



HP4750X Stirred Cell

Assembly and Operation Manual



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Introduction

The HP4750X Stirred Cell is a high-pressure, chemically resistant stirred cell that performs a wide variety of membrane separations. With a maximum pressure rating of 2500 psig (172 bar), the HP4750X Stirred Cell is ideally suited for reverse osmosis (RO) filtration, nanofiltration (NF), ultrafiltration (UF), and microfiltration (MF) separations. Stainless steel (316L) construction and chemically resistant components make the HP4750X Stirred Cell an ideal choice to filter aqueous and non-aqueous solutions.

The Sterlitech HP4750X Stirred Cell is designed and manufactured to provide many years of trouble-free operation. This instruction manual describes the functions, features, configuration, start-up, and operation of the HP4750X Stirred Cell.

The HP4750X Stirred Cell is activated by compressed air or inert gas pressure source. Any 47-50 mm diameter membrane disk can be used with the stirred cell, which provides excellent versatility. Before operating the HP4750X, please review the operating parameters in **Table 1**.

Table 1: HP4750X Stirred Cell Operating Parameters

Parameter	Description
Membrane Size:	47-49 mm diameter (1.93 inches)
Active Membrane Area:	14.6 cm ² (2.26 in ²)
Processing Volume:	300 mL
Hold-Up Volume:	1 mL
Maximum Pressure:	172 bar (2500 psig)
Maximum Temperature:	205 °C (400 °F) at 138 bars (2000 psig)
PH Range:	Membrane dependent
Connections:	
Permeate Outlet:	1/8-inch diameter 316L SS tubing
Pressure Inlet:	¼ inch FNPT
Wetted Materials of Construction	
Cell Body:	316L Stainless Steel
O-rings:	Viton, others available as options
Gaskets:	Viton, others available as options
Stir Bar:	PTFE-coated magnet
Dimensions:	
Cell Diameter:	5.1 cm (2.0 inches)
Cell Height:	22.4 cm (10.0 inches)
Autoclavable	Yes

Before Assembly

Verify that the stirred cell was shipped complete, intact, and undamaged. The complete set of stirred cell parts is found in **Figure 1** below.

1. Stainless steel cell body
2. Cell Top
3. Cell bottom
4. 10 Hex Screws and Washers
5. Ball Point Hex Key
6. Porous stainless steel membrane support disk
7. 2 O-rings
8. Top Gasket
9. Permeate Tube
10. Stir bar assembly (optional)
11. Stir bar retriever (optional)
12. Mechanical stirrer (optional, please see Page 8)

Figure 1: HP4750X Components



Stirred Cell Assembly

After verifying that all of the necessary components were shipped and present, you can begin the assembly of the stirred cell.

1. Wet the O-rings with a small amount of water or the fluid to be processed.

Note: *HP4750X Stirred Cells are shipped with Viton O-rings and gaskets by default; other materials such as FFKM and PTFE are available as options. Table 3 outlines O-ring and gasket material compatibility.*



Photo 1: Outer Ring Insertion

2. Insert the O-rings in the bottom of the cell body (Photo 1 & 2). Check to be certain that the O-rings fit properly in the grooves.



Photo 2: Inner Ring Insertion

3. Place a piece of precut membrane over the center O-ring. The membrane should be installed with the active side toward the cell reservoir. In general, membranes coated on substrate have a shiny, active side and a dull, substrate side (Photo 3).



Photo 3: Membrane Filter Insertion

- Place the stainless steel porous membrane support disk on top of the membrane to hold the membrane in place (Photo 4).

Note: *If you cut your own membranes, the stainless steel porous disk can be used as a template. See Appendix 2 for more details.*



Photo 4: Membrane Support Disk Insertion

- Fit the cell bottom onto the cell body, aligning the circular groove with the circular ridge on the bottom of the cell body (Photo 5).



Photo 5: Cell Bottom Assembly

- Use the Ball Point Hex Key or an Allen Key to tighten the bolts (Photo 6).



Photo 6: Bottom Clamp Assembly

- Insert Permeate Tube into side of cell body, tighten using a wrench (Photo 7).

Note: *The HP4750X uses Swagelok connection fittings. More detailed instructions, information and images of the fittings can be found in Appendix I.*



Photo 7: Permeate Tube Installation

8. Insert the Stir bar assembly by lowering it into the cell with the stir bar retriever (Photo 8).

Figure 2 shows the correct position of the Stir Bar Assembly. After the assembly is in place, pour the solution to be filtered into the Cell Body. Stir bar will work well with fluids with low viscosity. For more information on using a mechanical stirrer for liquids with high viscosity and at elevated pressures, please see Page 8.

Figure 2: Proper Stir Bar Position

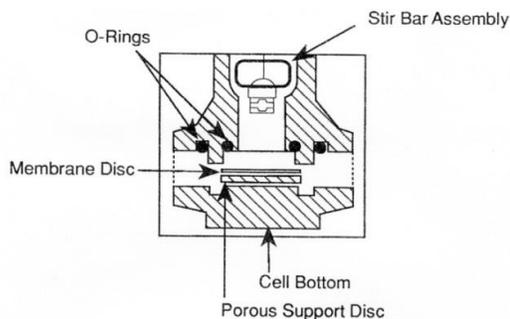


Photo 8: Stir Bar Insertion with Stir Bar Retriever

9. Insert the gasket on the top of the Cell Body, making sure it fits properly in the grooves (Photo 9).



Photo 9: Gasket Installation



Photo 10: Cell Top Attachment

10. Use Ball Point Hex Key provided or an Allen key to tighten the bolts (Photo 11).



Photo 11: Cell Top Bolts

Operation of the HP4750X Stirred Cell

1. Attach a high-pressure hose (sold separately, Sterlitech Part Number: 1151427) to the fitting on the Cell Top (Photo 12, fitting may look slightly differently than shown in the photo).



Photo 12: High Pressure Hose Attachment

2. Connect the other end of the hose to a pressure regulator assembly on the inert gas supply or the compressed air supply. The compressed air or inert gas source selected will determine pressure regulator (sold separately).



Photo 13: Permeate Collection Vessel And Stirring Plate

3. Place a Permeate Collection Vessel (user-supplied) under the Permeate Tube (Photo 13).
4. Turn on the magnetic stirrer (sold separately, Sterlitech Part Number 1144030 or 1144031) to start the motion of the Stir Bar Assembly (Photo 13).

Note: Mechanical stirrer may be preferred, please see Page 8.

Begin filtration by gradually pressurizing the HP4750X Stirred Cell, checking for leaks. Foreign material on the surface of the seals and insufficient tightening of the bolts are most common causes for leakage.

Note: *Preconditioning the membranes before use will ensure consistent performance. See Appendix 3 for more details.*

5. Upon completion of filtration, turn off the pressure source and depressurize the unit by the pressure relief valve (sold separately, Sterlitech Part Number: 1155893) (Photo 14).



Photo 14: Pressure Relief Valve

7. Once cell is depressurized and empty, the HP4750X Stirred Cell can be cleaned with a variety of cleaners, including detergents, solvents, caustic, acid, enzyme, etc.

Note: *Choice of appropriate cleaning regime should also consider compatibility of gasket/O-ring material. A section of O-ring chemical compatibilities is presented in Table 1.*

Optional Mechanical Stirrer

Mechanical stirrer can be used instead of magnetic stir bars (**Figure 3 and 4**) in HP4750X cells for filtering liquids with high viscosity and at elevated pressures. To use the mechanical stirrer, connect the mechanical stirrer to the Cell Top using the adapter provided in the shipped package. Screw in the shaft into the mechanical stirrer from the inside of the top plate. Place the Cell Top aligning the holes for bolts and tighten the bolts on the Cell Top using the Ball Point Hex Key provided in the shipped package or an Allen key.

Figure 3: Mechanical stirrer connected to the HP4750X cell top



Place HP4750X stirred cell on the support plate of the stand and fix the support in place so that stirred cell will not move during the experiments (**Figure 4**). Please refer to the enclosed mechanical stirrer manual for more information.

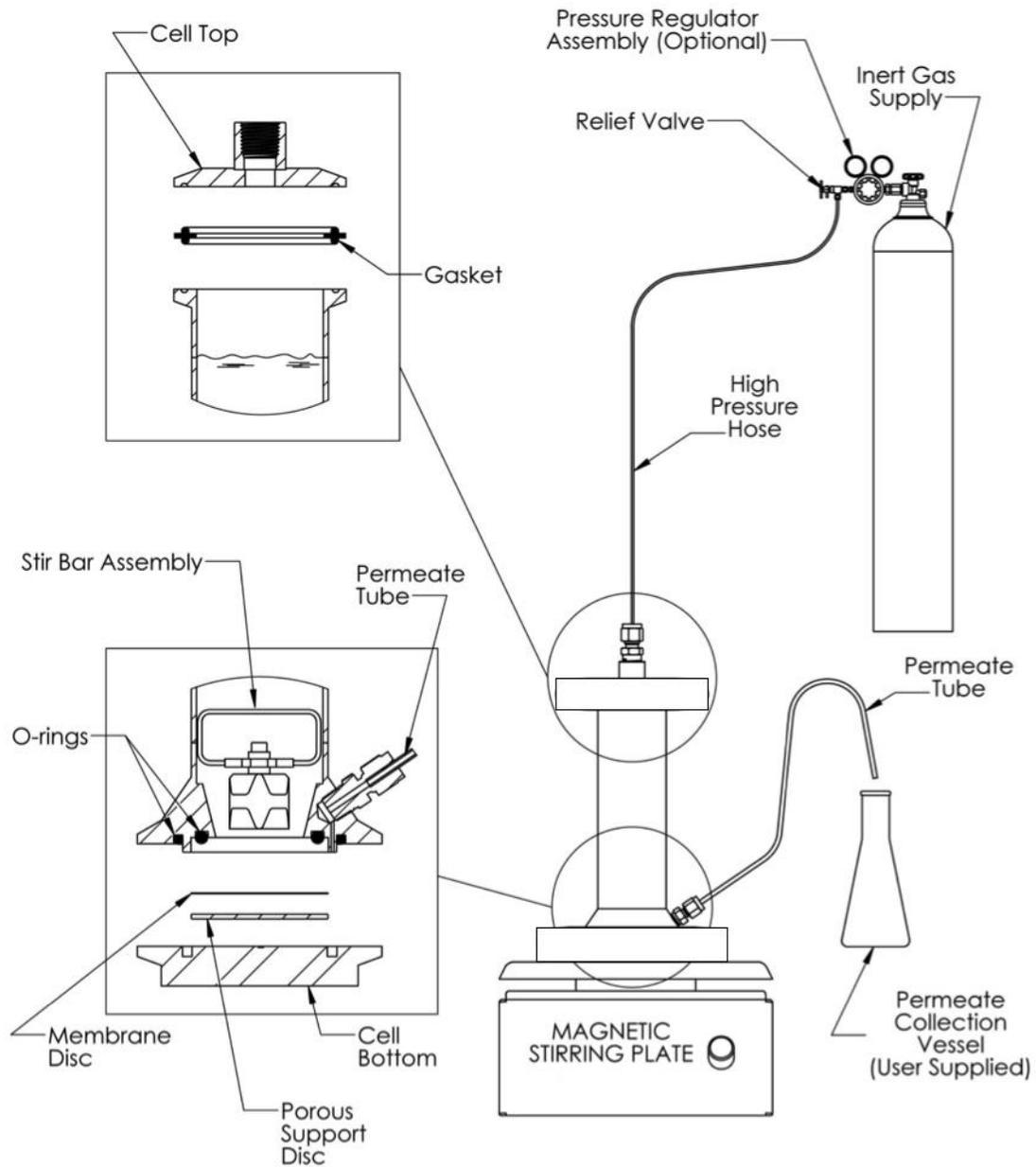
Figure 4: HP4750X cells assembly with mechanical stirrer



HP4750X Example System Configuration

Figure 5 illustrates the typical configuration of a standard HP4750X Stirred Cell System. The drawing shows the three major components of the system: the Cell Body with removable top and bottom, and Stir Bar Assembly.

Figure 5: HP4750X Stirred Cell System Schematic



Accessory and Spare Part Ordering Information

Accessories and spare parts for the HP4750X can be ordered by calling Sterlitech Corporation at 1-877-544-4420 or by visiting www.sterlitech.com.

Table 2: Accessory and Spare Part Ordering Information

Product	Shipping Weight kg (lb)	Ordering Number
HP4750X Stirred Cell, for operation to 172 bar (2500 psig)	3.8 (8)	HP4750X
Accessories		
High Pressure Hose, 183 cm (72 inch)	0.7 (1.5)	1151427
Pressure Bleed Valve, 172 bar (2500 psig)	0.1 (0.25)	1155893
PTFE O-ring/Gasket Kit	0.5 (0.1)	1144028
Viton O-ring/Gasket Kit	0.5 (0.1)	1144029
PTFE Encapsulated Viton O-ring/Gasket Kit	0.5 (0.1)	1144027
Buna O-ring/Gasket Kit	0.5 (0.1)	1144034
EPDM O-ring Gasket Kit	0.5 (0.1)	1144036
Magnetic Stirring Plate		
115 VAC 60 Hz	2.3 (5)	1144030
230 VAC 50 Hz	2.3 (5)	1144031
Spare Parts		
Cell Top	0.1 (0.25)	1143891X
Cell Body	1.4 (3)	1149782
Cell Bottom	1.4 (3)	1143073
Porous Support Disk	0.1 (0.25)	1114910
Stir Bar Assembly	0.1 (0.25)	1143109
Membrane Packs		
Visit www.sterlitech.com for membrane ordering information.		

O-ring Chemical Compatibility

The following O-ring and gasket compatibility chart (**Table 3**) is provided as an aid in selecting a specific synthetic rubber compound for a particular application situation. Operating conditions and environment must also be considered in determining the media suitability.

For recommendations regarding fluids not listed, consult Sterlitech. The recommendations represent compatibility of materials only and do not necessarily constitute a recommendation for use in a specific application.

Table 3: O-ring Chemical Compatibility Chart

Code	Compound	Temperature Range		
BN	Buna-N	-40 to 120 °C (-40 to 250 °F)		
EP	Ethylene-Propylene	-50 to 150 °C (-65 to 300 °F)		
V	Viton	-30 to 205 °C (-20 to 400 °F)		
Media (Liquid or Gas)		Code	Media (Liquid or Gas)	Code
Acetic Acid, Glacial		EP	Glycols	EP
Acetone		EP	Grease and Oils	BN
Aluminum Salts		BN	Hydrazine	EP
Ammonium Hydroxide		EP	Hydrochloric Acid	EP
Ammonium Salts		BN	Hydrofluoric Acid	EP
Amyl Alcohol		EP	Hydrogen Peroxide	V
Aniline Dyes		EP	Kerosene	BN
Aromatic Fuel – 50%		V	Linseed Oil	BN
Benzene		V	Methyl Ethyl Ketone	EP
Bleach Liquor		EP	Mineral Oils	BN
Butanol (Butyl Alcohol)		BN	Naphthas	V
Butyl Cellosolve		EP	N-Hexane	BN
Carbon Disulfide		V	Octyl Alcohol	EP
Carbon Tetrachloride		V	Organic Ester	EP
Cellosolve		EP	Peanut Oil	BN
Chlorinated Solvents		V	Phenol	V
Crude Oil		V	Pyridine Oil	EP
Cutting Oil		V	Sewage	BN
Decane		BN	Sodium Acetate	EP
Denatured Alcohol		BN	Sodium Chloride	BN
Detergent, Water Solution		BN	Stoddard Solvent	BN
Diesel Oil		BN	Sulfuric Acid	V
Diethylene Glycol		EP	Tannic Acid	BN
Dry Cleaning Fluids		V	Tertiary Butyl Alcohol	V
Ethyl Alcohol		BN	Titanium Tetrachloride	V
Ethyl Hexanol		BN	Transmission Fluid	BN
Ethylene Glycol		EP	Trioctyle Phosphate	EP
Fatty Acids		V	Varnish	V
Fatty Oil		BN	Water (Demineralized)	BN

Return Material Order Procedure

If materials are to be returned to Sterlitech for repair, evaluation, or warranty consideration, a Return Material Authorization (RMA) number must be obtained from Sterlitech prior to the return. Contact Sterlitech's Customer Service Department for these forms.

Be sure to include a complete, detailed written reason for the return. Also, include serial numbers, installation and removal dates, and any other pertinent information that is available. HP4750X Stirred Cells have a serial number imprinted on the cell body.

Indicate the proposed disposition of the material, and reference the RMA number on all packages or cartons. All material must be shipped to Sterlitech with freight prepared by the customer.

Warranty

The following is made in lieu of all other warranties expressed or implied. Sterlitech Corporation guarantees equipment to be free from defects in material and workmanship when operated in accordance with written instructions for a period of one year from receipt. Parts not manufactured by Sterlitech are covered by their manufacturer's warranties, which are normally for one year.

Manufacturers and Seller's only obligation shall be to issue credit against the purchase or replacement of equipment proved to be defective in material or workmanship. Neither manufacturer nor seller shall be liable for any injury, loss or damage, direct or indirect, special or consequential, arising out of the use of, misuse, or the inability to use such product.

The information contained herein is based on technical data and tests, which we believe to be reliable, and is intended for use by persons having technical skill at their discretion and risk. Since conditions of use are outside Sterlitech's control, we can assume no liability whatsoever for results obtained or damages incurred through the application of the data presented.

This information is not intended as a license to operate under, or a recommendation to infringe upon, any patent of Sterlitech or others covering any material or use.

The foregoing may not be altered except by a written agreement signed by officers of the manufacturer.

Technical Assistance:

Please contact us if you have any questions or technical inquiries about our products.

Appendix 1: Swagelok Connections

To install Swagelok Tube Fittings:

1. Insert the tubing into the Swagelok tube fitting. Make sure that the tubing rests firmly on the shoulder of the fitting and that the nut is finger-tight.



2. Scribe the nut at the 6 o'clock position. By scribing the nut at the 6 o'clock position as it appears to you, there will be no doubt as to the starting position.



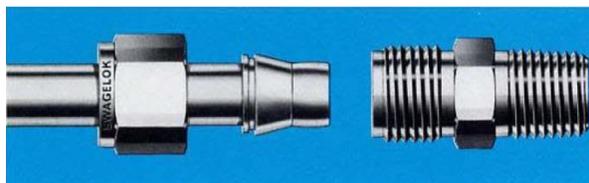
3. Hold the fitting body steady with a backup wrench and tighten the nut $1\frac{1}{4}$ turns. Watch the scribe mark, make one complete revolution and continue to the 9 o'clock position. When the nut is tightened to the 9 o'clock position, you can easily see the fitting has been tightened properly.



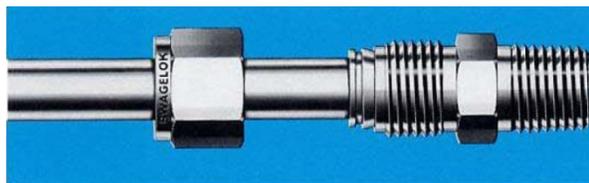
Swagelok connections can be disconnected and retightened many times.

To retighten the Swagelok connection:

1. Start with the disconnected fitting.



2. Insert tubing with preswaged ferrules into fitting body until front ferrule seats.



3. Tighten the nut by hand. Rotate nut to the original position with a wrench. An increase in resistance will be encountered at the original position. Then tighten slightly with the wrench.



Appendix 2: Membrane Cutting and Conditioning

Sterlitech offers a wide variety of membranes that have been pre-cut for use with the HP4750X. However, if you need cut your own membrane for use with the HP4750X Stirred Cell, then you will need the following items:

- The porous stainless steel support disk, which will serve as the template
- The membrane sheet to be cut
- A pair of sharp scissors
- A pair of latex gloves

To cut a membrane disk filter for the HP4750X:

1. Take the porous stainless support disk and place the membrane sheet against it. Be sure to have the latex gloves on to avoid contaminating the membrane surface.

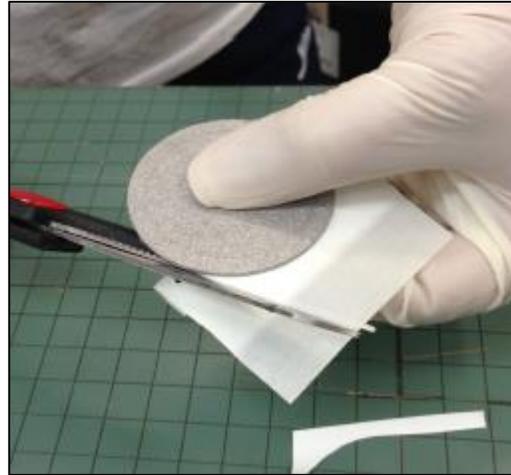


Photo 17: Membrane Cutting

2. Cut along the edge of the template with the scissors. Hold the scissors at an angle towards the center of the template to avoid under-trimming.

Once finished, the membrane should sit perfectly flat on supports without any bending and extend outside of the inner O-ring to avoid leakage.

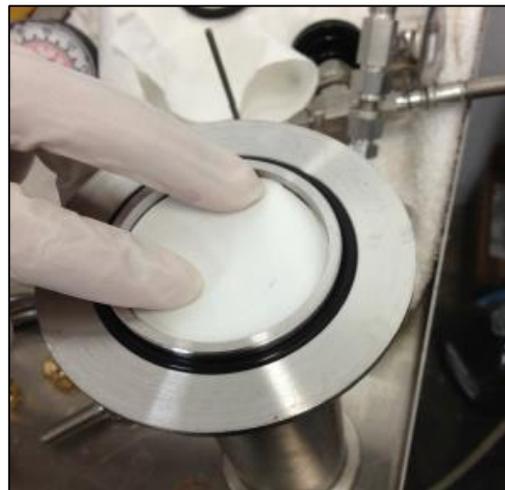


Photo 18: Membrane Fitting

Appendix 3: Preconditioning Membrane Disc Filters

To precondition the membrane:

1. Load the membrane into the HP4750X Stirred Cell.
2. Fill the stirred cell with deionized water and pressurize the cell. The temperature of the water and the pressure used should be the same as the temperature and pressure that will be used in the actual trials.
3. Run deionized water through the cell until flux is relatively constant. After a few minutes, flux through the membrane will stabilize following a sharp change.
4. Release pressure, discard the deionized water and fill the tank with desired feed sample.

Appendix 4: HP4750 Bibliography

The following studies utilized the HP4750 and HP4750X Stirred Cell in their method and are listed here to illustrate the potential applications for the HP4750. These studies are good references for understanding the operation of the HP4750 Stirred Cell.

Title	Abstract	Full Citation
The Effect of Very High Hydraulic Pressure on the Permeability and Salt Rejection of Reverse Osmosis Membranes,	A stirred-cell reverse osmosis setup was used to demonstrate that a seawater reverse osmosis membrane can maintain excellent rejection at pressures as high as 172 bar.	McGovern, Ronan Killian; McConnon, Dillon; Lienhard V, John H. The Effect of Very High Hydraulic Pressure on the Permeability and Salt Rejection of Reverse Osmosis Membranes , 2015 IDA World Congress on Desalination and Water Reuse (August 2015)
Membranes Separation of 2-Ethyl Hexyl Amine/1-Decene	Using HP4750X, this paper shows that Teflon AF 2400 and cellulose acetate produced interesting results in 1-decene/2-EHA separations.	Bander Bawareth. Membranes Separation of 2-Ethyl Hexyl Amine/1-Decene , Jurnal Teknologi, 69:9 (2014) 29–39
Experiments and modeling of multilayered coatings and membranes: application to thermal barrier coatings and reverse osmosis membranes	In this thesis, a novel methodology for characterizing interfacial delamination of thermal barrier coatings was developed using HP4750 cells.	Luk-Cyr, Jacques. Experiments and modeling of multilayered coatings and membranes: application to thermal barrier coatings and reverse osmosis membranes , MIT Thesis (2014)
Modeling of the retention of atrazine and dimethoate with nanofiltration	The HP4750 stirred cell was used to test which nanofiltration membrane (NF90, NF200, NF270, and DK) worked best at removing pesticides from water.	A.L. Ahmad, L.S. Tan, S.R. Abd. Shukor. Modeling of the retention of atrazine and dimethoate with nanofiltration . Chemical Engineering Journal, Volume 147, Issues 2–3, 15 April 2009, Pages 280–286. http://dx.doi.org/10.1016/j.cej.2008.07.015
Effects of palm oil-based fatty acids on fouling of ultrafiltration membranes during the clarification of glycerin-rich solution	In this study, the HP4750 cell was used to examine the membrane-binding properties fatty acids with polyethersulfone (PES) and polyvinylidene fluoride (PVDF) ultrafiltration membranes.	Indok Nurul Hasyimah Mohd Amin, Abdul Wahab Mohammad, Mastura Markom, Leo Choe Peng. Effects of palm oil-based fatty acids on fouling of ultrafiltration membranes during the clarification of glycerin-rich solution . Journal of Food Engineering, Volume 101, Issue 3, December 2010, Pages 264–272. http://dx.doi.org/10.1016/j.jfoodeng.2010.07.006
Preparation and characterization of a neutrally charged antifouling nanofiltration membrane by coating a layer of sulfonated poly(ether ether ketone) on a positively charged nanofiltration membrane	The HP4750 stirred cell was used to test the antifouling and separation capability of a specially prepared, electrically neutral nanofiltration membrane.	Chaoyi Ba, James Economy. Preparation and characterization of a neutrally charged antifouling nanofiltration membrane by coating a layer of sulfonated poly(ether ether ketone) on a positively charged nanofiltration membrane . Journal of Membrane Science, Volume 362, Issues 1–2, 15 October 2010, Pages 192–201. http://dx.doi.org/10.1016/j.memsci.2010.06.032
Synthesis and characterization of a carbon nanotube/polymer nanocomposite membrane for water treatment	The HP4750 was used to characterize the separation properties of carbon composite membrane at 2.9, 3.9 and 4.9 MPa.	Hosam A. Shawky, So-Ryong Chae, Shihong Lin, Mark R. Wiesner. Synthesis and characterization of a carbon nanotube/polymer nanocomposite membrane for water treatment . Desalination, Volume 272, Issues 1–3, 3 May 2011, Pages 46–50. http://dx.doi.org/10.1016/j.desal.2010.12.051

Founded in 2001 in Kent, WA, Sterlitech Corporation manufactures and markets filtration-focused laboratory products to a broad spectrum of scientific and industrial sectors. Its line of flat sheet membranes and tangential flow cells deliver industry-leading performance and reliable results. Configured for reverse osmosis, nanofiltration, ultrafiltration, and microfiltration applications, Sterlitech's bench scale test equipment provides the versatility required to innovate.

Sterlitech's comprehensive line of products is supported by the expertise of its technical specialists who can assist with application-specific product selection, and provide customized solutions where necessary. Unique problem-solving approaches, flexibility, and consistent quality have made Sterlitech Corporation a renowned global provider of filtration products and equipment.

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