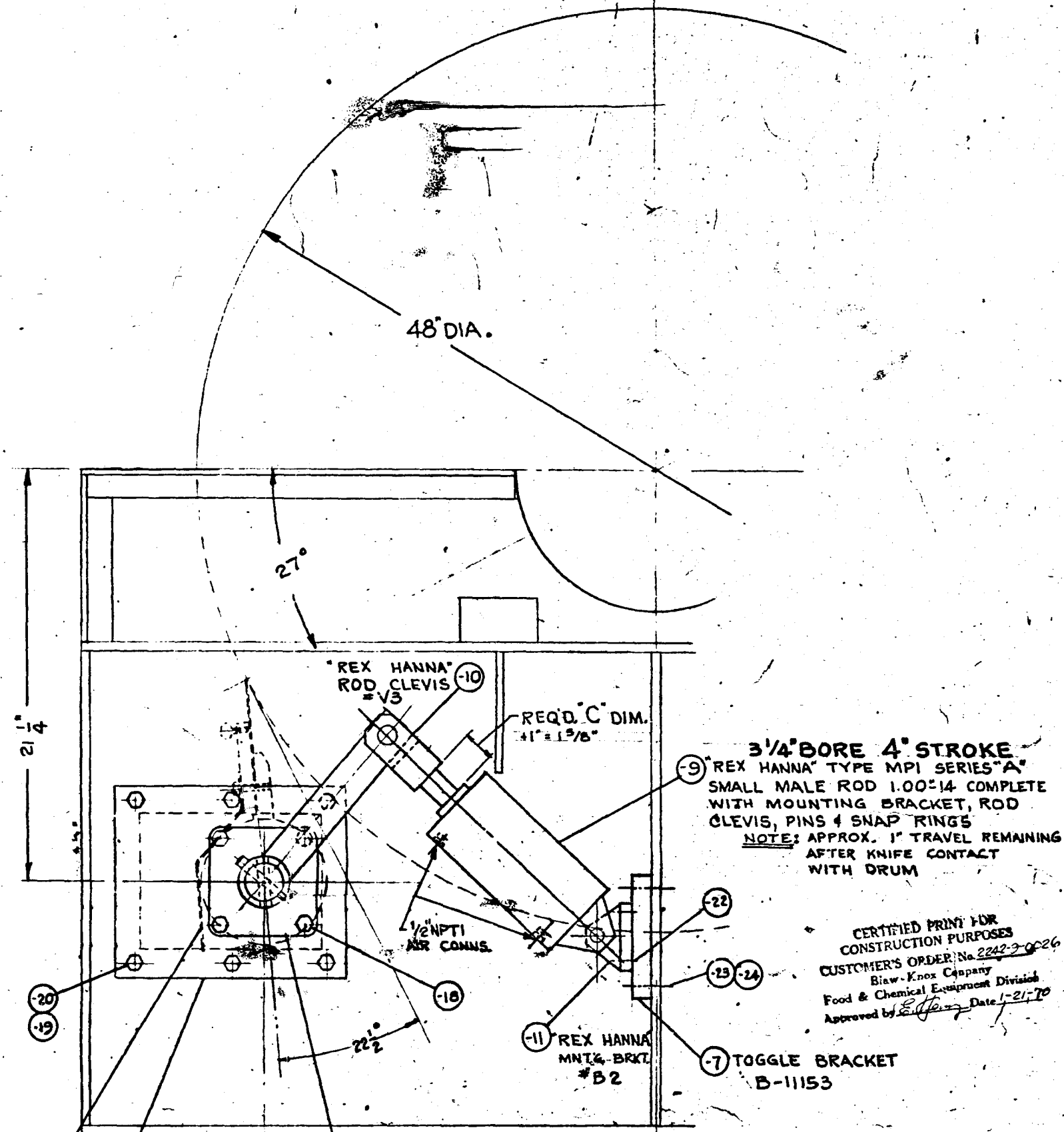
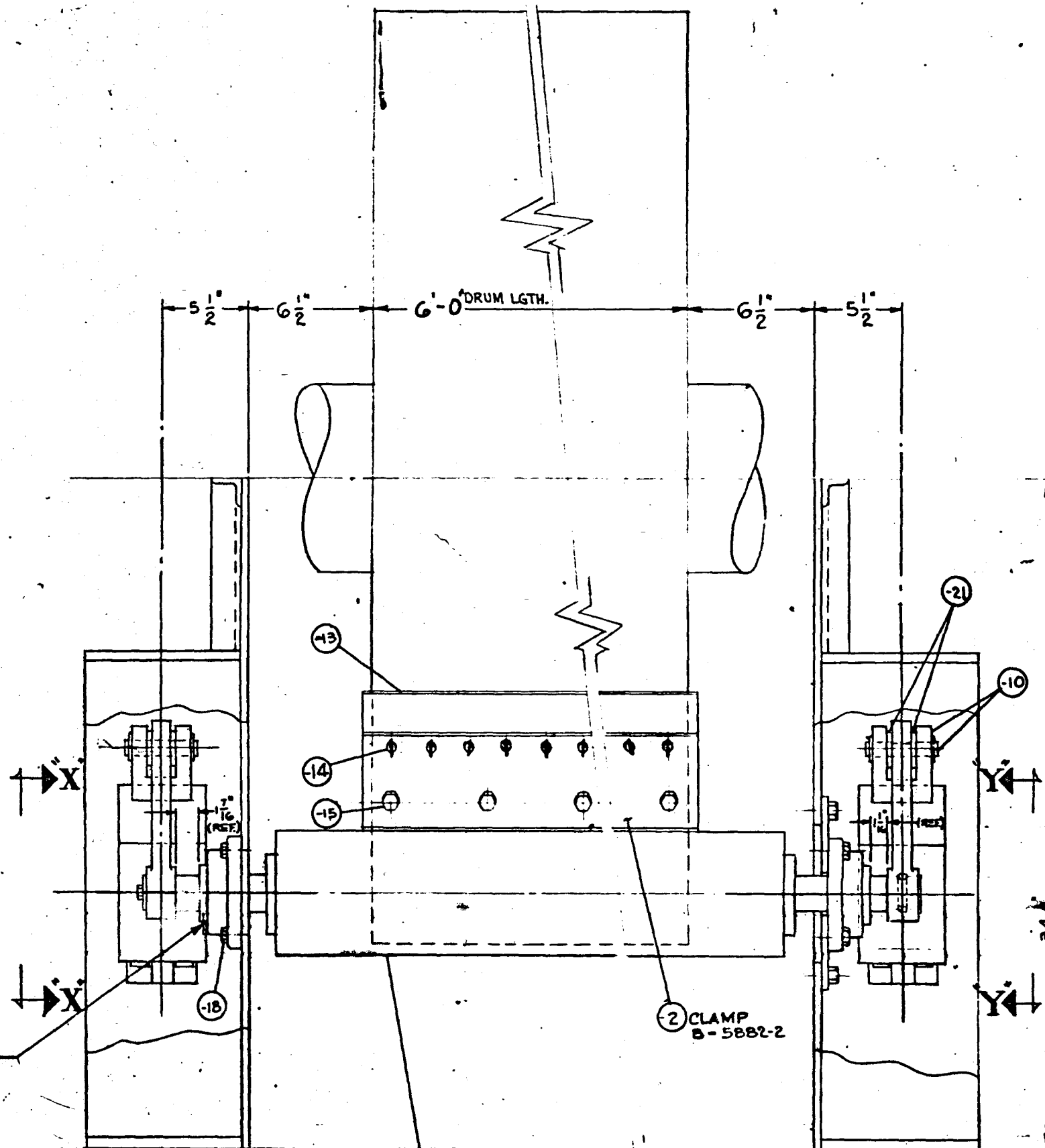
U.S. VARIDRIVE 23-215-40  
 YEV-HV-GD C FLOW  
 21-84 RPM OUTPUT SPEEDS  
 5HP-3PH-60CY-230/460 VOLTS  
 DRIP-PROOF MOTOR  
 D-9676  
 52-88875

APPROX. WEIGHT  
 FLAKER-LESS DRIVE-EMPTY-9,360\*  
 DRIVE-575\*

ACKNANTO COMPANY  
 CENTRAL ENGR DEPT  
 SAULET, ILLINOIS  
 437,000

BLAW-KNOX COMPANY FOOD & CHEMICAL EQUIPMENT DIVISION BUFFALO, NEW YORK	
SCALE: 1" = 12" DATE: 1-21-70	DESIGNED BY: [Signature]
EQUIP. SINGLE DRUM FLAKER	
PART NAME: FIELD ASSEMBLY	
REFERENCE DWG. No. E-5356	DRUG ORDER NO. 3086
DWG. No. E-5494	REV. 1

86618



CERTIFIED PRINT FOR CONSTRUCTION PURPOSES  
CUSTOMER'S ORDER No. 2242-9-0026  
Blaw-Knox Company  
Food & Chemical Equipment Division  
Approved by *E. J. [Signature]* Date 1-21-70

NOTICE  
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BLAW-KNOX COMPANY  
FOOD & CHEMICAL EQUIPMENT DIVISION  
BUFFALO, NEW YORK

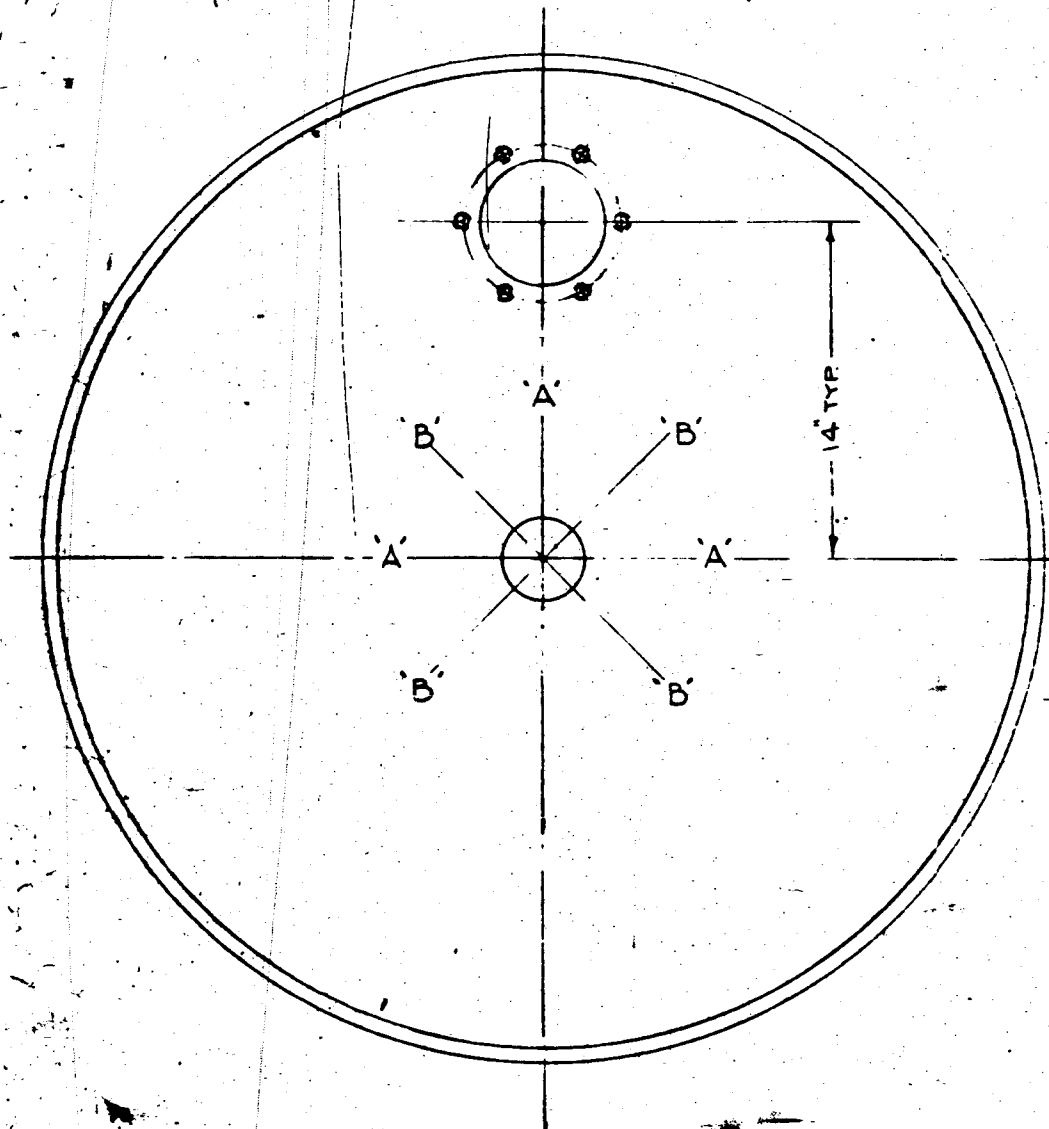
JAN 21 1970

2242-9-0026

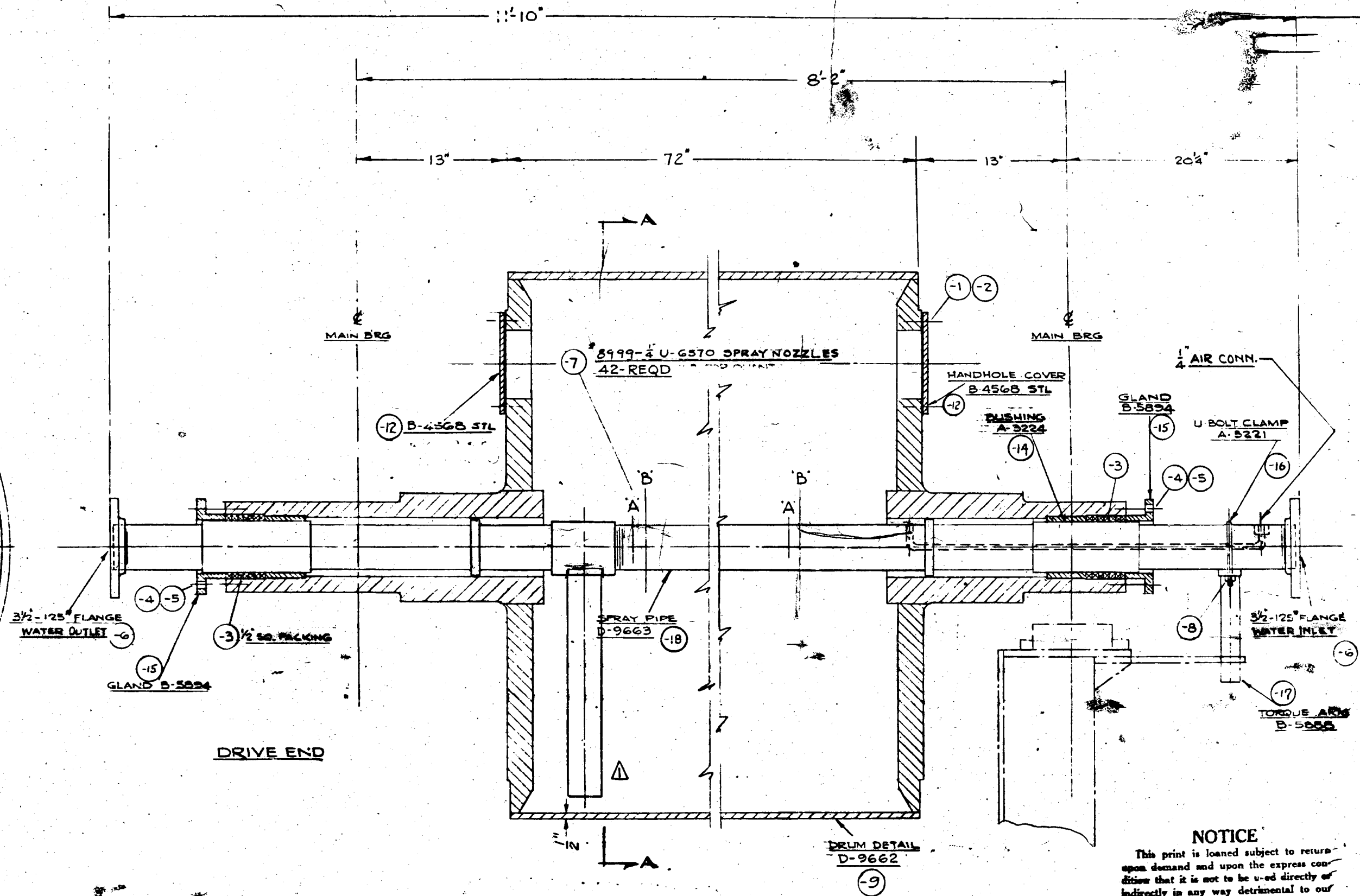
SAUGET, ILLINOIS

48" x 72" SINGLE DRUM FLAKER

SCALE	3" = 12"	DATE	12-27-68
EQUIP.	SINGLE DRUM FLAKER		
TYPE ENCLOSED	48" DIA. x 72" LG.		
SHOP ORDER	APP. BY	DATE	PART NAME
			PM [Signature]
REFERENCE DWG. No.	SHOP ORDER STANDARD		
	DWG. No. D-9355		



SECTION A-A



DRIVE END

DRUM DETAIL  
D-9662  
(9)

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BLAW-KNOX COMPANY  
FOOD & CHEMICAL EQUIPMENT DIVISION  
BUFFALO, NEW YORK  
U.S.A.

**CERTIFIED PRINT FOR CONSTRUCTION PURPOSES**  
CUSTOMER'S ORDER No. 2242-2-8026  
Blaw-Knox Company  
Food & Chemical Equipment Division  
Approved by *[Signature]* Date 1-21-70

JAN 21 1970  
2242-2-8026  
SAUGET, ILLINOIS  
437.000  
48" X 72" SINGLE DRUM FLAKER

Reviewed by *[Signature]* Date 1/27/70  
 Make Corrections noted  Leave as Shown  Final

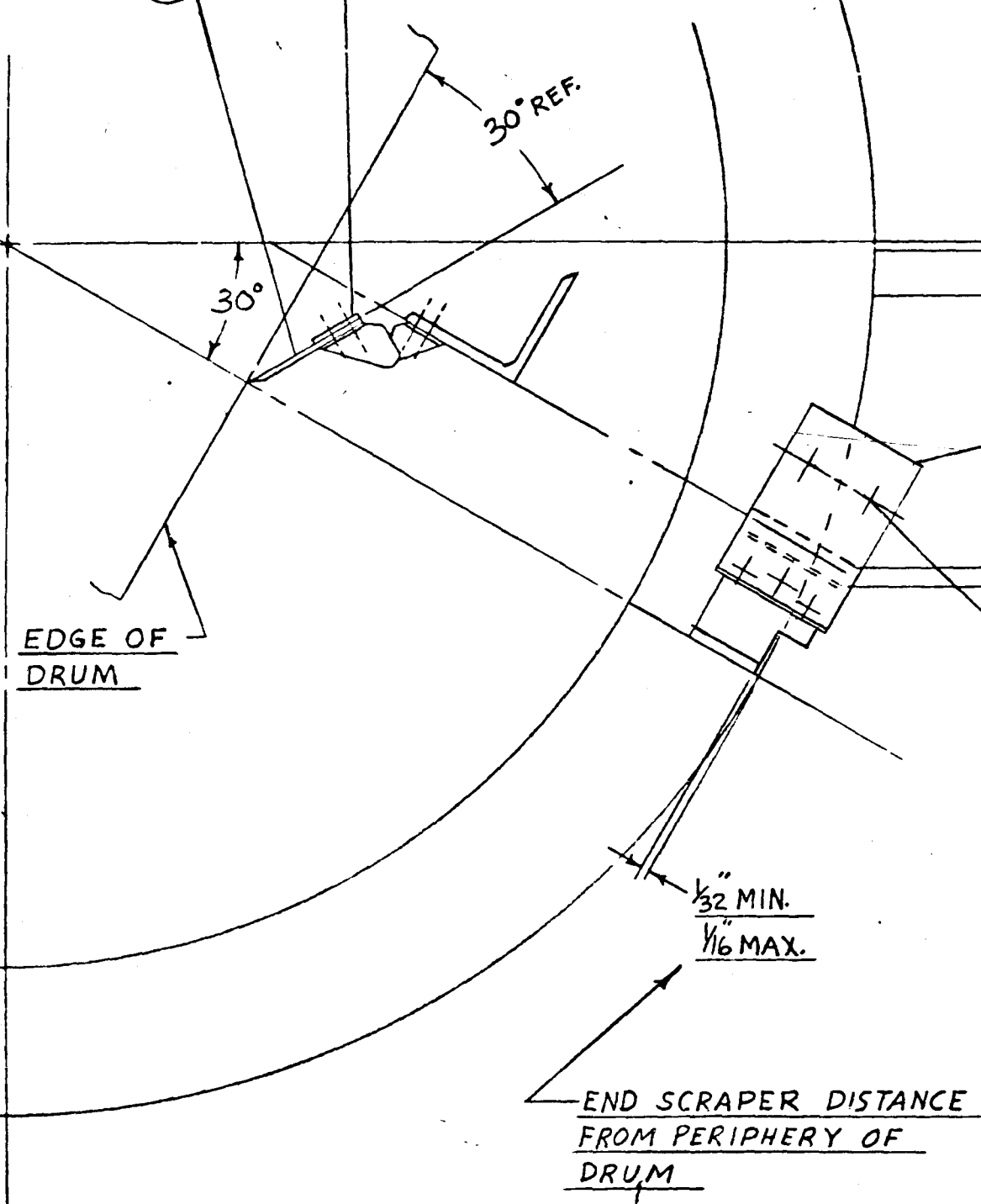
MACHINE FINISH SYMBOLS				RC - ROUGH CUT	R - ROUGH FINISH	M - MEDIUM FINISH	PL - POLISHED
1	2	3	4				
5	6	7	8				
9	10	11	12				
13	14	15	16				
17	18	19	20				
21	22	23	24				
25	26	27	28				
29	30	31	32				
33	34	35	36				
37	38	39	40				
41	42	43	44				
45	46	47	48				
49	50	51	52				
53	54	55	56				
57	58	59	60				
61	62	63	64				
65	66	67	68				
69	70	71	72				
73	74	75	76				
77	78	79	80				
81	82	83	84				
85	86	87	88				
89	90	91	92				
93	94	95	96				
97	98	99	100				

**BLAW-KNOX COMPANY**  
**BURLOVAK EQUIPMENT DIVISION**  
SCALE: E' - 12" BUFFALO, N.Y. 11-25-69  
EQUIP. SINGLE DRUM FLAKER  
TYPE: SIZE 48" DIA. X 72"  
PART NAME: DRUM ASSEMBLY  
Original Shop Order 106-36046-01  
DWG. No. D-9664

P/L WRITTEN

SCRAPER BLADE  
B-11063-1  
B-11063-2

SCRAPER BACK UP  
B-11062



-1  
BRACKET  
B-11154

-9  
-10  
▲

-6  
-7  
-8

-5  
SPRING HINGE #1481B22  
3"x3" STANDARD DUTY  
MCMASTER-CARR

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BLAW-KNOX COMPANY  
FOOD & CHEMICAL EQUIPMENT DIVISION  
BUFFALO, NEW YORK  
U.S.A.

1970

P/L WRITTEN

VIEW FROM RIGHT HAND FRAME

CERTIFIED PRINT FOR CONSTRUCTION PURPOSES  
CUSTOMER'S ORDER No. 2242-9-0026  
Blaw-Knox Company  
Food & Chemical Equipment Division  
Approved by *[Signature]* Date 1-21-70

Reviewed by *[Signature]* Date 1/29/70  
 Make Corrections noted  Leave as Shown

MONSANTO COMPANY Order No. 2242-9-0026  
CENTRAL ENGR. DEPT. Project No. 2242  
SADGET, ILLINOIS Area 01  
Sheet No. 437,000  
48"x72" SINGLE DRUM FLAKER

- (-50) L.H. END SCRAPER ASS'Y.
- (-51) R.H. END SCRAPER ASS'Y.

BLAW-KNOX COMPANY FOOD & CHEMICAL EQUIPMENT DIVISION BUFFALO, NEW YORK			
SCALE	3" = 12"	DATE	12-18-68
EQUIP. SINGLE DRUM FLAKER			DR. BY DEN
PART NAME END SCRAPER ASSEMBLY			TR. BY
STO. APP. DATE	12-23-68	TYPE	SIZE 48"
SHOP ORDER	BY	DATE	APP.
REFERENCE DWG. No.	DWG. No. C-11942		
CHG. ORDER STANDARD	REV. 1		