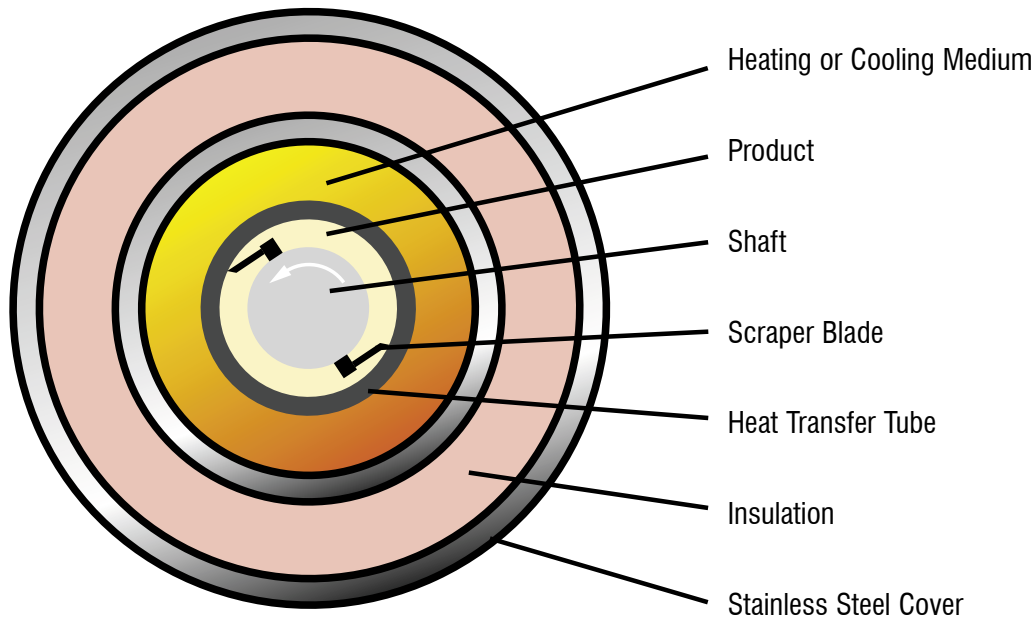


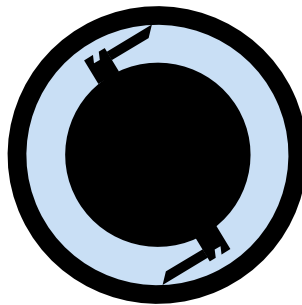
How It Works



Votator's high efficiency and productivity results from a simple concept, heat or cool continuously moving product by providing a large heat transfer surface for a small amount of product in a confined space.

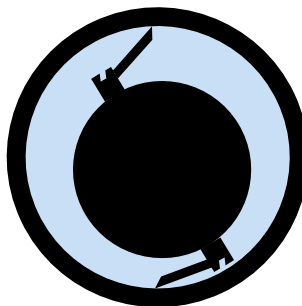
Inside every Votator®, a mutator shaft rotates within a tube. The product passes through an annulus formed by the shaft and heat transfer tube (light yellow). Heating or cooling medium flows in a jacket (orange). The unit is insulated (pink) to minimize energy loss and protect personnel. A stainless steel cover protects the insulation.

In operation, the rotating shaft has blades which continuously scrape product film from the heat transfer tube wall, thereby enhancing heat transfer, and agitating the product to produce a homogenous mixture.



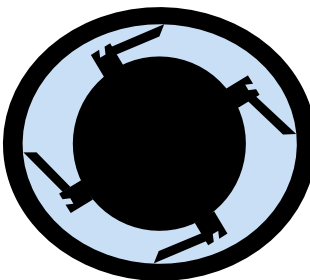
Concentric

For most applications the shaft is mounted in the center of the heat transfer tube, or CONCENTRIC.



Eccentric

An off centered shaft mount or ECCENTRIC design is recommended for viscous and sticky products. This shaft arrangement increases product mixing, eliminates mass rotation, and reduces the mechanical heat load.



Oval Tubes

Oval tubes are used to process extremely viscous products. This design eliminates product channeling within the tube, it reduces mechanical heat by a double cam action of the scraper blades, and it balances the internal forces to prevent shaft deflection.

How Components Are Selected

Votator® Scraped Surface Heat Exchanger components are manufactured in a variety of configurations and materials so that each unit can be assembled to meet the specific processing requirement of each application.

All pressure elements are designed in accordance with the latest ASME code requirements and can be CE-PED certified.

Jacket – Votator® Scraped Surface Heat Exchangers can be jacketed for liquid, steam, or direct expansion refrigeration.

Heat Transfer Tube – Thermal conductivity and wall thickness are key design considerations in selecting heat transfer tubes. Tube wall thickness is precisely engineered to minimize heat transfer resistance while maximizing structural stability.

Pure nickel tubes provide high thermal conductivity. The inside of the tube is hard chrome plated, then honed and polished to a smooth finish for resistance to wear from scraper blades and abrasive products.

Stainless steel tubes specially designed for enhanced heat transfer are offered for acidic products and to provide flexibility in the use of cleaning agents for aseptic processing.

Scraper Blades – Votator® scraper blades are arranged on the shaft in staggered rows. The blades are held on the Votator® Scraped Surface Heat Exchanger shaft by strong, durable, specially designed “universal pins,” which are welded to the shaft. There are no threaded areas to cause product build-up and possible unsanitary conditions. These pins allow quick, easy blade removal and replacement. A variety of blade materials are available.

Seals – Years of experience led to development of the Votator® rotary mechanical seals. Seals are designed for easy assembly and maintenance, and for clean operation.

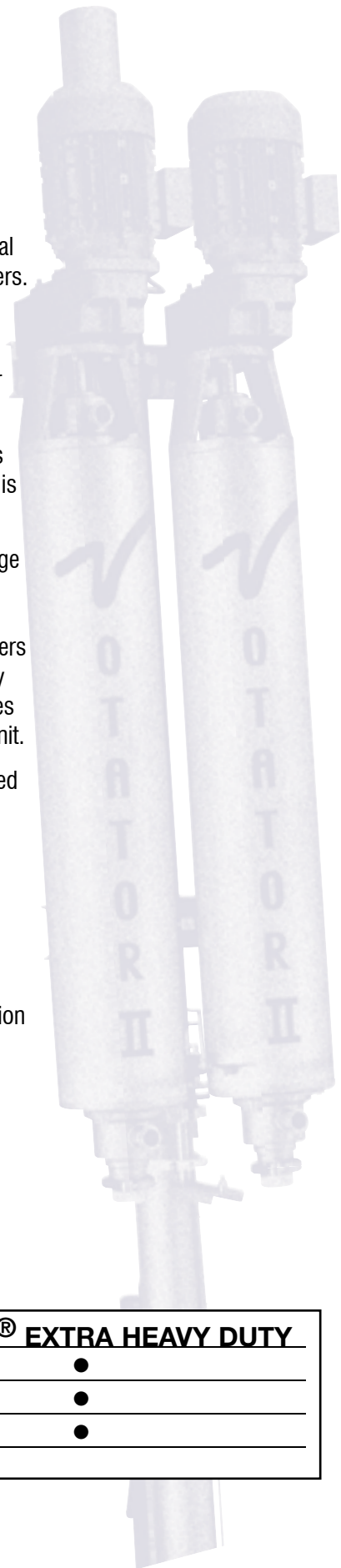
Standard seal faces for best durability consist of hardened surfaces. Flexible seal parts are available in a variety of elastomers.

Votator® II double mechanical seals are designed with the capability to use steam or water seal flush, and all are suitable for aseptic processing.

Shaft – The amount of time the product is within the heat exchanger for a given rate is controlled by the volume of the unit.

Small-shaft heat exchangers provide a large annulus for longer residence time, they handle lumpy products and those having large particles. Large-shaft heat exchangers provide a smaller annulus for high velocity and turbulence with high heat transfer rates and short product residence time in the unit.

Drives – The drive for the Votator® Scraped Surface Heat Exchanger is selected to provide optimum performance in each individual application and thus assure that the product is vigorously agitated and continuously removed from the heat transfer wall. Votator® Scraped Surface Heat Exchangers are furnished with direct drive gear motors with horsepower selection for optimum performance for the specific application.



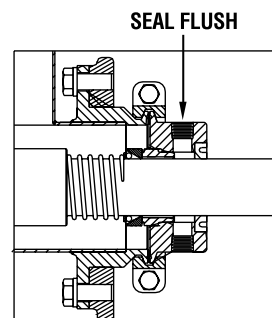
SHAFT MOUNTING	4x120	VOTATOR® II	VOTATOR® EXTRA HEAVY DUTY
CONCENTRIC	●	●	●
ECCENTRIC		●	●
OVAL			●

Votator® 4 x 120 Scraped Surface Heat Exchanger

The 4 x 120 is a unique concentric heat exchanger designed for heating and cooling moderately viscous products. The heat transfer cylinder is 4 inches (102 mm) in diameter by 120 inches (3048 mm) long.

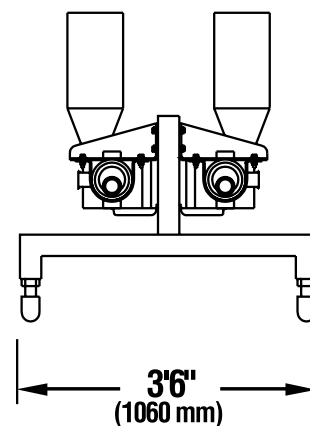
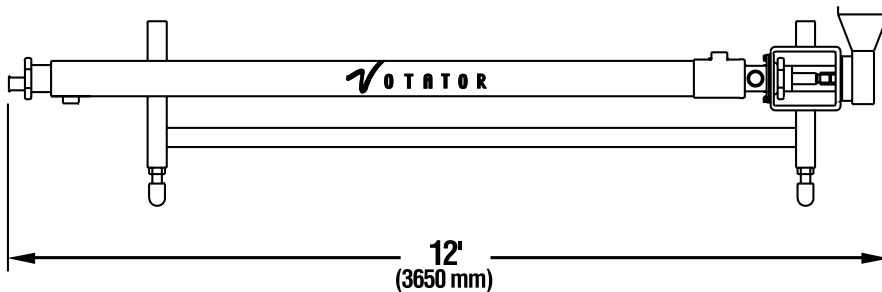
FEATURES

- All **316 stainless steel** construction with high efficiency 0.083 **stainless steel heat transfer tube or optional AL6XN tube**
- Available with **9 ft² (0.84 m²) heat transfer area**
- **Horizontal units can be mounted side by side** with up to 8 cylinders per frame or furnished loose for vertical mount
- All units suitable for **steam or liquid media**
- **Mechanical seal with flush connection** on drive end with sleeve bearing on non-driven end
- **3 and 5 horsepower (2.2 kW – 5.5 kW) gear drives** with shaft speeds of **90 and 175 rpm; No couplings, belts or sheaves**
- **Product side pressure of 200 psig (14 bar) @ 365° F (185° C)**
Jacket pressure of 150 psig (10.5 bar) @ 365° F (185° C)
- **2.375 inch (60 mm) shaft diameter for particulates** up to 0.75 inches (19 mm)
- 2 inch S-line product connections 1-1/2 FPT media connections
- Easy to field insulate after installation
- 3A and CE-SEP compliant



*Drive end
mechanical seal
(Ceramic or Graphitar)*

DIMENSIONAL DATA MODEL 4 x 120



Votator® II Scraped Surface Heat Exchanger

The Votator® II is the newest design of scraped surface heat exchangers. It is a combination of design features from the proven Votator family, Thermutator Heat Exchangers, and new innovations resulting in a rugged, economical, and hygienic heat exchanger that can be used for heating and cooling products of a wide range of viscosities, including extremely thick and sticky products that require the cam action of the eccentric design.

FEATURES

- Can be mounted **vertically or horizontally**
- Sanitary appearance
- Minimum overall length
- **USDA, CFIA, 3A, and ASME** design standard; CE-PED optional
- Tough 2 inch (50 mm) shaft spline
- Steam / water or gravity / pumped liquid refrigerant jacket configurations
- Concentric or eccentric shaft mounting

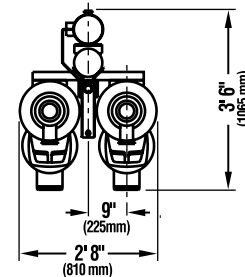
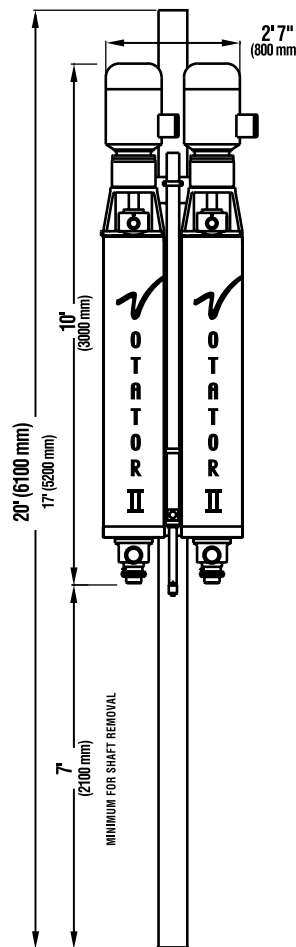
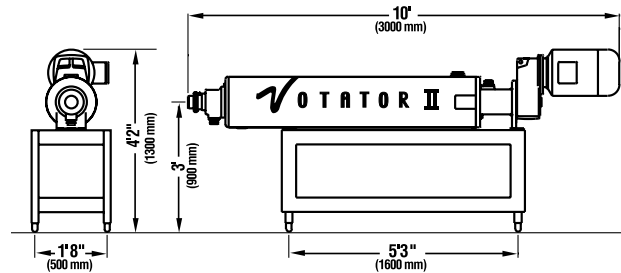
PROCESS MATCHED

- Drives From **7-1/2 TO 20 HP**
- Wide range of output speeds
- Chrome plated nickel heat transfer tubes or 316 stainless steel tubes specially designed for **enhanced heat transfer**
- Stainless **steel** or **plastic** scraper **blades**
- Mutator shaft diameter based on fluid properties, 2-1/2, 4, 4-1/2, and 5-1/4 inches (63, 102, 114, and 133 mm)
- Single and double mechanical seals

EASY TO MAINTAIN

- **Stainless steel** exterior and stainless steel painted drive
- Open stainless steel mounting frame
- **Boltless V-Lock heads** for quick disassembly
- Splined mutator shaft **removes in minutes**
- Unique **boltless** blade mounting pins
- Gear motor drive - **no couplings, belts or sheaves**
- Heat transfer tube **separate** from media jacket. It has a reliable double O-Ring seal on each end and can be removed from the jacket in minutes without disturbing the media piping.

DIMENSIONAL DATA MODEL 6 X 72



MODELS AVAILABLE	HEAT TRANSFER AREA
------------------	--------------------

6 x 24	3.0 ft ² (0.28 m ²)
6 x 36	4.2 ft ² (0.39 m ²)
6 x 48	6.0 ft ² (0.56 m ²)
6 x 72	9.0 ft ² (0.84 m ²)
6 x 84	11.0 ft ² (1.0 m ²)

PRODUCT SIDE PRESSURE

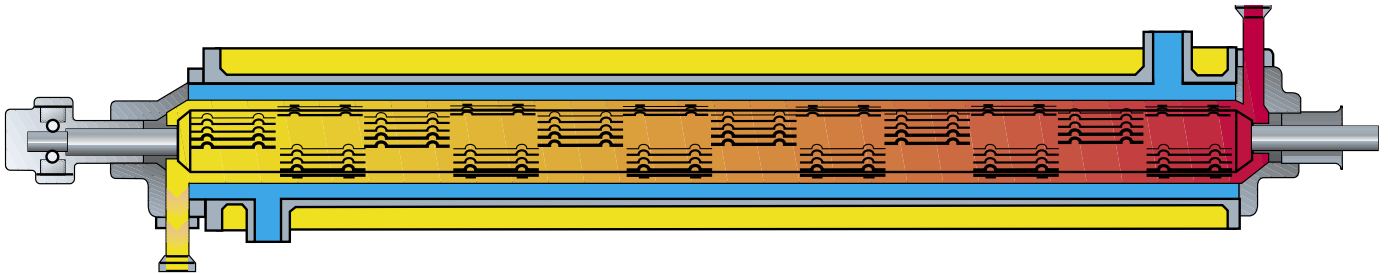
600 psi (42 bar) @ 400° F (204° C) or
800 psi (56 bar) @ 400° F (204° C)

JACKET PRESSURE

250 psi (17.5 bar) @ 400° F (204° C) or
150 psi (10.3 bar) @ 400° F (204° C)

Votator® II Extra Heavy Duty Scraped Surface Heat Exchanger

The Votator® name carries with it the reputation of durability that is unequalled. The Extra Heavy Duty Votator® II is capable of heating and cooling products with viscosities in the 1,000,000 centipoise range. The units have high torque 17-4 PH stainless steel drive spline, can be equipped with direct drives with up to 30 horsepower, and are available with Concentric, Eccentric or Oval heat transfer tubes to provide optimum processing conditions for any product.



FEATURES and OPTIONS

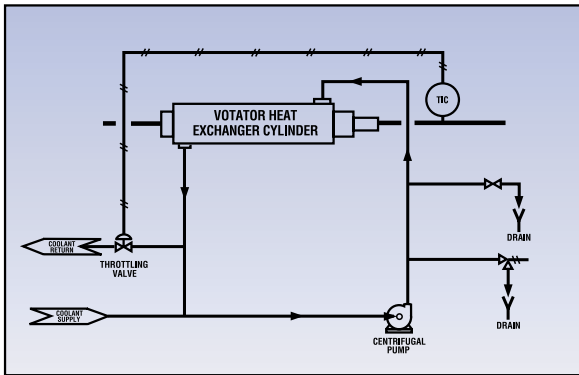
The Extra Heavy Duty (XHD) Scraped Surface Heat Exchanger is now available as a Votator II option. The Extra Heavy Duty option has a special heavy-duty roller bearing on the non-driven product head and a high torque 17-4 PH Stainless Steel spline on the driven end of the Mutator shaft. The motor pedestal is modified to use a larger gear drive with a 20, 25, or 30 Horsepower motor. Other mechanical features and most options are the same as the standard Votator® II.

- The **overall dimensions of the unit and space requirements** are the same as the Votator II.
- It has **bayonet locking product heads without bolts**.
- The integral Nord gear motor drive with a stainless steel mounting pedestal - without the traditional drive shaft and motor coupling - **reduces the overall length or height of the unit by over 2 feet**.
- It has a flange bolted heat transfer tube with a double o-ring seal on each end, drastically **reducing the maintenance time** associated with servicing that component.
- The mechanical seal is **same design as the standard Votator® II and is available as a single or double seal**.

Versatile Heat Transfer Systems

Liquid / Steam Jacketing

When using a liquid heat transfer medium, it is necessary to maintain a high flow rate for optimum efficiency. This is accomplished by using a centrifugal pump to maintain a constant media flow. A controller monitors the product temperature out of the Votator® II heat exchanger and allows liquid media from the supply to be introduced into the loop as required

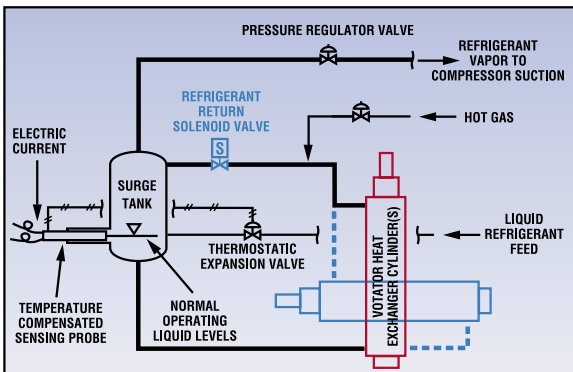


Brine Water Steam

Gravity System

In the gravity refrigeration system, liquid refrigerant flows from a receiver in the compressor plant to a surge drum installed above the Votator® II or the Votator® II Extra Heavy Duty. A modulating thermostatically controlled expansion valve automatically maintains the correct refrigerant level in this vessel. Gravity forces the refrigerant into the cooling jacket, where product heat vaporizes a portion of the liquid and reduces the bulk density of the remainder. The flow of vapor and this density difference combine to create the classic “thermosyphon effect,” which forces liquid refrigerant to circulate from the surge drum to the cooler. A regulating valve controls the pressure in the surge drum and, consequently, the temperature of the refrigerant in the cooling cylinder. Make-up liquid enters through the level control and the entire cycle continues. Individual surge drums can be provided for each cooling cylinder or a single drum can be used for two cylinders.

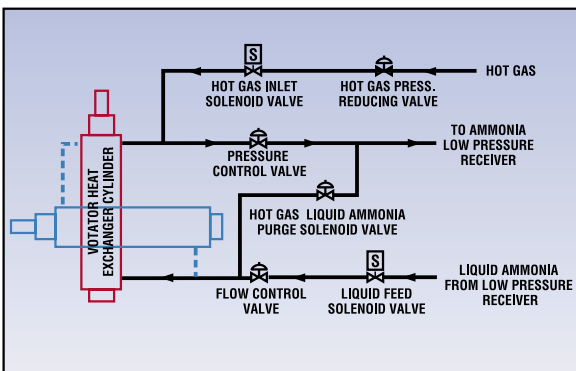
The gravity system protects against freeze-up through an instantaneous current relay system. Optional hot gas controls also can be provided for freeze-up protection and to assist in removing refrigerant for pump down.



Gravity System

Liquid Overfeed Refrigeration System

Liquid Overfeed (LOF) is available on the Votator® II and the Votator® II Extra Heavy Duty. It is a proven direct expansion concept in which only 25-35% of the liquid refrigerant flowing to the heat exchanger is actually vaporized. A large low pressure receiver replaces individual surge drums. This receiver, normally located in the compressor plant, is designed to separate the vapor from the circulated liquid. Waukesha Cherry-Burrell has designed many scraped surface heat exchangers for operating with Liquid Overfeed refrigeration. Overload protection against freeze-up is included and hot gas systems can be provided.



Liquid Overfeed Refrigeration System

Votator® Shortening & Margarine Systems

Votator® technology pioneered continuous, controlled shortening and margarine production more than 70 years ago. All systems rely on the unique efficiency of Votator® Scraped Surface Heat Exchangers in achieving quick, consistent production of crystal nuclei. The super-cooled product is then plasticized for the desired crystal structure through controlled agitation and working in a Votator® agitated holding unit or it is held in a static rest unit to develop a more rigid structure.

Votator® systems can be furnished for various capacity requirements for bulk or bakery shortening, lard, and margarine formulations for stick, tub, and spreads, and Puff Pastry formulations. All systems are easy to install.

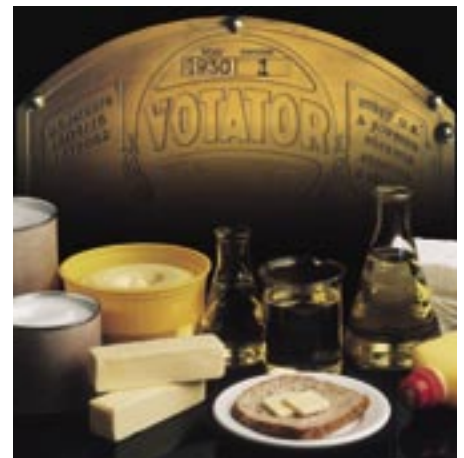
SLS FEATURES

- Includes Votator® II SSHE
- All stainless steel construction
- Pre-piped assembly factory-tested before shipment
- Eductor permits injection of low pressure air or nitrogen
- High pressure feed pump has no mechanical seal
- Individual gear motor drives — no belts or sheaves
- Open mounting frames for easier cleaning
- Rotary joints for mutator shafts are standard
- Votator® extrusion valve assures correct product texture
- Reliable and efficient refrigeration controls

OPTIONS

- Manual or automatic control panels
- Shaft diameters for controlled residence time
- Tempered-water circulating systems for shaft rotary joints
- Process-matched refrigeration compressor systems
- Eccentric Votator® II shortening post coolers

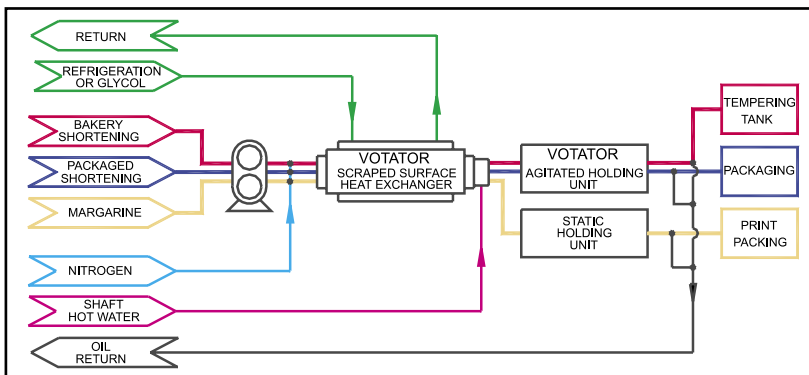
Why do you think they call it "VOTATING"?



MARGARINE		
MODELS	Lbs/Hr	Kg/Hr
1M48	2300	1000
1M72	3500	1600
2M48	4600	2100
2M72	7000	3200
3M72	10500	4700
4M72	14000	6400

SHORTENING

MODELS	Lbs/Hr	Kg/Hr
SLS61	3000	1300
SLS91	5000	2200
SLS182	10000	4500
SLS364	20000	9000



The Votator® Agitated Holding Unit consists of a tube, in which a motorized shaft with agitating pins revolves at a fixed speed; the unit prevents margarine from "setting," so it can deliver the soft product to tubs or bulk containers.