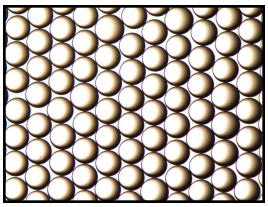
Product Data Sheet

DuPont™ AmberLite™ CR99 K/320 and Na/320 Chromatographic Separation Resins

Separation Resin Primarily Used for Size Exclusion Chromatography such Beet Molasses Desugarization and Dextrose Purification

Description



DuPont™ AmberLite™ CR99 Chromatographic Separation Resins are strong acid cation resins manufactured in a process that produces an extremely uniform particle size. This family of resins was specifically developed for use in simulated moving bed (SMB) chromatographic systems for the recovery and purification of sweeteners.

The 320-µm members of the AmberLite™ CR99 family are specifically designed with the combination of particle size and rapid kinetics for excellent separator performance. For decades it has demonstrated reliability in sweetener separations for the production of beet sugar and high-purity dextrose.

DuPont™ AmberLite™ CR99 K/320 Chromatographic Separation Resin is used in chromatography for beet molasses desugarization and high-purity dextrose production.

DuPont™ AmberLite™ CR99 Na/320 Chromatographic Separation Resin is used in lactose removal in dairy operations and glucose recovery.

Either ionic form, or the available Ca-form 320-µm chromatographic separation resin, can be used in other specialty separations, depending on the binary pair of constituents. ‡

Applications

- Beet molasses desugarization
- High-purity dextrose production
- Polyols/sugar alcohols separation
- Lactose removal
- Glucose recovery
- Specialty separations ‡

‡ Refer to the DuPont Separability Advisor™ Bubble Chart (Form No. 45-D01069-en) as a guide regarding the feasibility to separate various binary combinations of sugars and sugar alcohols. Plus, lab testing is available through System Optimization Services℠ (SOS) to help identify the best product to meet your needs.

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Typical Properties

Physical Properties		
Copolymer	Styrene-divinylbenzene	
Matrix	Gel	
Type	Strong acid cation	
Functional Group	Sulfonic acid	
Physical Form	Amber, translucent, spherical beads	
Chemical Properties		
Ionic Form as Shipped	**K^+**	**Na^+**
Total Exchange Capacity	≥ 1.5 eq/L (H^+ form)	≥ 1.5 eq/L (H^+ form)
Water Retention Capacity	57 – 61% (H^+ form)	58 – 61% (H^+ form)
Stability		
Whole Uncracked Beads	≥ 98%	≥ 97%
Density		
Particle Density	1.28 g/mL	1.25 g/mL

Typical Bead Size Distribution [§] (Light Obscuration Instrument Particle Size)

	K^+		**Na^+**	
Particle Diameter	320 ± 15 µm		323 ± 15 µm	
Broad Range	287 – 352 µm	≥ 90%	290 – 355 µm	≥ 90%
Narrow Range	305 – 340 µm	≥ 75%	308 – 343 µm	≥ 75%
Fine Beads	< 282 µm	≤ 4%	< 285 µm	≤ 4%
Coarse Beads	> 383 µm	≤ 4%	> 386 µm	≤ 4%

[§] For additional particle size information, please refer to the Particle Size Distribution Cross Reference Chart (Form No. 45-D00954-en).

Suggested Operating Conditions

	Dextrose (K^+ form)	**Beet Molasses (K^+ form)**	**Glucose/Lactose (Na^+ form)**
Syrup Temperature	60 – 71°C (140 – 160°F)	80 – 85°C (176 – 185°F)	Depends on the application
Syrup pH	4 – 7	7 – 12	Depends on the application
Dissolved Oxygen Concentration			
Recommended	< 0.1 ppm	< 0.1 ppm	< 0.1 ppm
Maximum	0.25 ppm	0.25 ppm	0.25 ppm
Simulated Moving Bed Operation	With optimized tuning (annually)	With optimized tuning (annually)	With optimized tuning (annually)

It is strongly advised to remove oxygen from feed streams and elution water going into the chromatographic separation resin. Limiting the oxygen concentration to less than 0.1 ppm (0.25 ppm maximum) will help maximize resin life.

Form No. 45-D00718-en, Rev. 2
October 2022

Hydraulic Characteristics

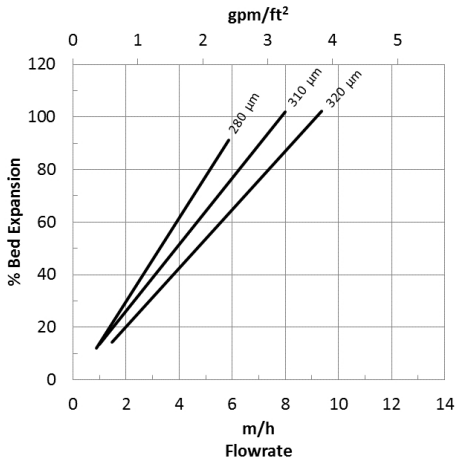
Estimated bed expansion of the 320-µm size of DuPont™ AmberLite™ CR99 Chromatographic Separation Resin as a function of backwash flowrate at 25°C (77°F) is shown in Figure 1. Data for DuPont's 310- and 280-µm chromatographic separation resins is also provided for comparison. The flowrate necessary to achieve a desired bed expansion for other water temperatures can be calculated with the provided equations.

Estimated pressure drop data for the 320-µm size of AmberLite™ CR99 as a function of service flowrate and concentration of 42% HFCS (50% D.S. and 30% D.S.) is shown in Figure 2. Data for DuPont's 310- and 280-µm chromatographic separation resins is also provided for comparison.

Thermal expansion of the 320-µm size of AmberLite™ CR99 as a function of temperature and ionic form is shown in Figure 3.

Figure 1: Backwash Expansion

Temperature = 25°C (77°F)



For other temperatures use:

$F_T = F_{25°C} [1 + 0.008 (1.8T_{°C} - 45)]$, where F ≡ m/h

$F_T = F_{77°F} [1 + 0.008 (T_{°F} - 77)]$, where F ≡ gpm/ft²

Figure 2: Pressure Drop

Syrup (42% HFCS) Concentration = 30% D.S., 50% D.S.

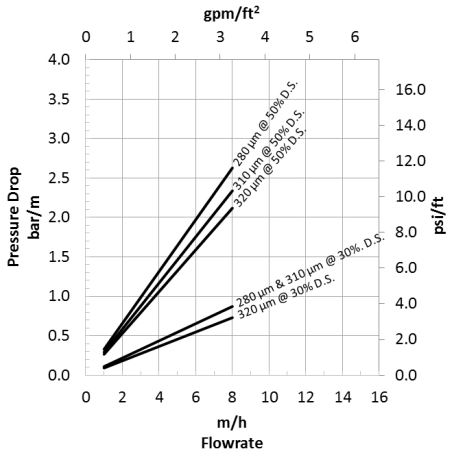
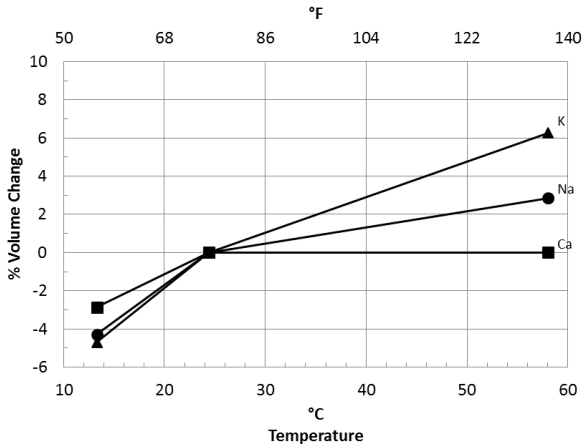


Figure 3: Thermal Expansion



Form No. 45-D00718-en, Rev. 2
October 2022

Product Stewardship

DuPont has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with DuPont products—from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

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Please be aware of the following:

- **WARNING:** Oxidizing agents such as nitric acid attack organic ion exchange resins under certain conditions. This could lead to anything from slight resin degradation to a violent exothermic reaction (explosion). Before using strong oxidizing agents, consult sources knowledgeable in handling such materials.

Have a question? Contact us at:

www.dupont.com/water/contact-us

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Form No. 45-D00718-en, Rev. 2
October 2022