

**FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS**  
 (Alternative Form for Single Chamber, Completely Shop or Field Fabricated Vessels Only)  
 As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

Form U1-A  
01

1. Manufactured and certified by Industrial Service & Fabricators, Inc. 1425 South Burleson Boulevard Burleson, Texas, USA 76028  
 (Name and address of manufacturer)  
 2. Manufactured for Crouch Engineering, 305 S Main St., Fort Worth, TX 76104  
 (Name and address of purchaser)  
 3. Location of installation Bunge Foods, 6700 Snowden Dr., Fort Worth, TX 76140  
 (Name and address)  
 4. Type Vertical 05-6231 --- 8015-2 Rev. 1 5896 2005  
 (Horiz. or vert. tank) (Mfg's serial No.) (CRN) (Drawing No.) (Nat'l. Bd. No.) (Year Built)  
 5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE.  
 The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 2004  
 to --- --- --- --- --- --- --- --- --- ---  
 Addenda (Date) Code Case Nos. Special Service per UG-120 (d) Year

6. Shell: SA-516-70 0.375" 0 3' 6" OD 10' 0"  
 Matl. (Spec. No., Grade) Nom. Thk. (in.) Corr. Allow. (in.) Diam. I.D. (ft. & in.) Length (overall) (ft. & in.)  
 7. Seams: Welded, Dbl. Butt None 70% --- --- Welded, Sngl. Butt, Type 2 None 1  
 Long (Welded, Dbl, Sngl, Lap, Butt) R.T. (Spot or Full) Eff. (%) H.T. Temp. (°F) Time (hr) Girth (Welded, Dbl, Sngl, Lap, Butt) R.T. (Spot, Partial or Full) No. of Courses

8. Heads: (a) Matl. SA-516-70 (b) Matl. ---  
 (Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Top, Bottom	0.3125"	0	---	---	2:1	---	---	---	Concave
(b)										

If removable, bolts used (describe other fastenings) \_\_\_\_\_  
 (Matl., Spec. No., Gr., Size, No.)  
 9. MAWP 250 psi at max. temp. 200 °F  
 Min. design metal temp. -20 °F at 250 psi. Hydro., Pneu., or Comb. test pressure 325 psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl	How Attached	Location
Wet Return	1	8"	Pipe	SA-106B	0.322"	SA-516-70	Welded	Shell
Dry Suction	1	6"	Pipe	SA-106B	0.280"	SA-516-70	Welded	Shell
Pump Suction	2	4"	Pipe	SA-106B	0.237"	SA-516-70	Welded	Bottom Head
Liq. Make-Up	1	2.5"	Pipe	SA-106B	0.203"	Inherent	Welded	Shell
Drain, Lvl. Column	3	1.5"	Pipe	SA-106B	0.200"	Inherent	Welded	Bottom Head, Shell
Pump Bypass/Relief	2	1"	Pipe	SA-106B	0.179"	Inherent	Welded	Shell, Bottom Head
Pump Recirc, OP Vent	3	0.75"	Pipe	SA-106B	0.154"	Inherent	Welded	Shell, Bottom Head
Relief	1	0.75"	Cplg.	SA-105	3000#	Inherent	Welded	Shell

11. Supports: Skirt No Lugs --- Legs --- Other Angle Legs (4) Attached Bottom Head/Shell, Welded  
 (Yes or no) (No.) (No.) (Describe) (Where and how)  
 12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: \_\_\_\_\_  
 (Name of part, item number, Mfg's. name and identifying stamp)

For Non-Corrosive Service  
 M.D.M.T. Per UG 20 (f)  
 Designed per UG 22 (a)

**CERTIFICATE OF SHOP/FIELD COMPLIANCE**

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 Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 24,474  
 expires August 23 2007  
 Date 11-22-05 Co. name Industrial Service & Fabricators, Inc. Signed [Signature]  
 (Manufacturer) (Representative)

**CERTIFICATE OF SHOP/FIELD INSPECTION**

Vessel constructed by Industrial Service & Fabricators, Inc. at Burleson, TX, I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Texas and employed by IB&M RE have inspected the component described in this Manufacturer's Data Report on 11-23-05, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. 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 11-23-05 Signed [Signature] Commissions 9441 A TX, 1066  
 (Authorized Inspector) Nat'l. Board (Incl. endorsements, State, Prov. and No.)