



HP4750

ASSEMBLY & OPERATION MANUAL



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1. INTRODUCTION

The HP4750 Stirred Cell is a high-pressure, chemically resistant stirred cell that performs a wide variety of membrane separations. With a maximum pressure rating of 1000 psig (69 bar), the HP4750 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 HP4750 Stirred Cell an ideal choice to filter aqueous and non-aqueous solutions.

Table 1 outlines the operational parameters and technical specifications of the HP4750 Cell.

Prior to operating or servicing this device, this manual must be read and understood.

Table 1: HP4750 Features and Technical Specification

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	69 bar (1000 psig)
Maximum Temperature	121 °C (250 °F) at 55 bars (800 psig)
Maximum Torque Setting for Nuts	20 ft-lbs
pH Range	Membrane Dependant
Connections	
Permeate Outlet	1/8 inch diameter 316L SS tubing
Pressure Inlet	1/4 inch FNPT
Wetted Materials of Construction	
Cell Body	316L Stainless Steel
O-Rings	Buna-N, others available as options
Gasket	Buna-N, 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

2. 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. Cell Top Coupling
5. Cell Bottom Coupling
6. Porous Stainless Steel Membrane Support Disk
7. 2 O-rings
8. Top Gasket
9. Permeate Tube
10. Stir Bar Assembly
11. Stir Bar Retriever

Figure 1: HP4750 Components



3. STIRRED CELL ASSEMBLY

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

To assemble the HP4750 stirred cell:

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

Note: HP4750 Stirred Cells are shipped with Buna O-rings and gaskets by default; other materials such as Viton and PTFE are available as options. **Table 3** outlines O-ring and gasket material compatibility.

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.
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**).
4. 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 3** for more details.



Photo 1: Outer Ring Insertion



Photo 2: Inner Ring Insertion



Photo 3: Membrane Filter Insertion



Photo 4: Membrane Support Disc Insertion

5. 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**).
6. Use the 3-inch high pressure coupling to clamp the cell bottom to the cell body. Tighten the high pressure coupling with 16 foot pounds of torque for 1000 psig (69 bar) operation (**Photo 6**).
7. Insert Permeate Tube into side of cell body, tighten using a wrench (**Photo 7**).

Note: The HP4750 uses Swagelok connection fittings. More detailed instructions, information and images of the fittings can be found in **Appendix 1**.

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.

Figure 2: Proper Stir Bar Position

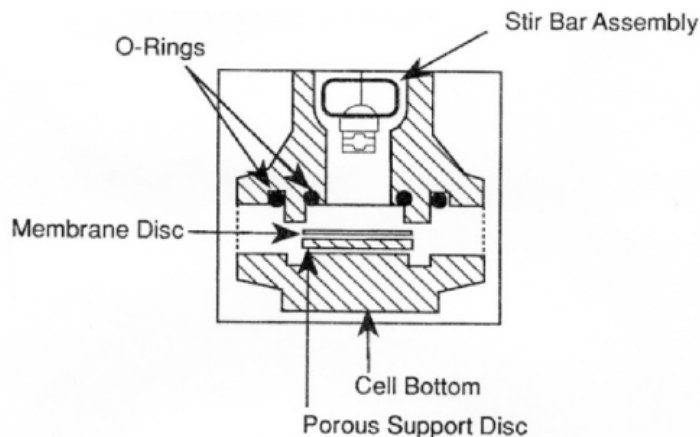


Photo 5: Cell Bottom Assembly

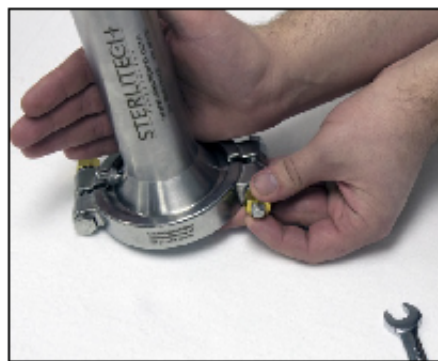


Photo 6: Bottom Clamp Assembly

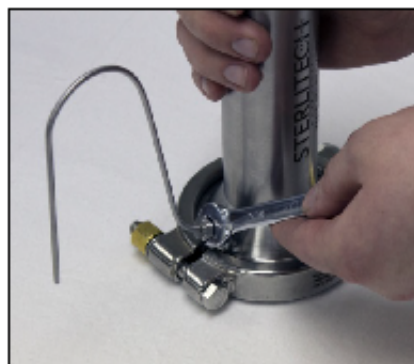


Photo 7: Permeate Tube Installation

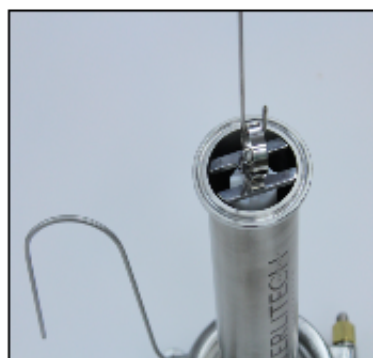


Photo 8: Stir Bar Insertion w/ Stir Bar Retriever

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

10. Use the 2-inch high pressure coupling to clamp the cell top to the cell body (**Photo 10**). Tighten the high pressure coupling with 16 foot pounds of torque for 1000 psig (69 bar) operation (**Photo 11**). After both clamps are properly attached, the HP4750 Stirred Cell should be centered on top of a magnetic stirrer.



Photo 10: Cell Top Attachment



Photo 11: Cell Top Clamp

4. OPERATION OF THE HP4750 STIRRED CELL

1. Attach a high pressure hose (sold separately, Sterlitech Part Number: 1151427) to the fitting on the Cell Top (**Photo 12**).
2. Connect the other end of the hose to the 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, Sterlitech Part Number: 1144026 style and pressure requirements (**Photo 13**).
3. Place a Permeate Collection Vessel (user supplied) under the Permeate Tube (**Photo 14**).
4. Turn on the magnetic stirrer (sold separately, Sterlitech Part Number 1144030 or 1144031) to start the motion of the Stir Bar Assembly (**Photo 15**).
5. Begin filtration by gradually pressurizing the HP4750 Stirred Cell, checking for leaks. Foreign material on the surface of the seals and insufficient tightening of the clamps are most common causes for leakage.

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



Photo 12: High Pressure Hose Attachment

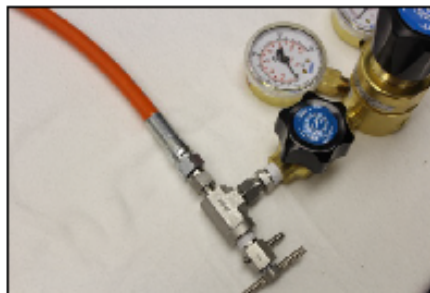


Photo 13: Pressure Regulator Connection



Photo 14: Permeate Collection Vessel



Photo 15: Magnetic Stirrer

6. 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 16)**.

CAUTION: Do not depressurize the HP4750 Stirred Cell by loosening the couplings.

7. Once it is depressurized and empty, the HP4750 Stirred Cell can be cleaned with a variety of cleaners, including detergents, solvents, caustic, acid, enzyme cleaners, etc.

Note: Choice of the appropriate cleaning regime should also consider the compatibility of the gasket and O-ring material. A section of O-ring chemical compatibilities is presented on page 10.

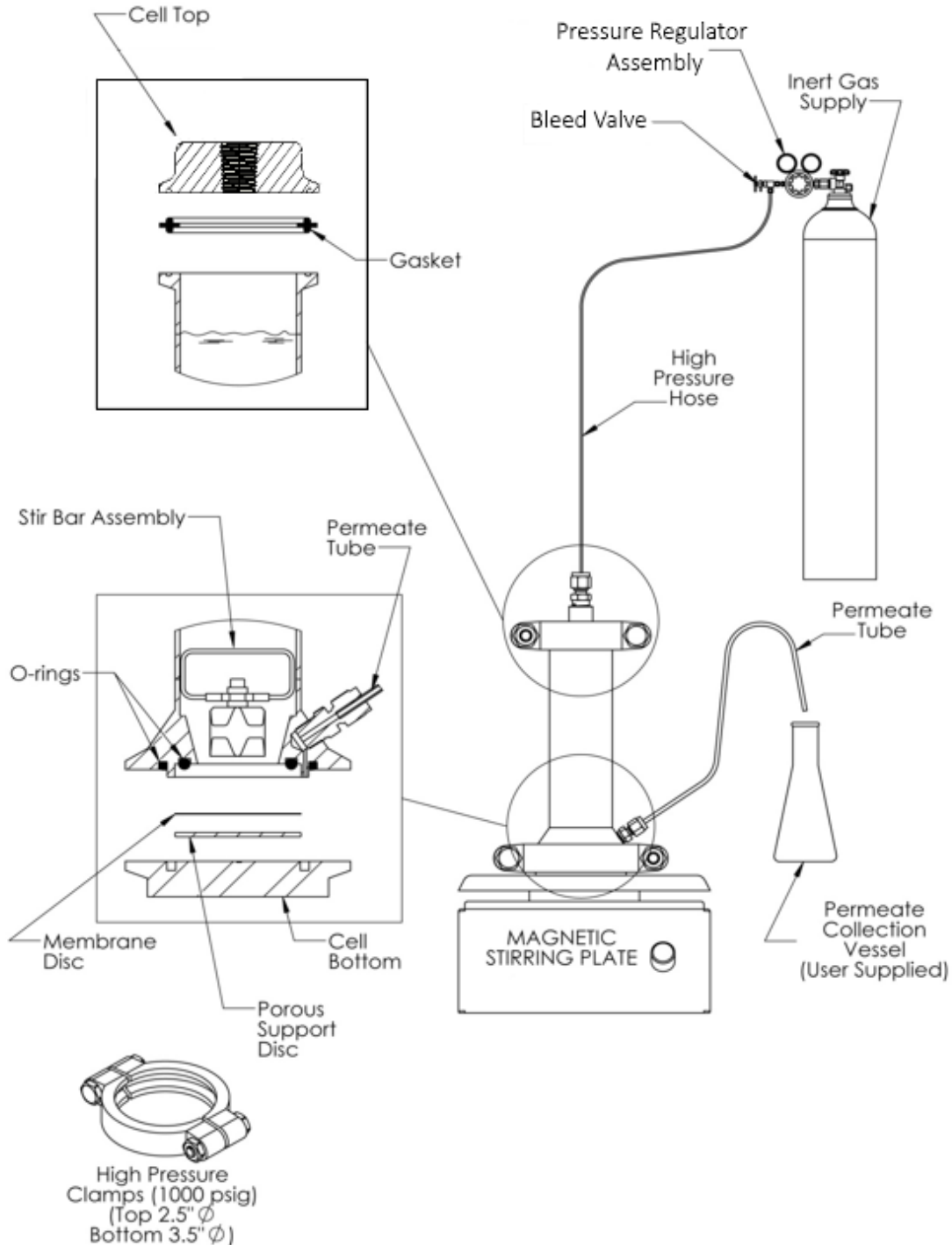


Photo 16: Pressure Relief Valve

5. HP4750 EXAMPLE SYSTEM CONFIGURATION

Figure 3 illustrates the typical configuration of a standard HP4750 Stirred Cell System. The drawing shows the three major components of the system: the Cell Body with removable top and bottom, Stir Bar Assembly, and Standard Coupling.

Figure 3: HP4750 Stirred Cell System Schematic



6. ACCESSORY AND SPARE PART ORDERING INFORMATION

Accessories and spare parts for the HP4750 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	Ordering Number
HP4750 Stirred Cell, for operation to 69 bar (1000 psig)	3.8 kg (8 lbs)	HP4750
Accessories		
Pressure Regulator Assembly, 6.9-69 bar (100-1000 psig)	2.3 kg (5 lbs)	1144026
Pressure Bleed Valve, 172 bar (2500 psig)	0.1 kg (0.25 lb)	1155893
High Pressure Hose, 183 cm (72 inch)	0.7 kg (1.5 lbs)	1151427
PTFE O-ring/Gasket Kit	0.5 kg (0.1 lb)	1144028
Viton O-ring/Gasket Kit	0.5 kg (0.1 lb)	1144029
PTFE Encapsulated Viton O-ring/Gasket Kit	0.5 kg (0.1 lb)	1144027
Buna O-ring/Gasket Kit	0.5 kg (0.1 lb)	1144034
EPDM O-ring Gasket Kit	0.5 kg (0.1 lb)	1144036
Magnetic Stirring Plate		
115 VAC 60 Hz	2.3 kg (5 lbs)	1144030
230 VAC 50 Hz	2.3 kg (5 lbs)	1144031
Spare Parts		
Cell Top	0.1 kg (0.25 lb)	1143891
Cell Body	1.4 kg (3 lbs)	1149782
Cell Bottom	1.4 kg (3 lbs)	1143073
Porous Support Disk	0.1 kg (0.25 lb)	1114910
Stir Bar Assembly	0.1 kg (0.25 lb)	1143109
Membrane Packs		
Visit www.sterlitech.com for membrane ordering information.		

7. 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
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	Glycols	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

8. RETURN MATERIAL AUTHORIZATION

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

The form must be completed and returned with the material. 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. HP4750 Cells have a serial number imprinted on the cell bottom.

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.

9. 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.

10. TECHNICAL ASSISTANCE

Please contact us if you have any questions or technical inquiries about our products by calling Sterlitech Corporation at 1-877-544-4420 or by visiting www.sterlitech.com.

APPENDIX 1: COMPRESSION CONNECTIONS

To install Compression Tube Fittings:

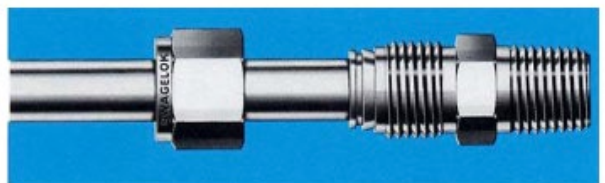
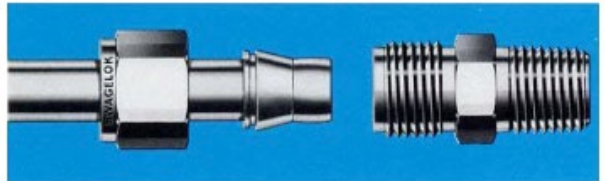
1. Insert the tubing into the Compression tube fitting. Make sure that the tubing rests firmly on the shoulder of the fitting and that the nut is finger-tight.
2. Scribe the nut at the 6 o'clock position. By scribing the nut at the 6 o'clock position as it appears to you, there will be no doubt as to 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, you can easily see the fitting has been tightened properly.



Compression connections can be disconnected and retightened many times.

To retighten the Compression 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 HP4750. However, if you need cut your own membrane for use with the HP4750 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 HP4750:

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.
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 undertrimming (**Photo 17**). 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**).

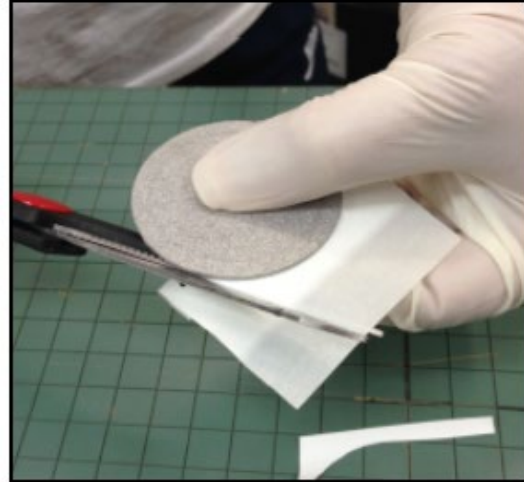


Photo 17: Membrane Cutting

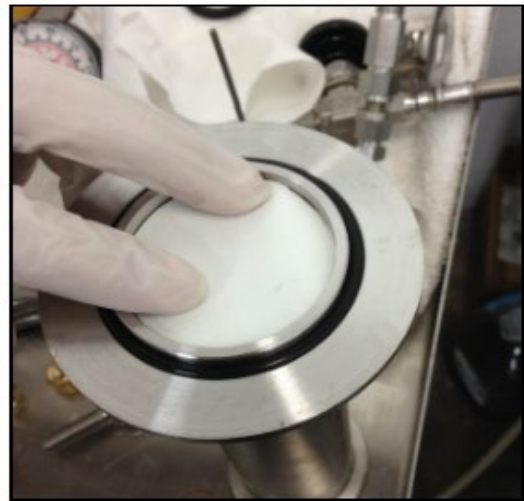


Photo 18: Membrane Fitting

APPENDIX 3: PRECONDITIONING MEMBRANE DISC FILTERS

To precondition the membrane:

1. Load the membrane into the HP4750 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 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
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 oilbased 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

APPENDIX 5: STERLITECH BENCH SCALE FILTRATION PRODUCTS

	Discoverer	Innovator	Explorer	Developer	Investigator
					
	HP4750(X)	CF016	CF042	Sepa	1812
Filter Holder					
Membrane Active Area	14.6 cm ² (2.26 in ²)	20.6 cm ² (3.2 in ²)	42 cm ² (6.5 in ²)	140 cm ² (24 in ²)	0.27-0.46 m ² (3-5 ft ²)
Typical Permeate Flux	30-300 LMH (17.6-176 GFD)	30-300 LMH (17.6-176 GFD)	30-300 LMH (17.6-176 GFD)	30-300 LMH (17.6-176 GFD)	30-300 LMH (17.6-176 GFD)
Typical Permeate Flow Rate (per Cell)	1.5-15 mL/min	1-10 mL/min	2-20 mL/min	7-70 mL/min	350-2,300 mL/min
System Capacity	0.7-7 L/day (0.2-2 GPD)	1.5-15 L/day (0.4-4 GPD)	3-30 L/day (0.5-5 GPD)	10-100 L/day (2.6-26 GPD)	194-1,940 L/day (51-510 GPD)
Min. Batch Volume (per Cell)	300 mL	3.7 L (1 gal)	3.7 L (1 gal)	3.7 L (1 gal)	15 L (4 gal)
Max. Pump Capacity	N/A	6.8 LPM (76 bar) 1.8 GPM (1,100 psi)	6.8 LPM (76 bar) 1.8 GPM (1,100 psi)	6.8 LPM (76 bar) 1.8 GPM (1,100 psi)	6.8-38 LPM (76 bar) 1.8-10 GPM (1,100 psi)
Cell Material	SS316, Hastelloy™	PTFE, Delrin, Acrylic, SS316, Hastelloy™	PTFE, Delrin, Acrylic, SS316, Hastelloy™	Acrylic, SS316, Hastelloy™	SS316
Max. Operating Pressure	HP4750: 69 bar (1,000 psi) HP4750X: 172 bar (2,500 psi)	PTFE/Acrylic: 27.6 bar (400 psi) Delrin/SS316/Hastelloy™: 69 bar (1,000 psi)	PTFE/Acrylic: 27.6 bar (400 psi) Delrin/SS316/Hastelloy™: 69 bar (1,000 psi)	Acrylic: 27.6 bar (400 psi) SS316/Hastelloy™: 69 bar (1,000 psi)	41.4 bar (600 psi)
Filtration Mode(s)	Dead-End Stirred Cell	Cross Flow, Forward Osmosis	Cross Flow, Forward Osmosis	Cross Flow, Forward Osmosis	Cross Flow

NOTES:

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.

General Corporate Information

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