Note: The following is an excerpt from an historical account by Carl Nielsen who was co-founder and President of DCI, Inc. from 1955 until his retirement in 1987.

"DCI began on a cold winter day in 1955 when Carl Nielsen, who was then equipment sales manager for Owatonna Creamery Supplies Co., was visiting with Fred and Richard Konsor, who owned Konser Brothers’ Welding and Machine Shop in Holdingford, MN. The three discussed orders which Carl had placed with the Konsors for producing stainless steel storage tanks. During the conversation, Carl suggested that it might be worthwhile to investigate the possibilities of forming a new corporation for the manufacture of stainless steel equipment for the dairy industry. Fred and Richard were receptive to the idea, so Carl resigned his position at Owatonna Creamery Supplies Co.; borrowed money from friends to invest in the new company and brought in investors along with Fred and Richard who agreed to invest their equipment and talent in the company.

Dairy Craft, Inc., started operations on May 1, 1955, in a vacant farm implement building in Holdingford purchased on a contract-for-deed basis. In the ensuing years, two major additions were attached to the building.

In 1969, having outgrown the Holdingford plant, DCI moved to its present location in St. Cloud through arrangements made with St. Cloud Opportunities, Inc., and local banks. An addition was built onto the plant in 1974.

The quality of stainless steel equipment being made by DCI, Inc., was being purchased by a wide range of industries. In 1978, it became apparent that the Dairy Craft corporate name was not symbolic of the products and industries being served by the company and the name was changed to DCI, Inc."

Fifty Years of Quality Craftsmanship

In 2001, DCI formed an affiliation which once again expanded the services offered—field fabrication of tanks, known as DCI Site-Fab. The facility in Ozark, Missouri, is the base for Site-Fab, as well as shop-fabricated tanks.

Today, DCI provides stainless steel/high alloy equipment to many industries worldwide—companies whose processes require the metal’s long-lasting, corrosion-resistant advantages.

We thank all of our many customers as we celebrate 50 years and look to a successful future!
Why DCI?

DCI, Inc. is a world leader in the manufacturing and servicing of both shop and field-fabricated storage and processing tanks and vessels. Proudly serving the pharmaceutical, bioscience, chemical, cosmetic, food, dairy, beverage and brewing industries, DCI has remained true to our commitment to quality since 1955 through our design and fabrication services.

We strive toward continuous improvement through involvement. We are members of ISPE, IAFIS, FPMA, FISA, IDFA, SADFM, QCS (SECO/Quality Check’d), ASME, AWS, NACE, ASTM, ASM, ASME-BPE, as well as many regional organizations.

As an employee-owned company, we’re committed to complete customer satisfaction through quality, value and service. We know our success is related to your satisfaction!

Why DCI?

...experience, commitment and quality—we’ve been here for over 50 years and we’re looking forward to a successful future!

DCI GOES THE EXTRA MILE TO COMPLETE YOUR PROJECT TO THE FULLEST. NO DETAIL IS OVERLOOKED.

Why DCI?

DCI, Inc.
Corporate Offices
St. Cloud, Minnesota
Plant Area: 87,640 sq. ft.
Office Area: 12,960 sq.ft.

Code Compliance Capabilities
- ASME Section VIII, Div. 1
- ASME Pressure Vessel Code—“U” Stamp
- ASME BPE Standard
- 3A (Authorization Holder for 01-, 22-, 24-, 25-, 32-)
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Other Capabilities
- API 620 & 650
- NBIC
- CRN
- OSHA
- UBC
- IBC
- USDA
- UL 5B, 80, 142 (Underwriters Lab)
- TEMA (Tubular Exchange Mfg. Assoc.)
- cGMP’s
- NSF
- ANSI
- AISI
- ASTM
- AWS
- BOCA
- NFPA-30
- WRC (Welding Research Council)
- AutoCAD 2D & 3D
- 3D Modeling (Autodesk Inventor)

Customer FAT (Factory Acceptance Testing/Inspection Room)

DCI’s new, climate-controlled, semi-private inspection room includes an office area and all utilities to serve our customers’ requirements during inspection. Approximate dimensions are 23’ W x 60’ L x 21’ H.

DCI, Inc.
Springfield Division
Ozark, Missouri
Plant Area: 10,000 sq. ft.
Office Area: 800 sq.ft.

Customer FAT (Factory Acceptance Testing/Inspection Room)
### Fabrication

<table>
<thead>
<tr>
<th>Capacity</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 Liter to 70,000 Gallon (500,000 Gallon Site-Fab)</td>
<td>Plasma-CNC Burn Table: 2 1/2&quot; x 3/4&quot; maximum, 100° x 144”</td>
</tr>
<tr>
<td>Passivation Equipment</td>
<td>Air Compressors 200 HP maximum; 1,000 CFM total</td>
</tr>
<tr>
<td>PLC-CIP Skid/Station (2)</td>
<td>Bay Sizes: 60’ W x 384’ L</td>
</tr>
<tr>
<td>Tank Turning Rollers: up to 120,000 lb. capacity</td>
<td>Door Sizes: up to and including 22’ H x 20’ W</td>
</tr>
<tr>
<td>Heat Transfer Surface: coil, half pipe, dimple jacket, laser weld</td>
<td>Forklifts: up to 11,000 lb. capacity</td>
</tr>
<tr>
<td>Plasma-Arc Cutting: 1” SS maximum; portable</td>
<td>Overhead Cranes: 23’ underhook height capacity-35 ton capacity</td>
</tr>
<tr>
<td></td>
<td>Travel Lift: 25 ton (straddle carrier)</td>
</tr>
</tbody>
</table>

### Finishing

<table>
<thead>
<tr>
<th>Capacity</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Glass Ilead: 22’ W x 60’ L x 20’ H</td>
<td>Cylinder Polishing (Internal): 13’ ID x 24’ L; 24” diameter minimum</td>
</tr>
<tr>
<td>Paint Booth: 23’ W x 80’ L x 21’ H</td>
<td>Electropolishing: up to 13” diameter, up to 25,000 gallon</td>
</tr>
<tr>
<td>Pipe Polishing: external 8” x 20’ maximum</td>
<td>Head Polishing: 24” diameter minimum; up to 14’ diameter; up to 3/4” thick</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Welding

<table>
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<tr>
<th>Capacity</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Gas Tungsten Arc Welding (GTAW)</td>
<td>Tube to Tube Sheet (GTAW): 5/8” to 5”</td>
</tr>
<tr>
<td>Gas Metal Arc Welding (GMAW)</td>
<td>Manipulator: 14’ x 14’ on tracks</td>
</tr>
<tr>
<td>Shielded Metal Arc Welding (SMAW)</td>
<td>Weld Positioners: 25,000 lb. capacity maximum</td>
</tr>
<tr>
<td>Submerged Arc Welding (SAW)</td>
<td>Seam Welding Fixtures: up to 24” maximum</td>
</tr>
<tr>
<td>Plasma Arc Welding (PAW)</td>
<td></td>
</tr>
<tr>
<td>Orbital Welding: 3/8” to 4” tube</td>
<td></td>
</tr>
<tr>
<td>Flux-Cored Arc Welding (FCAW)</td>
<td></td>
</tr>
</tbody>
</table>

### Forming

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<tr>
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<tbody>
<tr>
<td>Cylinder Rolls: 3/8” x 12’ L</td>
<td>Head Forming</td>
</tr>
<tr>
<td>Bar/Angle Rolls: 5” x 5/16” x 1/2” angle</td>
<td>Hydro-Form Presses: 12”-108”, 5/16” thick; 12”-132”, 1/4” thick (1,500 &amp; 3,000 ton presses)</td>
</tr>
<tr>
<td>Flatbar: 1 1/4” x 9” easy, 3/4” x 5” hard</td>
<td>Bumpers: 3/8” x 84” diameter</td>
</tr>
<tr>
<td>Tube &amp; Pipe Rolling: 1” diameter x 16 gauge wall minimum, tubing through 4” sch. 40 pipe maximum</td>
<td></td>
</tr>
<tr>
<td>Shear: 3/8” x 14” L</td>
<td>Punch Press: 50 ton 48” throat</td>
</tr>
<tr>
<td>Circle Shear: 3/16” x 13” diameter</td>
<td>Ringers: 14” dia. max. x 3/8” x 5/16” through 12” knuckle radius</td>
</tr>
<tr>
<td></td>
<td>Press Brake: 300 ton x 14’ L</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Machining Tools

<table>
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<tr>
<th>Capacity</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Vert. Milling Machine: 2 HP x 11” x 58” table</td>
<td>Band Saws: 36” throat</td>
</tr>
<tr>
<td>Horiz. Milling Machine: 2 HP x 10” x 50” table</td>
<td>Abrasive Cut-off Saws: 8” maximum</td>
</tr>
<tr>
<td>Drill Presses: 2”maximum</td>
<td>Lathes</td>
</tr>
<tr>
<td>Threading: through 4” NPT</td>
<td>Engine: 32” swingx4/12”x120”</td>
</tr>
<tr>
<td>Drill Press-Radial Arm: 4” arm x 16” column</td>
<td>Turret: 21” swing</td>
</tr>
<tr>
<td></td>
<td>T/Cutter: chuck to 65” diameter</td>
</tr>
</tbody>
</table>

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**The DCI Team**

All of us at DCI are proud to be a custom manufacturer of equipment for our customers. Our engineer-to-order approach allows us to design to our customers’ standards of excellence, and our over 2,500 years of combined years-of-service experience ensures we fabricate quality equipment!

DCI’s process is a team approach. Many of our internal resources are concentrated by industry, enabling people experienced in your applications to provide knowledgeable service. From the sales proposal/estimate, engineering/drafting, and materials/inventory associates to the craftspeople on our shop floor who perform the forming, welding, machining/polishing and shipment of your order, DCI works together as a team unit.

As we commemorate our 50th anniversary, we celebrate our legacy of experience: single-source capability, innovation, product quality, dependability, follow-on service.
DCI Products
Food · Dairy · Beverage

Whether you need to store, cool, heat, blend, mix or process, DCI’s outstanding craftsmanship and proven product performance are evident. The quality of our products ensures the integrity of yours.

ASME Pressure Vessels
Aseptic Tanks
Batch-Mix Tanks
Blend Tanks
Brew Kettles
Bright Beer Tanks
Dual-Agitated Mix Tanks
Dynamixers and Dynamixer Processors
Evaporators
Fermenters
Honey Melters
Hot/Cold Liquor Tanks
Lagering Tanks
Mash and Lauter Tuns
Mix/Blend Tanks
Portable Vessels
Pressure Vessels
Processors
Reactor Tanks
Round Horizontal Storage Tanks
Sanitary Tanks
Separators
Silo Tanks
Silo Type Storage Tanks
Single-Shell Tanks
Starter Tanks
Storage Tanks
Vacuum Chambers
Vats
Whey Crystallizing Tanks
Whirlpools
Wine Tanks
Wort Boilers
DCI Site-Fab—fabrication at customer’s location

Positive Material Identification
To assure material traceability of components built into our products, DCI uses Positive Material Identification (PMI). Using the latest technology, NITON® X-Ray Fluorescence (XRF) hand-held analyzers, DCI can validate raw materials before we begin manufacturing our products.

This testing is non-destructive and can give qualitative and quantitative analysis. The data and NDT software comply with FDA 21 CFR Part 11, which is a requirement for many DCI customers. Our procedure follows ASTM E1476 and includes calibrations to Certified Materials References (CRMs) to verify that the material and documentation is correct before production begins. The performance and capabilities of the unit and DCI’s procedures guarantee reliable, accurate results.

New and Innovative Designs and Engineering Make DCI a Cut Above the Rest.

Material Selection
- Austenitic Stainless Steel
- Material Selection of Type 304/304L, 316/316L, High Purity 316/316L ESR (Electro-Slag Remelted)
- Super Austenitic, Duplex, and Nickel Alloys such as AL6XN®, Inconel®, Hastelloy®

Surface Finishes
- Finishes Offered Range from #2B Mill Finish Through 10 Ra Finish and Electropolishing

Documentation
- Complete Turn-Over Documentation Packages Delivered with Vessels

Testing & Inspection
- CIP/Riboflavin
- Positive Material (PMI)
- Surface Finish
- Liquid Dye Penetrant
- Borescope
- Pressure Leak Testing
- Welding Oxygen Analyzer
- Ferrite Testing
- Metallurgical Analysis/Other Tests Such as Radiography, Eddy Current, Helium Testing Available (Outsourced)
Count on DCI to have what you need when you need it.

Pharmaceutical · Bioscience
Chemical · Cosmetic

Expert manufacturing and consistent quality control result in product perfection, the foundation of DCI’s superior reputation. Our industry knowledge, technological aptitude and product excellence offers solutions to the most demanding and critical process requirements of our customers.

ASME Pressure Vessels
Acorn Tanks
Batch-Mix Tanks
Bioreactors
Blend Tanks
Chromatography Vessels
Buffer Tanks
Dual-Agitated Mix Tanks
Fermenters
Jacketed Tanks
Mix/Blend Tanks
Portable Vessels
Pressure Vessels
Processors
Product Hold Vessels
R & D Tanks
Reactor Tanks
Round Horizontal Storage Tanks
Sanitary Tanks
Silo Tanks
Single-Shell Tanks
Storage Tanks
Tulip Tanks
Vacuum Chambers
Vial Stopper Washers
WFI Tanks
DCI Site-Fab—fabrication at customer’s location

Spray Fixtures (CIP Devices/Sprayballs)
DCI specially designs and fabricates sprayballs and fixtures for your application.

CIP Pre-Validation
Our custom designed and built CIP (Clean-In-Place) system includes a PLC for automatic control of flow, pressure and temperature. Timed bursts and other customer test requirements can be programmed. A process recorder provides a printout of the parameters for each test.

Upward Spray Cleaning System
DCI’s optional Upward Spray Cleaning System, with primary and secondary internal vent lines, performs all CIP (Clean-In-Place) operations without requiring access to the top of the tank. Our customers realize cost savings by eliminating the purchase of external ladders, walkways and cages. Because the lines are internal, the cost for insulation and heat tape is also eliminated. The system remains in the tank—there is no need for removal between CIP cycles. Our design is currently available in sizes ranging up to 40,000 gallon silo tanks; additional sizes are available upon review of customer specifications. The Upward Spray Cleaning System is USDA accepted for use in 3-A silo tanks.

DCI PharmAssist® Lift Assist Solutions
For manway lifting in a safe and controlled manner, look to DCI PharmAssist® Lift Assist. This new piston style assist is dramatically better than the spring style lift. DCI can field-modify existing tanks from spring to piston without requiring an ASME hydro or R stamp. A conversion kit is also available. Horizontal and vertical designs fit any size manway cover.

Compact, Sealed and Cleanable Design
All Stainless Steel Design Including Belleville Springs
Bushings and Gaskets of FDA Approved Materials
Standard Finish is 32Ra, Other Finishes Available
Adjustable Design
Optional Belleville Springs Loaded in Both Directions for Ease of Opening and Damping any Overhung Load are Available for Horizontal or Vertical Lift Assist Design

Vertical Mount includes the same features as on the standard horizontal mount, along with:
Linear Assist is Specifically Designed for Vessels with Flanged Top Head
Compact Right-Angle Design Allows the Assist to Remain Close to the Vessel Side, Eliminating Interference and Safety Concerns

Photo courtesy of CRB Builders and Bernard Andre Photography
Components, Parts & OEM

DCI produces components for a number of other original equipment manufacturers (OEM) using the same quality standards found in all DCI products. We also offer a full line of replacement parts for manways, agitators, etc.

Bearings
Cylinders/Shells
Gaskets
Heat Transfer Surfaces
Large Custom/OEM Projects
Lift Assists
Manway Assemblies & Parts
Metal Stamping
Mixing/Agitation Systems
Spray Fixtures (CIP Devices/Sprayballs)
Tank Heads

Custom-Designed Agitators/Mixers

DCI Pharmix®
Axial
Bottom-Entering
Magnetic
Coaxial
Counter-Rotating
Disperser
Dual or Triple Dynamo
Guarded Cage Turbine
High Shear
Low Shear
Off-Set Propeller Type
Radial Turbine
Rushton Turbine Scrapper
Side-Entering
Squirrel Cage
Sweep: Bottom, Bottom & Side
Top-Entering
Turbine

DCI Site-Fab

DCI can bring the highest skill levels and up-to-date technology directly to any customer’s site. DCI Site-Fab is a specialty, on-site fabricator and erector of stainless steel tanks, pressure vessels, evaporators, columns and equipment for use in the pharmaceutical, dairy, food, grain, ethanol, chemical, beverage, wine and brewing industries.

Our field fabrication and service group is a team of experienced field specialists in stainless steel and other alloy materials who supply prompt service for field or in-plant fabrication of any size tank—up to 500,000 gallons.

DCI Field Services Group

Repair, modification & maintenance solutions...at your site, for any size tank:

Repair:
Agitator Alignment
Vacuum-Collapsed Tank Restoration
Demolition
Weld Cracks or Failures
Heat Transfer Services
Valve Replacement Fittings
Corrosion Removal
Spot Electropolish (EP)

Modification/Addition:
Electropolish Fittings, Valves, CIP Fixtures
Heat Transfer Surfaces
Agitator Tank Capacity Increase
Manway Lift Assist Tank Rigging
Flashing
Alcove

Testing:
CIP/Riboflavin
Positive Material Identification (PMI)
Non-Destructive Testing:
- Ultrasonic Thickness
- Eddy Current
- Liquid Dye Penetrant
- Surface Finish
- Radiograph (X-ray)

Inspections:
Gaskets, Sight Glasses, Fittings, Manways
Tanks
Agitators
Components, Parts & OEM

DCI produces components for a number of other original equipment manufacturers (OEM) using the same quality standards found in all DCI products. We also offer a full line of replacement parts for manways, agitators, etc.

- Bearings
- Cylinders/Shells
- Gaskets
- Heat Transfer Surfaces
- Large Custom/OEM Projects
- Lift Assists
- Manway Assemblies & Parts
- Metal Stamping
- Mixing/Agitation Systems
- Spray Fixtures (CIP Devices/Sprayballs)
- Tank Heads

Custom-Designed Agitators/Mixers

- DCI Pharmix®
  - Axial
  - Bottom-Entering
  - Magnetic
- Coaxial
- Counter-Rotating
- Disperser
- Dual or Triple
- Dynamixer
- Guarded Cage
- High Shear
- Low Shear
- Off-Set
- Propeller Type
- Radial Turbine
- Rushton Turbine
- Scraper
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**Repair:**
- Agitator Alignment
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- Demolition
- Weld Cracks or Failures
- Heat Transfer Services
- Valve Replacement
- Fittings
- Corrosion Removal
- Spot Electropolish (EP)

**Modification/Addition:**
- Electropolish
- Fittings, Valves, CIP Fixtures
- Heat Transfer Surfaces
- Agitator
- Tank Capacity Increase
- Manway Lift Assists
- Tank Rigging
- Flashing
- Alcove

**Testing:**
- CIP/Riboflavin
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  - Ultrasonic Thickness
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DCI Site-Fab
fabrication at customer’s location
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Ozark, Missouri
Plant Area: 10,000 sq. ft.
Office Area: 800 sq. ft.

Customer FAT (Factory Acceptance Testing) Inspection Room
DCI’s new, climate-controlled, semi-private inspection room includes an office area and all utilities to serve our customers’ requirements during inspection.
Note: The following is an excerpt from an historical account by Carl Nielsen who was co-founder and President of DCI, Inc. from 1955 until his retirement in 1987.

“DCI began on a cold winter day in 1955 when Carl Nielsen, who was then equipment sales manager for Owatonna Creamery Supplies Co., was visiting with Fred and Richard Konsor, who owned Konser Brothers’ Welding and Machine Shop in Holdingford, MN. The three discussed orders which Carl had placed with the Konsors for producing stainless steel storage tanks. During the conversation, Carl suggested that it might be worthwhile to investigate the possibilities of forming a new corporation for the manufacture of stainless steel equipment for the dairy industry. Fred and Richard were receptive to the idea, so Carl resigned his position at Owatonna Creamery Supplies Co.; borrowed money from friends to invest in the new company and brought in investors along with Fred and Richard who agreed to invest their equipment and talent in the company.

Dairy Craft, Inc., started operations on May 1, 1955, in a vacant farm implement building in Holdingford purchased on a contract-for-deed basis. In the ensuing years, two major additions were attached to the building.

In 1969, having outgrown the Holdingford plant, DCI moved to its present location in St. Cloud through arrangements made with St. Cloud Opportunities, Inc., and local banks. An addition was built onto the plant in 1974.

The quality of stainless steel equipment being made by DCI, Inc., was being purchased by a wide range of industries. In 1978, it became apparent that the Dairy Craft corporate name was not symbolic of the products and industries being served by the company and the name was changed to DCI, Inc.”

Fifty Years of Quality Craftsmanship

In 2001, DCI formed an affiliation which once again expanded the services offered—field fabrication of tanks, known as DCI Site-Fab. The facility in Ozark, Missouri, is the base for Site-Fab, as well as shop-fabricated tanks.

Today, DCI provides stainless steel/high alloy equipment to many industries worldwide—companies whose processes require the metal’s long-lasting, corrosion-resistant advantages.

We thank all of our many customers as we celebrate 50 years and look to a successful future!